

## ONYX HD tri-coat system-

### Blending in on the adjacent panel with ONYX HD (Translucent Step 2)

#### B 3.3

#### Process description

In principle, panel repairs with translucent ONYX HD basecoats are possible. Therefore, it is in general not necessary to respray adjacent body parts. But when color differences beyond allowable limits are to be expected, the more appropriate method to balance color differences may be to blend into the damaged area and/or the adjacent part. This procedure can be considerably more efficient and economical than time-consuming color matching.

#### Substrates

- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Refinishes, fully cured and solvent-resistant

#### Products required

- PK 2000
- ONYX HD
- ONYX EASY BLENDER A 2520
- HYDROMIX
- RAPIDCLEAR C 2570

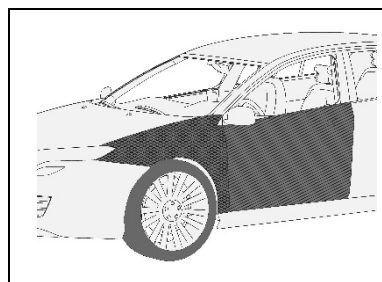
#### Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

#### 1) Pre-treatment



Degrease with PK 1000.

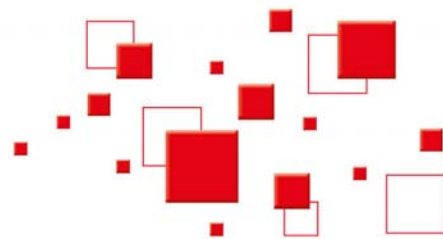
Dry-sand filler patch with P400.

Sand the adjacent panel with P1000 / P2000

Degrease with PK 2000.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at [www.mpaint.com](http://www.mpaint.com) or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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#### 2) Refinishing of the panel to be repaired / the new panel Step 1

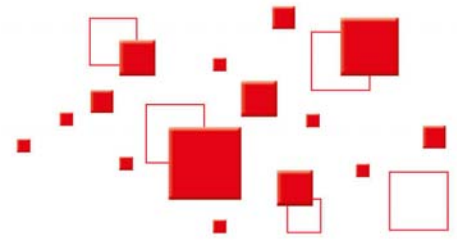
	<b>Masking:</b>	Mask the adjacent panel	
	<b>Mixing ratio:</b>	ONYX HD Step 1 HYDROMIX	100% by vol. 60% by vol.
	<b>Spray gun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	2.0 bar	
	<b>Application:</b>	1 or 2 + 1 coat to match the effect on the new panel.	
	<b>Attention:</b>	Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat. When using HB004 slow in the mixing formula, HYDROMIX slow must also be used.	

#### 3) ONYX EASY BLENDER A 2520

	<b>Masking:</b>	Demask the adjacent panel	
	<b>Mixing ratio:</b>	ONYX EASY BLENDER A 2520 HYDROMIX / HYDROMIX SLOW	100% by vol. 60 by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	2.0 bar	
	<b>Application:</b>	1 full, wet coat on the adjacent panel.	
	<b>Flash-off:</b>	No flash-off! It has to be wet during the whole blending process. At higher temperatures, it can also be applied after the first spraycoat of ONYX HD.	

#### 4) Refinishing of the transition area to the adjacent panel Step 1

	<b>Masking:</b>	Demask the adjacent panel	
	<b>Mixing ratio:</b>	ONYX HD Step 1 HYDROMIX	100% by vol. 60% by vol.
	<b>Spray gun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	1.0 bar	
	<b>Application:</b>	1 - 2 spray coats on fading out on the adjacent panel	
	<b>Flash-off:</b>	Flash off until mat with Venturi System	

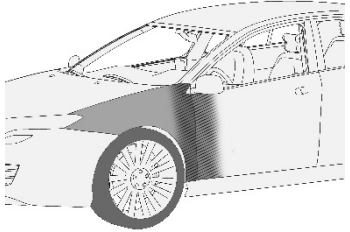


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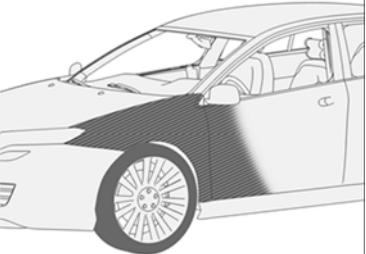
Blending in on the adjacent panel  
with ONYX HD (Translucent Step 2)

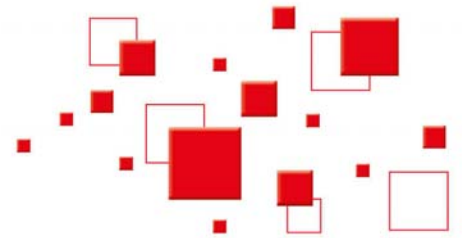
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#### 5) Refinishing of the transition area to the adjacent panel Mix Step 1 + Step 2

	<b>Mixing ratio:</b>	ONYX HD Step 1 (RFU)	100% by vol.
		ONYX HD Step 2 (RFU)	200% by vol.
		ONYX HD Step 1 + Step 2	100% by vol.
		HYDROMIX	60% by vol.
	<b>Spray gun:</b>	1.4 – 1.5 mm HVLP	
<b>Pressure:</b>	1.0 bar		
<b>Application:</b>	1 – 3 spray coats fading out on both panels		
<b>Flash-off:</b>	Flash off until mat with Venturi System		

#### 6) Refinishing of the panel to be repaired / the new panel and of the adjacent panel Step 2

	<b>Mixing ratio:</b>	ONYX HD Step 2	100% by vol.
		HYDROMIX	60% by vol.
	<b>Spray gun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	2.0 bar	
	<b>Application:</b>	1 spray coat fading out on the adjacent panel (overlapping).	
<b>Flash-off:</b>	Flash off until mat with Venturi System		

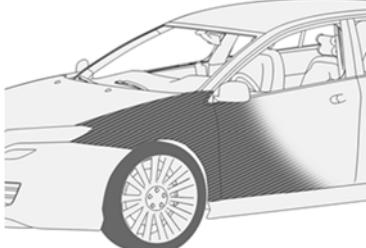


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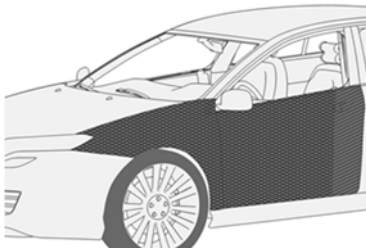
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#### 7) Refinishing of the panel to be repaired / the new panel and of the adjacent panel Step 2

	<b>Mixing ratio:</b>	<b>ONYX HD Step 2</b>	100% by vol.
		<b>HYDROMIX</b>	60% by vol.
	<b>Spray gun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	2.0 bar	
	<b>Application:</b>	1 spray coat fading out on the adjacent panel (overlapping the first spray coat).	
	<b>Flash-off:</b>	Flash off until mat with Venturi System	

#### 8) RAPIDCLEAR C 2570 Step 3

	<b>Mixing ratio:</b>	<b>RAPIDCLEAR C 2570*</b>	300% by vol.
		<b>H 2550</b>	100% by vol.
		<b>R 2200</b>	100% by vol.
		* Option CHRONOLUX CP	
	<b>Spray gun:</b>	1.3 HVLP	
<b>Application:</b>	1 thin and 1 full spray coat, overlapping.		
<b>Flash-off:</b>	not necessary		
<b>Drying:</b>	10 min at 60°C		