

## ONYX HD tri-coat system- Blending in on the panel being repaired with ONYX HD (Translucent Step 2) B 3.4

### 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. However, in order to achieve an accurate color matching of the car to be repaired, the application of color test panels is necessary.

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 (see "Blending in on the adjacent panel with ONYX HD (Translucent Step 2)"). Depending on the color (especially the pigment content of step 2) and the painter's experience, one of the two methods can be selected.

### Substrates

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

### Products required

- PK 2000
- ONYX HD
- HYDROMIX
- RAPIDCLEAR C 2570
- BLENDING FLASH

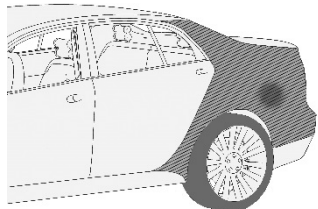
### Safety instructions

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

The products are suitable for professional use only.

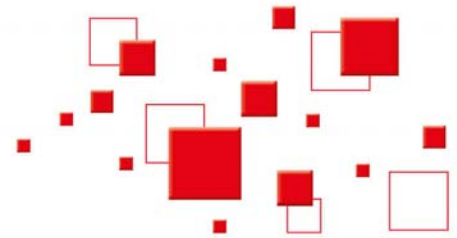
For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

### 1) Pre-treatment

	<p>1) Sanding of filler patch Degrease with PK 1000. Sand with P400 / P500, then P1000 so as to remove filler overspray from the surrounding areas.</p> <p>2) Sanding of the blending area Sand with P1000 – P2000. Degrease with PK 2000.</p>
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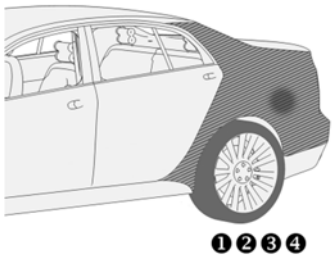
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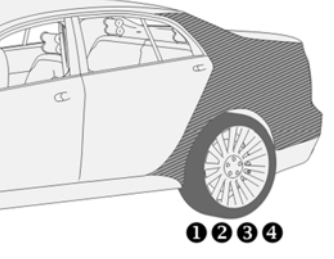


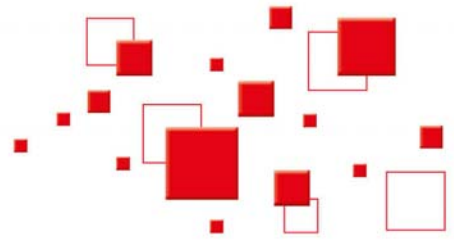
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### 2) Refinish of the damaged panel including a user – defined number of color test panels Step 1

	<b>Mixing ratio:</b>	ONYX HD Step 1	100% by vol.
		HYDROMIX	60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	1.0 – 1.5 bar	
	<b>Application:</b>	2 coats (including color test panels ①②③④ etc.) until the filler patch is invisible. Within the area and for a softer transition, both spray coats should be sprayed overlapped.	
	<b>Flash-off:</b>	Flash off until mat after each spray coat.	

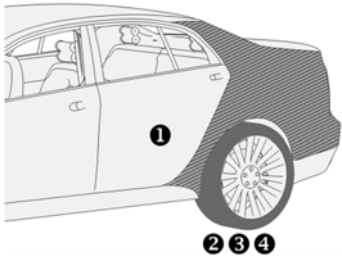
### 3) Refinish of the damaged panel and the prepared color test panels Step 2

	<b>Mixing ratio:</b>	ONYX HD Step 2	100% by vol.
		HYDROMIX	60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	1.0 – 1.5 bar	
	<b>Application:</b>	1 coat (including the prepared color test panels ①②③④ etc.)	
	<b>Flash-off:</b>	Flash off until mat.	

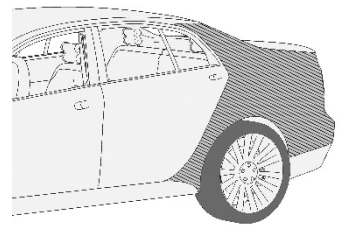


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### 4) Color matching and further spraycoats if necessary Step 2

	<p><b>Color matching:</b></p> <p>The 1<sup>st</sup> color test panel <b>1</b> is compared with the vehicle's color. <b>Attention: Before color matching apply clear coat on the test panel!</b> Is the color exactly matched, the process will be continued with the clear (see step 3).</p> <p>Otherwise apply another spraycoat on the panel to be repaired and the remaining color test panels (<b>2 3 4</b> etc.). Repeat steps until color is matched exactly.</p> <p><b>Mixing ratio:</b>    <b>ONYX HD Step 2</b>                    100% by vol.                                  <b>HYDROMIX</b>    60% by vol.</p> <p><b>Spraygun:</b>       1.4 – 1.5 mm HVLP</p> <p><b>Pressure:</b>        1.0 – 1.5 bar</p> <p><b>Application:</b>    1 - x coats: for a softer transition second coat overlaps the first.</p> <p><b>Flash-off:</b>        Flash off until mat after each spray coat.</p>
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### 5) RAPIDCLEAR C 2570 Step 3

	<p><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.</p> <p>* Option CHRONOLUX CP</p> <p><b>Spraygun:</b>       1.3 HVLP</p> <p><b>Pressure:</b>        2.0 bar</p> <p><b>Application:</b>    1 thin and 1 full spraycoat, overlapping.</p> <p><b>Flash-off:</b>        No flash-off between coats.</p> <p><b>Drying:</b>           10 min at 60°C</p>
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