

Process Information



eSense process

Process description

In the production process a combination of fossil (crude-oil based) and renewable ingredients are used. These ingredients can be separated into volumes of products that are based on fossil and biobased. The biobased volumes are now marketed under the label "eSense" for R-Mt. The "eSense" product offer for R-M consists out of six products. The formulation is identical with the already existing "fossil-based" part of the production. By the use of renewable instead of fossil material, a reduction of the CO₂ emission is achieved."

Substrates

- Automotive OEM finishes, fully cured and solvent-resistant




Products required

- PK 700 / PK 1000 / PK2000
- STOP QUICK B 2445E eSense
- LIGHT FILLER GREY P2530 E eSense
- ONYX HD Basecoat
- RAPIDCLEAR C 2570 E eSense

Safety instructions

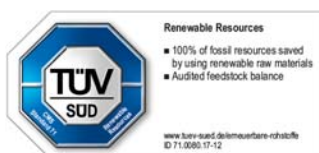
It cannot be ruled out that these products contain particles < 0.1 µm.
 The products are suitable for professional use only.
 For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

Pre-treatment

	Degreasing PK 1000
	Sanding P80 – P150 Sand damaged areas to the bare metal
	Degreasing PK 1000
	Please note: Alternatively, you may use PK 700.

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 statements 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.rmpaint.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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Body Filler

	STOP QUICK B 2445E eSense Hardener	100 g 3 g
	Time 4 min.	Temperature increase 20°C / min.
	Alternative: Time 20 – 30 min	Temperature
	Coarse sanding P80 / P150	Fine sanding P240 / P320
	Clean PK 2000	

Primerfiller

	LIGHT FILLER GREY P 2530E eSense	100% by vol.
	HVLP gravity-feed spraygun Compliant gravity-feed spraygun	1.1 mm 1.1 mm
		0.7 bar at the nozzle 2.0 bar
	Spray coats Film thickness If higher film thicknesses are necessary, a second layer LIGHT FILLER GREY P 2530E eSense can be applied with intermediate sanding after having dried the first layer. LIGHT FILLER GREY P 2530E eSense appears transparent and should not be applied to achieve hiding power.	Primer surfacer for metal ½ + 1 max. 120 µm Primer surfacer for plastics ½ + 1 max. 80 µm
	Flash off at 20°C When applying higher film builds a longer intermediate flash-off and a flash-off before drying is recommended.	20 s between spray coats
	UV drying (shortwave UV-A > 6 mW/cm²)	5 min.

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Basecoat

	Stir ONYX HD mixing bases on the mixing machine twice a day for 15 minutes		
	ONYX HD basecoat 100% by vol. depending on colour HYDROMIX 60% by vol. 60 g Mix intensively immediately after weighing. Strain before application. Attention: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat.		
	HVLP gravity-feed spray gun	1.4 – 1.5 mm	0.7 bar at the nozzle
	Spraycoats: Solid colors 2 – 3 Metallic or pearl-effect colors 1 or 2 + 1 coat to match the effect Film thickness: 20 – 25 µm 12 – 15 µm		
	Flash off until mat between spray coats and before clearcoat application		
	Alternative:		
	Time 4 min.	Temperature increase 15°C / min.	Max. surface temperature 60°C

Clear

	RAPIDCLEAR C 2570E eSense 300% by vol. H 2550E eSense 100% by vol. AIRFLASH A 2140E eSense / 100% by vol. SPEEDFLASH S A 2120E eSense		
	HVLP gravity-feed spray gun	1.3 – 1.5 mm	2.0 bar
	Spraycoats: ½ + 1 Film thickness: 40 – 50 µm		
	Time 10 min.	Temperature increase 15°C / min.	Max. surface temperature 60°C
	Alternative:		
	Time 10 min	Temperature 60°C	