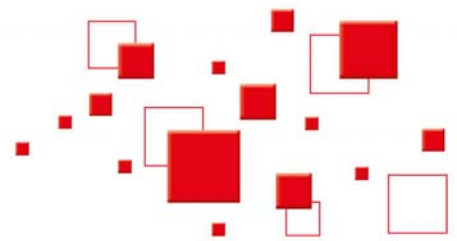


Technical Information

ONYX HD ACTIVATOR



Activator for waterborne basecoats

Product Category: **C 5**

Fields of use

For special applications recommended by car manufactures, the usage of ONYX HD ACTIVATOR could be necessary in ONYX HD basecoats.

Additive for solid-colour ONYX HD and for use in solid-color basecoats applied as a ground coat in ONYX HD 3-layer systems to improve tape resistance and hardness.

Additional Information

Technical characteristics

Solids content 78 % \pm 2	Density 1.030– 1.130 g/cm ³
Storage temperature min. 5°C to max. 45°C	Shelf life 24 months

Application

New mixing bases must be stirred manually before use and additionally for 15 minutes in the mixing machine. Stir all products stored in the mixing machine twice a day for 15 minutes.

Substrate / Pre-treatment / Cleaning

Clean with PK 2000.

Sand with P400 (sanding filler and well-cured or solvent-resistant old paintwork).

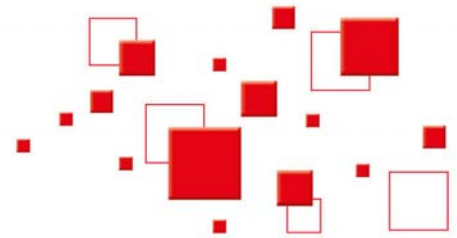
Clean with PK 2000.







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ONYX ACTIVATOR



	<p> ONYX HD solid color* 100% by vol. 0,1 l ONYX HD ACTIVATOR 5% by vol. 5 g HYDROMIX 80% by vol. 80 g Mix the ONYX HD basecoat to the formula and stir it carefully. Add ONYX HD ACTIVATOR and stir again carefully. Add HYDROMIX and stir carefully. Strain before application. *Mixing formulas that contain HB 100, HYDROMIX, MIXINGBASE W cannot be used with ONYX HD ACTIVATOR </p>
	<p> Viscosity at 20°C: ISO 4 cup: 42 to 68 seconds DIN 4 cup: 18 to 25 seconds </p>
	<p>Potlife: 2 hours 20°C</p>
	<p> HVLP gravity-feed spraygun 1.4 – 1.5 mm 0.7 bar at the nozzle </p>
	<p> Solid color or ground coat Spraycoats: 2 – 3 Film thickness: 20 – 25 µm For some colors, one further spraycoat may be necessary. Flash off until mat after each spraycoat. </p>
	<p> The drying time depends on climatic conditions and equipment used. Drying at 20°C: approx. 15 min. Drying at 60°C: approx. 10 min. + cooling </p>
	<p> 1st spraycoat: flash off at room temperature until mat. 2nd spraycoat: at 40 – 50°C (max 70°C) surface temperature to mat surface + cooling. </p>

Finishing

Apply one of the recommended R-M clears. ONYX HD basecoats may be over coated with the same product after the indicated drying times.

Safety instructions

It cannot be ruled out that this product contains particles < 0.1 µm.

The products are suitable for professional use only.

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.