

ONYX HD

Gleam Silver HB 10S

C 3.1

Process description

Paint System for the use of ONYX HD special colors containing "Gleam Silver" HB 10S like BMW A80, BMW A91, or VW LZ49

1. Edge to edge repair

1-1. Substrates

PROFILLER GREY, PERFECTFILLER GREY, EUROXY CP or full cured, solvent resistant old paintwork

1-2. Pretreatment

- 1) Sand surfacer with a dual action sander P500
- 2) Sand with dual action sander P1000 to cover the sanding marks of P500
- 3) Degrease with PK 2000

Note:

- If the rough surface of primer filler remains, it will result in a scaly appearance
- If the sand-scratch marks of P500 remains, it will affect the surface quality by mottling or telegraphing the sand-scratches
- Use sanding guide to control the sanding process
- Use soft inter face pad for orbital sander

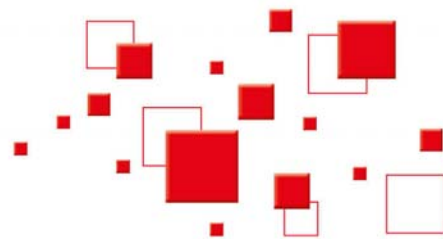
Required products

- HB 100
- HYDROMIX
- ONYX HD Gleam Silver color
- R-M Clear

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1-3. Application of HB 100

Mixing ratio:

HB 100 100% by vol.

HYDROMIX 60% by vol.

(Stir immediately after having added adjusting base)

Spray coats: 1 wet

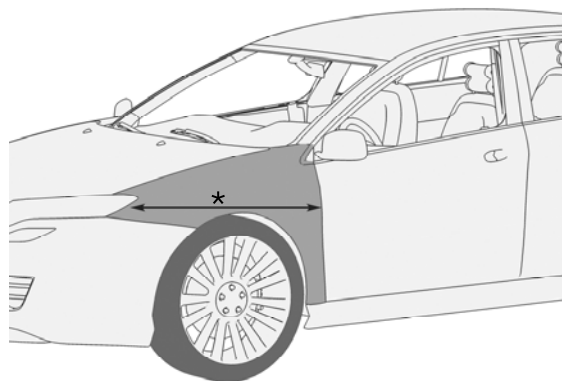
Flash-off time: 15 min. 20°C

Spray gun setting: 1.4 – 1.5 mm HVLP

Intake pressure 2.0 bar

Note

- For ground coat, apply wet coat to avoid generating peel on the surface.
- Allow the total dry time to expire in order to avoid creating a scaly surface.



* = 1 wet coat

1-4. Application of "Gleam Silver" HB 10S color

ONYX HD "Gleam Silver" HB 10S color as supplied by distributor

ONYX HD "Gleam Silver" color 100% by vol.

HYDROMIX 60% by vol.

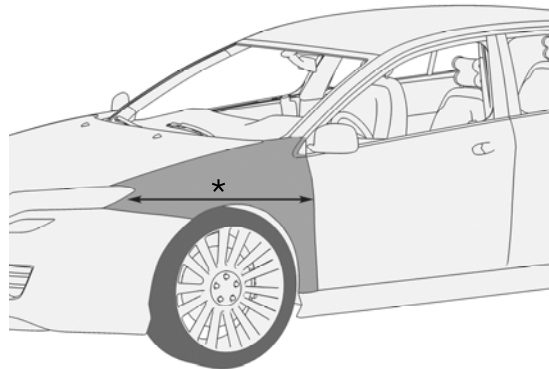
(Stir immediately after having added adjusting base)

Spray coats: ca. 2 – 3 + 2 effect coats

Dry time: Flash off until matt, after each single coat

Spray gun setting: 1.4 – 1.5 mm HVLP

Intake pressure 2.0 bar



* = 2 – 3 coats + 2 effect coats

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1-5. Application of R-M clear

Apply R-M clear according to technical information

2. Blend-in technique

2-1. Substrates

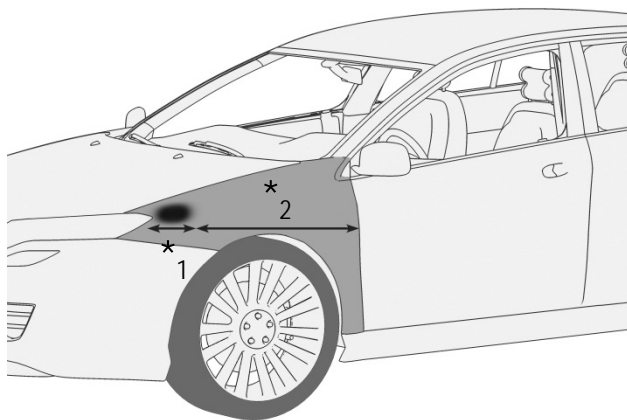
PROFILLER GREY, PERFECTFILLER GREY, EUROXY CP or full cured, solvent resistant old paintwork

2-2. Pretreatment

- 1) Sand substrates with a dual action sander P500
- 2) Sand with dual action sander P1000 to cover the sanding marks of P500
- 3) Sand with dual action sander P1500 the fade out zone
- 4) Degrease with PK 2000

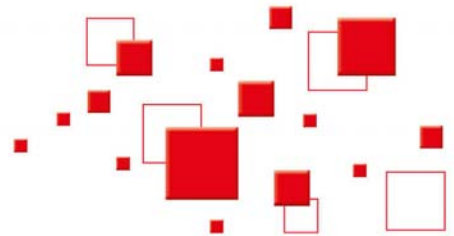
Note

- If the rough surface of the substrates remains, it will result in a scaly appearance.
- If the sand-scratch marks of P500 remains, it will affect the surface quality by mottling or telegraphing the sand-scratches.
- Use sanding guide to control the sanding process
- Use soft inter face pad for orbital sander



* 1= P500 / P1000

* 2= P1500



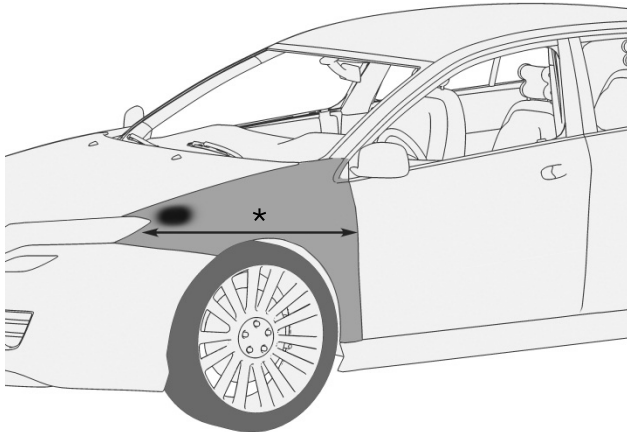
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2-3. Application von HB100 (1)

Mixing ratio:	
HB100	100% by vol.
HYDROMIX	60% by vol.
Spray coats:	1 wet
Flash-off time:	flash off until mat
Spray gun setting:	1.4 – 1.5 mm HVLP
Intake pressure	2.0 bar

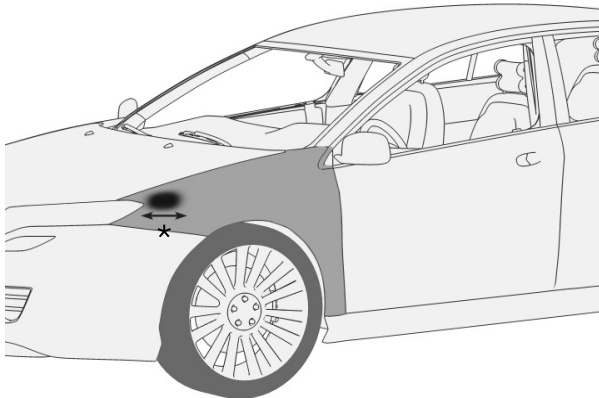


* = 1 wet spray coat

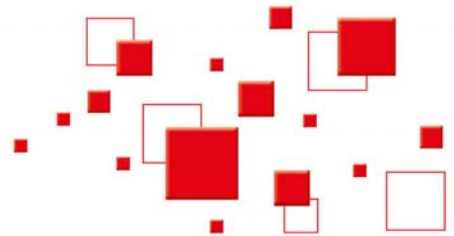
2-4. Application von "Gleam Silver" color (1)

ONYX HD "Gleam Silver" color as supplied by distributor

Mixing ratio:	
ONYX HD "Gleam Silver" color	100% by vol.
HYDROMIX	60% by vol.
(Stir immediately after having added adjusting base)	
Spray coats:	2 – 3
Flash-off time:	Flash off until matt, after each single coat
Spray gun settings:	1.4 – 1.5 mm HVLP
Intake pressure	1.0 – 1.5 bar



* = 2 – 3 coats



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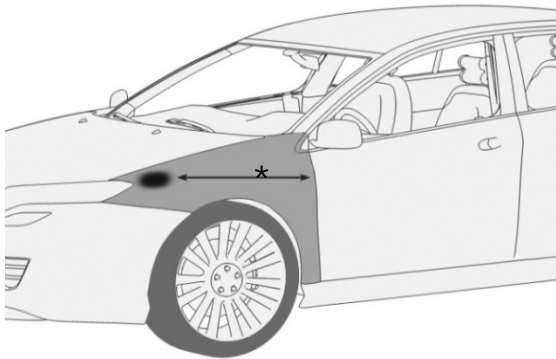
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2-5. Application of HB 100 (2)

Mixing ratio:	
HB100	100% by vol.
HYDROMIX	60% by vol.
Spray coats:	1 wet
Flash-off time:	flash off until mat
Spray gun setting:	1.4 – 1.5 mm HVLP
Intake pressure	2.0 bar

Note

- Before the mist coat of "Gleam Silver" base coat, apply a wet coat of blending clear on the blending area to avoid overspray mist.

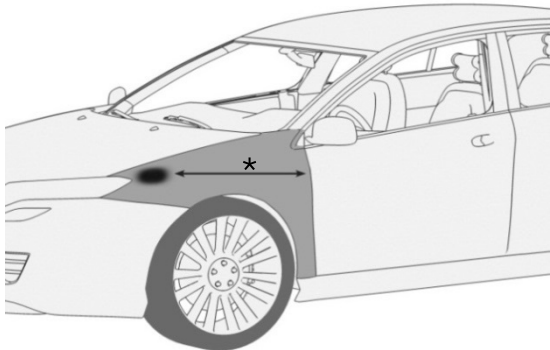


* = 1 wet coat

2-6. Application of "Gleam Silver" color (2)

ONYX HD "Gleam Silver" color as supplied by distributor

Mixing ratio:	
ONYX HD "Gleam Silver" color	100% by vol.
HYDROMIX	60% by vol.
(Stir immediately after having added adjusting base)	
Spray coats:	2 effect coats
Flash-off time:	flash off until mat
Spray gun setting:	1.4 – 1.5 mm HVLP
Intake pressure	0.8 – 1.5 bar



* = 2 effect coats

2-7. Application of R-M clear

Apply R-M clear according to technical information