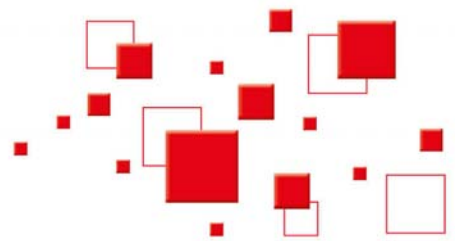


Technical Information

ONYX HD



SPECIAL CRYSTAL BASE

Product Category: **C 3.1**

Fields of use

Special-color finishes or colors with special and exclusive color effects which can only be reproduced by adding rarely used color pigments to ONYX HD mixing bases.

Additional Information

These rarely used pigments are not available as a mixing base for the mixing machine. The colors are only available as ready-mixed colors from the respective business partner.

Technical characteristics

Solids content 15 % \pm 2	Density depending on color
Storage temperature min. 5°C to max. 45°C	Shelf life

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.

Attention: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat.

Substrate / Pre-treatment / Cleaning

Clean with PK 2000.

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

Clean with PK 2000.

Alternative: apply to R-M wet-on-wet filler or sealer.

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 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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	ONYX HD mixing formula* HYDROMIX * contains SPECIAL CRYSTAL BASE, Mixing Clear HB002 and further mixing bases if necessary.	100% by vol. 60% by vol.	depending on color 60 g
	Viscosity at 20°C: ISO 4 cup: DIN 4 cup:	42 to 68 seconds 18 to 25 seconds	
	Potlife: ONYX HD ready for use: 1 week in a sealed plastic vessel.		
	Please search the color database for the color code to check whether a specific ground coat color is required for "Step 1" to reproduce the desired color.		
	HVLP gravity-feed spraygun	1.4 – 1.5 mm	0.7 bar at the nozzle
	Spraycoats: Film thickness: Flash off until mat after each spraycoat.	1 or 2 + 1 coat to match the effect 12 – 15 µm	
	Drying at 20°C: Drying at 60°C:	approx. 15 min. Possibility to speed up the process with additional air flow approx. 10 min. + cooling	
	Drying IR 1st spraycoat, flash off at room temperature until mat. 2nd spraycoat, at 40 – 50°C (max 60°C) surface temperature to mat surface + cooling. Harmonizing coat, flash off at room temperature until mat		

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

2004/42/II B(d)(420)419: The EU limit value for this product (product category: IIB.d) in ready-for-use form is max 420 grams of VOC per liter. The VOC content of this product is 419 g/l.

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.