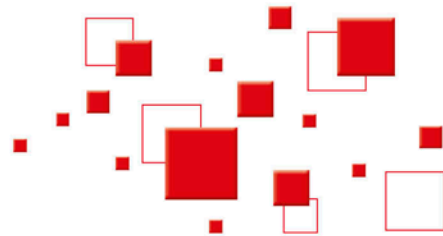


# Process Information

## Citroen Cactus Airbump



### Process description

Paint system for the repair of Citroen Cactus Airbump panels produced out of TPU thermoplastic polyurethan

### Substrates

- Airbump panels out of TPU thermoplastic polyurethan

### Products required

- PK 1000 / PK 2000
- STOP FLEX
- AM 870 SEALERPALST 90
- PERFECTFILLER WHITE, BLACK, GREY
- FLEX
- ONYX HD
- CRYSTALCLEAR CP

### 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. Substrate without defects

##### Pre-treatment

	Degreasing PK 1000
	Sanding Pad grey
	Degreasing PK 1000

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.rmpaint.com](http://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.




R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 10/2015







# Process Information

## Citroen Cactus Airbump

### Primer

	<b>AM 870 SEALERPLAST 90</b> shake vigorously for 2 min. before use
	Spraycoats: 1 – 2 Film thickness: 5 µm
	Flash-off 20°C: 15 min.





### Filler

	<b>PERFECTFILLER WHITE, GREY, BLACK</b> 400% by vol.      100 g <b>FLEX</b> 100% by vol.      16 g <b>D 70 / D 80</b> 150% by vol.      23 g <b>FR 500, R 2100, R 2200, R 2300</b> 100% by vol.      14 g Alternatively, use filler mixes or mixes for highly flexible plastic parts as shown in Appendix A 1.6.1, "Undercoat mixing ratios"
	Spraycoats: 2 Film thickness: 50 – 70 µm
	60°C      30 min.
	Dry with P800, then degrease with PK 2000





# Process Information

## Citroen Cactus Airbump

### Basecoat

	ONYX HD basecot HYDROMIX	100% by vol. 60% by vol.	
	HVLP gravity-feed spray gun	1.4 – 1.5 mm	0.7 bar at the nozzle
	Spray coats: Film thickness:	<b>Solid</b> 2 20 – 25 µm	<b>Effect</b> 2 ½ 12 – 15 µm
	Flash off until surface until matt between spray coats and before clear coat		

### Clear




	CRYSTALCLEAR CP H 420 SC 850 / SC820 / SC 880	300% by vol. 100% by vol. 100% by vol.	
	HVLP gravity-feed spray gun Compliant gravity-feed spray gun	1.3 – 1.5 mm 1.3 – 1.4 mm	0.7 bar at the nozzle 2.0 – 2.5 bar
	Spray coats: Film thickness:	2 40 – 60 µm	
	60°C	30 min.	

# Process Information





## Citroen Cactus Airbump

### 2. Slightly damaged panels




#### Pre-treatment

	Degreasing PK 1000
	Damaged area P150 / entire part sanding pad grey
	Degreasing PK 1000

#### Putty

	STOP FLEX Hardener	100 g 3 g
	Coats:	1 – 2
	20°C	25 – 35 min.
	Dry with P80, P150, P240, P320, P400	





#### Primer

	AM 870 SEALERPLAST 90 hake vigorously for 2 min. before use	
	Spraycoats: Fim thickness:	1 – 2 5 µm
	Flash-off 20°C:	15 min.





# Process Information

## Citroen Cactus Airbump





### Filler

	<p>PERFECTFILLER WHITE, GREY, BLACK 400% by vol. 100 g</p> <p>FLEX 100% by vol. 16 g</p> <p>D 70 / D 80 150% by vol. 23 g</p> <p>FR 500, R 2100, R 2200, R 2300 100% by vol. 14 g</p> <p>Alternatively, use filler mixes or mixes for highly flexible plastic parts as shown in Appendix A 1.6.1, "Undercoat mixing ratios"</p>
	<p>Spraycoats: 2</p> <p>Film thickness: 50 – 70 µm</p>
	<p>60°C 30 min.</p>
	<p>Dry with P800, then degrease with PK 2000</p>

### Basecoat

	<p>ONYX HD basecoat 100% by vol.</p> <p>HYDROMIX 60% by vol.</p>									
	<p>HVLP gravity-feed spray gun 1.4 – 1.5 mm 0.7 bar at the nozzle</p>									
	<table border="0"> <tr> <td>Spray coats:</td> <td><b>Solid</b></td> <td><b>effect</b></td> </tr> <tr> <td>Film thickness:</td> <td>2</td> <td>2 ½</td> </tr> <tr> <td></td> <td>20 – 25 µm</td> <td>12 – 15 µm</td> </tr> </table>	Spray coats:	<b>Solid</b>	<b>effect</b>	Film thickness:	2	2 ½		20 – 25 µm	12 – 15 µm
Spray coats:	<b>Solid</b>	<b>effect</b>								
Film thickness:	2	2 ½								
	20 – 25 µm	12 – 15 µm								
	<p>Flash off until surface is matt between the coats and before clear coat</p>									

### Clear

	<p>CRYSTALCLEAR CP 300% by vol.</p> <p>H 420 100% by vol.</p> <p>SC 850 / SC820 / SC 880 100% by vol.</p>
	<p>HVLP gravity-feed spray gun 1.3 – 1.5 mm 0.7 bar at the nozzle</p> <p>Compliant gravity-feed spray gun 1.3 – 1.4 mm 2.0 – 2.5 bar</p>
	<p>Spray coats: 2</p> <p>Film thickness: 40 – 60 µm</p>
	<p>60°C 30 min.</p>