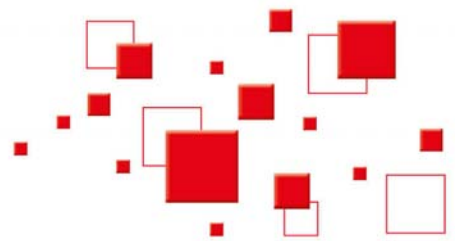


Process Information

Lexus Dark Grey Met 1K7 Mat Clear System



Application

R-M Matt Shade Concept was designed to achieve equal mat surfaces on ONYX HD / DIAMONT basecoat with the clears SILICATOP und SATINTOP. With the mixture of both mat clears gloss levels of 12 up to 65 units at an angle of 60 could be achieved.

Background:

The gloss level of the OEM and repair finishes may occasionally vary on one and the same car. This may lead to additional work in the refinishing process.

Possible reasons:

- Gloss level deviations or variations within the original coating (original mat finishes applied at the carmakers' production lines, for example, show gloss level differences between vertically and horizontally coated panels)
- Carmakers use different paint products with different gloss levels
- In the refinishing process, insufficient flash-off times after the spraycoats and too high or too low film builds may lead to different gloss levels of the mat clearcoat. Other reasons may be that the recommended basecoat film build was not respected or that the spraycoats applied did not overlap correctly.

Measures:

- In order to avoid the above described different gloss levels, R-M recommends to respect the specified basecoat and clearcoat film builds and to flash off the clearcoat sufficiently after each spraycoat, i.e. until the surface is completely (Flash off until mat between spraycoats and before stoving. After the first spraycoat, allow to flash off for 10 – 15 min, after the second spraycoat for 15 – 20 min.) Do not flash off for more than 25 minutes after each spraycoat.
- R-M recommends the R-M Matt Shade concept swatch to determine the gloss level of the vehicle to be repaired.
- These specifications refer to finishes for solid-color and metallic basecoats. Light and pure silver colors can increase the gloss level. Therefore, we recommend producing a spray-out sample before each refinishing job.
- SILICATOP and SATINTOP can be used without FLEX Additive for plastic parts!
- Mat surfaces cannot be polished in order to remove dust inclusions.
- Matt clears cannot be faded out. Therefore, application of whole panel is necessary.

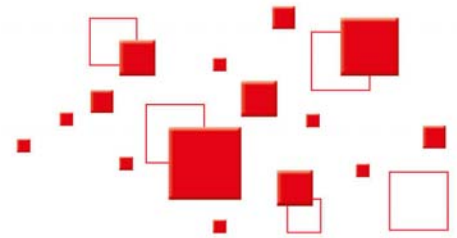
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Process Information

Lexus Dark Grey Met 1K7 Mat Clear System



Additional Information:

It is imperative to avoid:

- Polishing or sanding of clearcoat surface
- usage of wax or polish
- usage of "scratching" sponges (e.g. household sponge, rag, etc.)
- usage of any aggressive agents (cleaner, oil, fat, etc.)

Cleaning instruction:

- do not use car wash sides
- never wash a car with mat clear in direct sunlight
- Not adherent particles (dust, leaves, etc.) should be removed with compressed air before washing the car
- Soak any remaining dead insects, bird droppings etc. with plenty of water and remove them with a high-pressure cleaner.
- The vehicle should preferably be washed by hand, using a soft sponge, a neutral cleaning agent and plenty of water.
- The washed car should be preferably dried with compressed air or by wiping with a soft leather rag

Substrates

- R-M fillers (R-M PREP'ART System)
- Automotive OEM finishes, fully cured and solvent-resistant
- Refinishes, fully cured and solvent-resistant

Products required

- PK 2000
- ONYX HD / DIAMONT basecoats
- SATINTOP / SILICATOP
- H 420
- SC850

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



Cleaning PK 2000

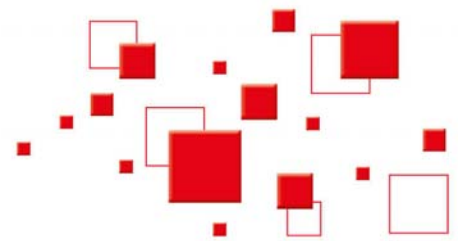
Applying the basecoat







ONYX HD / DIAMONT
Apply in accordance with the Technical Data Sheet

Process Information

Lexus Dark Grey Met 1K7 Mat Clear System



Applying the clear

| | | | | | | | | | |
|--|--|--------------------------------------|--|--|-------|-------|------|--------|------|
|  | Mixing ratio of R-M clears to achieve a gloss level of 12 – 65 units when using hardener H 420: | | | | | | | | |
| | Mixing ratio % by vol. | Gloss level +/- 2 at an angle of 60° | | | | | | | |
| | | 30 | | | | | | | |
| | SILICATOP | 20 | | | | | | | |
| | SATINTOP | 80 | | | | | | | |
| Stir well before use Clear coat mixture <table style="width: 100%; border: none;"> <tr> <td style="width: 50%;"></td> <td style="width: 50%; text-align: right;">100 g</td> </tr> <tr> <td>H 420</td> <td style="text-align: right;">50 g</td> </tr> <tr> <td>SC 850</td> <td style="text-align: right;">36 g</td> </tr> </table> | | | | | 100 g | H 420 | 50 g | SC 850 | 36 g |
| | 100 g | | | | | | | | |
| H 420 | 50 g | | | | | | | | |
| SC 850 | 36 g | | | | | | | | |
|  | HVLP gravity-feed spraygun Compliant gravity-feed spraygun | 1.3 – 1.5 mm 1.3 – 1.4 mm | 0.7 bar at the nozzle 2.0 – 2.5 bar | | | | | | |
|  | Spraycoats: 2 Film thickness: 40 – 50 µm Flash off until mat between spraycoats and before stoving. After the first spraycoat, allow to flash off for 10 - 15 min, after the second spraycoat for 15 - 20 min. Do not flash off for more than 25 minutes after each spraycoat. | | | | | | | | |
|  | Drying at 60°C | | 30 min. | | | | | | |