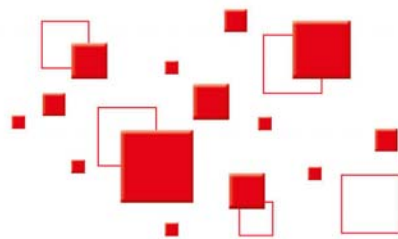


Process Information



Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2) Mazda 46V Soul Red Crystal Met.

This one service mixing formula is recommended to be used in conjunction with this blending process, listed below.

With all translucent colors there is the need to verify the amounts of spray coats needed for each color match for each vehicle. Therefore, and due to differences in application techniques we recommend to apply different amounts of spray coats of Step 2 (translucent coat) to test panels of Step 1 to match the process and color of the vehicle to be repaired.

This process provides paint material and time saving advantages:

- Easier and safer blending process
- No need to use R-M ONYX EASY BLENDER A 2520

| Service Formula 1 | |
|-------------------|---------------|
| Mazda 46V | Step 1 |
| HB002 | 60,00 |
| HB88M | 17,50 |
| HB80T | 12,75 |
| HB861 | 7,80 |
| HB120 | 1,90 |
| | |
| Mazda 46V | Step 2 |
| HB002 | 4,20 |
| HB100 | 89,90 |
| HB80T | 6,00 |

Recommendation:

Service formula 1 usually needs 2½ coats of Step 2.

Please check color and application first on test panels before applying to the vehicle.

Please refer to the following Blending Process:

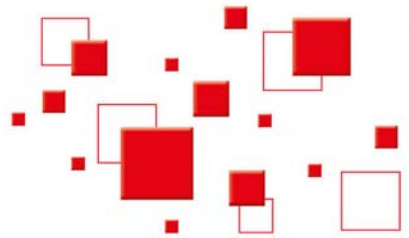
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Process Information

Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2) Mazda 46V Soul Red Crystal Met.



Process description

In principle, panel repairs with translucent ONYX HD basecoats are possible. Therefore, it is in general not necessary to respray adjacent body parts. But when color differences beyond allowable limits are to be expected, the more appropriate method to balance color differences may be to blend into the damaged area and/or the adjacent part. This procedure can be considerably more efficient and economical than time-consuming color matching.

Substrates

- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Refinishes, fully cured and solvent-resistant

Substrates

- Stick to the recommended flash-off times.
- Flash off after each spray coat until the surface is completely mat.
- Flash-off times can be reduced by additional ventilation with blow equipment (e.g. Dry Jet).
- Brief increase of temperature in combined spray booths or by intermediate drying at 40°C in the oven after the final coat.
- An increasing basecoat thickness needs more flash-off time.

Products required

- PK 1000 / PK 2000
- ONYX HD Mazda 46V
- HYDROMIX
- RAPIDCLEAR C 2570

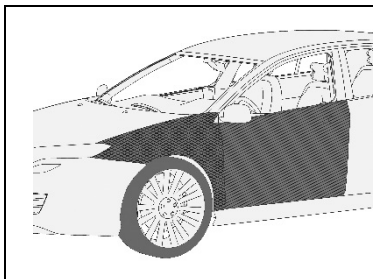
Safety instructions

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) Pre-treatment



Degrease with PK 1000.

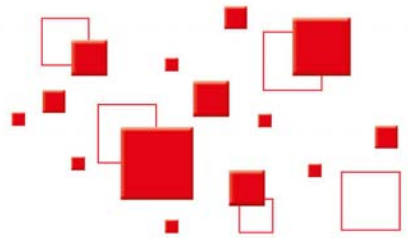
Sanding with foam pad P1000 – P2000.

Degrease with PK 2000.

Final sanding of the filler surfacer with orbital sander, not coarser than P500, and not finer than P1000.

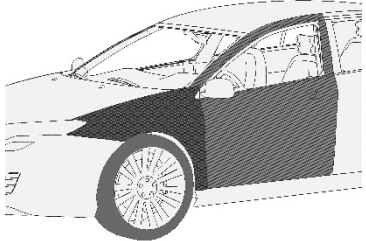


Process Information

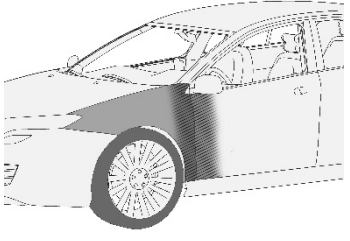


Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2) Mazda 46V Soul Red Crystal Met.

2) Refinishing of the panel to be repaired / the new panel Step 1

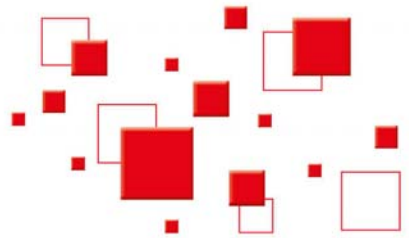
| | |
|--|--|
|  | Masking: Mask the adjacent blending panel if necessary |
| | Mixing ratio: ONYX HD Mazda 46V Step 1 100% by vol. HYDROMIX 60% by vol. |
| Spray gun: 1.4 – 1.5 mm HVLP | |
| Pressure: 2.0 bar | |
| Application: 2 (spray to cover) + ½ coat to match the effect | |
| Notes: Demask the adjacent panel, after the last spray coat has dried. Using <u>Step 1</u> fade out and overlap each spray coat into the adjacent panel. Keep the blend small and keep the edge transition soft and gradual. Maximum pressure 1.5 bar when blending out. Do not use ONYX BLENDER PRO. | |

2.1) Refinishing of the transition area to the adjacent panel Step 1

| | |
|---|--|
|  | Mixing ratio: ONYX HD Mazda 46V Step 1 100% by vol. HYDROMIX 60% by vol. |
| | Spray gun: 1.4 – 1.5 mm HVLP |
| Pressure: 1.0 – 1.5 bar | |
| Application: 1 - 2 spray coats fading out on both panels + ½ coat to match the effect | |
| Flash-off: Flash off until mat | |
| Notes: Reduce spray gun pressure when blending. After <u>Step 1</u> has dried, use tack rack on the blended panel to remove any loose over spray. | |



Process Information



Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2) Mazda 46V Soul Red Crystal Met.

3) Refinishing of the panel to be repaired / the new panel and of the adjacent panel Step 2

| | | |
|--|---|-----------------------------|
| | Mixing ratio: ONYX HD Mazda 46V Step 2 HYDROMIX | 100% by vol. 60% by vol. |
| | Spray gun: 1.4 – 1.5 mm HVLP | |
| | Pressure: 2.0 bar on repaired panel. 1.5 bar on blending area | |
| | Application: 1 - 2 + ½ spray coats to match the effect Application of ½ coat 1.5 bar. | |
| | Flash-off: Flash off until mat | |
| | Notes: Fade out and overlap each spray coat into the adjacent panel. Reduce pressure when blending into adjacent panel if needed. Apply the ½ coat to match the effect over the repaired area with reduced pressure of 1.5 bar. Apply staggered overlaps to produce consistent basecoat finish. | |

4) RAPIDCLEAR C 2570

| | | |
|--|---|--|
| | Mixing ratio: RAPIDCLEAR C 2570* H 2550 R 2200 | 300% by vol. 100% by vol. 100% by vol. |
| | * Option CHRONOLUX CP | |
| | Spray gun: 1.3 HVLP | |
| | Application: 2 spray coats. | |
| | Flash-off: not necessary | |
| | Drying: 30 min at 60°C | |

