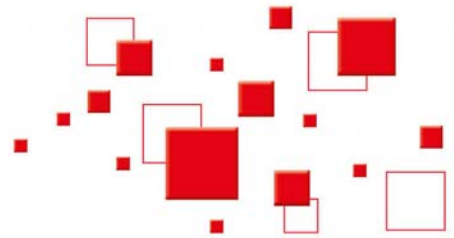


Process Information

Repair of Peugeot 208 mat textured paintwork and blending with ONYX HD



Process description

System designed to repair textured finishes with ONYX HD and R-M® Textured Mat Clear coat systems. On the new Peugeot 208 model, Ice silver (EWW ice silver nacre met mat textured) and Ice Grey (EJD silky grey nacre mat) colors present a complete mat textured finish over the entire vehicle. In principle, panel repairs with basecoat / clearcoat systems are possible. Therefore, generally, it is not necessary to respray adjacent body parts. When color differences beyond allowable limits are to be expected and when the areas to be resprayed are not limited by trim strips or edges, the more appropriate method to balance color differences may be to blend in the damaged area and the adjacent part, if required. This procedure can be considerably more efficient and economical than time-consuming color matching. However, it is not possible to blend in the mat textured clearcoat!

To repair a panel painted in mat textured finish and to avoid differences in appearance, the complete panel must be repainted with the textured clearcoat. Then apply and blend in the basecoat, after that the mat textured clearcoat on the complete panel.

Substrates

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

Products required

- PK 1000 / 2000
- ONYX HD
- ONYX EASY BLENDER A 2520
- HYDROMIX
- R-M mat clears
- MT 900

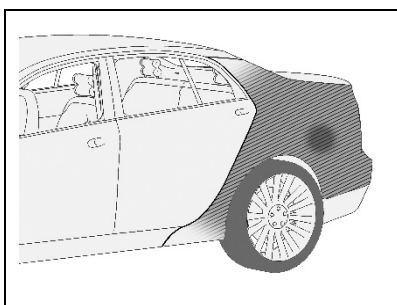
Safety instructions

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



Sanding of filler patch
Degrease with PK 1000.

Sand with P400 / P500, the original texture clearcoat on the repair area where basecoat has to be applied must be sanded smooth.

Sanding of ONYX HD blending area. Sand with P1000 – P1200. The area to be clear coated only needs to be abraded and not sanded smooth.

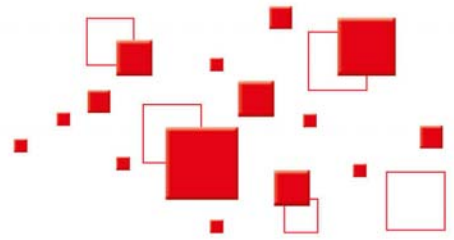
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Process Information

Repair of Peugeot 208 mat textured paintwork and blending with ONYX HD



The mat textured metallic finish is a two-layer system:

- 2nd coat = mat textured clearcoat
- 1st coat = ONYX HD Basecoat



Application of ONYX HD (Blending)

When identifying the color, three things need to be taken into consideration. The actual color, the gloss level of the mat clear and the textured finish. All three parts have a big influence on the final finish.

If the standard formula does not fit the vehicle being repaired, check service formulas or additional information. If there is a replacement panel or an area near the repair that will be recoated, this can be sanded and polished to a gloss level to help to identify the color first, especially when COLORMASTER is used as an abstract tool.

1) Hiding the filler patch

	Mixing ratio:	ONYX HD	100% by vol.
		HYDROMIX	60% by vol.
	Spraygun:	1.4 – 1.5 mm HVLP	
	Pressure:	1.0 – 1.5 bar	
	Application:	1 or 2 coats until the filler patch is almost invisible.	
	Flash-off:	Flash off until mat.	

2) Applying ONYX EASY BLENDER A 2520

	Mixing ratio:	ONYX EASY BLENDER A 2520	100% by vol.
		HYDROMIX / HYDROMIX SLOW	60% by vol.
	Spraygun:	1.4 – 1.5 mm HVLP	
	Pressure:	2.0 bar	
	Application:	1 spraycoat	
	Flash-off:	not necessary	

3) Blending into the surrounding area and applying the ONYX HD effect coat

	Mixing ratio:	ONYX HD / HYDROMIX (ready for use)	100% by vol.
		ONYX B EASY BLENDER A 2520 / HYROMIX (ready for use)	100% by vol.
	Spraygun:	1.4 – 1.5 mm HVLP	
	Pressure:	1.0 – 1.5 bar	
	Application:	2 or 3 thin spraycoats, fading out into the surrounding area.	
	Flash-off:	Flash off until mat. 1 thin coat to match the effect.	



Process Information

Repair of Peugeot 208 mat textured paintwork and blending with ONYX HD

Special precautions:

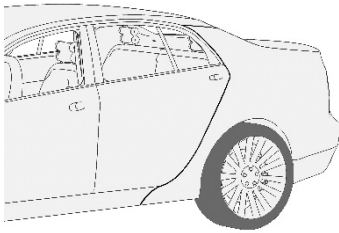
Painting must be carried out in the cleanest possible conditions. No surface defect can be removed through polishing. Removing a surface defect, if necessary, requires repainting of the complete panel, which means that the complete system consisting of a texture coat, a basecoat and a mat clearcoat must be re-applied.

MFR code	Color Name	Color Code
PEU	ICE SILVER NACRE MET MAT TEXTU	EWV
PEU	SILKY GREY NACRE MAT	EJD

Remarks:

In order to avoid any gloss deviation when refinishing mat textured clearcoats, it is important to observe the recommended film thicknesses for basecoat and clearcoat. Apply staggered overlaps to produce consistent basecoat and clearcoat film thicknesses, and allow the clearcoat to flash off until completely mat after each spraycoat. (Generally, after the first spraycoat 10 – 15 min and after the second spraycoat 15 – 20 min.) This depends on air speed and spraybooth temperature. Do not flash off for more than 25 min. after each spraycoat. Strain the RFU mixture with minimum 190 µm filters.

4) Textured mat clear

	Mixing ratio:	
		SILICATOP 75 grams MT 900 25 grams H 420 23 grams SC 850 36 grams
	Spraygun:	1.4 – 1.5 mm HVLP
	Pressure:	2.0 bar
	Application:	2 spraycoats
	Flash-off:	Flash off until mat between each spraycoat
	Drying:	30 min. 60°C

Maintenance of the textured paint:

Always avoid:

- Polishing of the paint surface
- The use of wax and polish
- The use of abrasive sponges (e.g. household sponges, cloths etc.)
- Car wash
- The use of aggressive products (cleaning agents, oils, greases etc.)

Cleaning:

- Do not wash the vehicle in bright sunlight.
- Before washing, remove soiling such as dust, leaves etc., using compressed air.
- Soak the remains of insects and bird droppings in water before removing them using a high-pressure cleaner.
- Wash preferably by hand, using a soft sponge, neutral soap and lots of water.
- Dry preferably with compressed air and a piece of soft chamois leather.