

# Process Information

## Blend-in repair

### R-M ONYX HD – Porsche chrome blue / silver liquid metal

#### Process description

Special blend-in system for repairing a Porsche 918 Spyder in chrome blue and silver (liquid metal).

Prefer to blend into the adjacent panel(s) because a cosmetic damage repair of these specific colours might cause a deviation in the finish colour.

#### Substrates

- Fully cured Porsche Spyder finish

#### Products required

- PK 2000
- ONYX HD chrome blue and silver (liquid metal)
- ONYX BLENDER PRO
- SUPREMELUX CP


#### Safety instructions

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

Comply with present safety instructions and personal protective equipment.

#### Pre-treatment

	<p>Clean with <b>PK 2000</b>.</p> <p>Sand filler area with P500. Then use P1000 or P1500 to make the sanding scratches less profound.</p> <p>Dry sand the blending area manually with P1500 and then clean it with PK 2000.</p> <p>Alternatively to manual sanding, you can also use an orbital sander.</p>
---	---

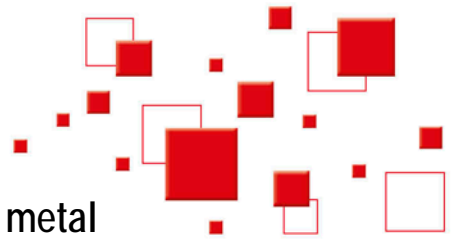
The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these statements do not relieve processors from carrying out their own investigations and tests; neither do these data imply 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, 05/2013


# Process Information

## Blend-in repair


### R-M ONYX HD – Porsche chrome blue / silver liquid metal




#### 1) ONYX BLENDER PRO

	Mask the adjacent panel before applying ONYX BLENDER PRO.	
	<b>Mixing ratio:</b>	
	ONYX BLENDER PRO	100% by vol.
	HYDROMIX	60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP, 2.0 bar
<b>Spraycoats:</b>	1	
<b>Flash-off:</b>	until matt	


#### 2) ONYX HD liquid metal

	<b>Mixing ratio:</b>	
	ONYX HD liquid metal	100% by vol.
	HYDROMIX	60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP, 2.0 bar
	<b>Spraycoats:</b>	1
<b>Flash-off:</b>	until matt	
Remove the masking material from the adjacent panel once ONYX BLENDER PRO has flashed off.		

#### 3) ONYX BLENDER PRO

	<b>Mixing ratio:</b>	
	ONYX BLENDER PRO	100% by vol.
	HYDROMIX	60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP, 2.0 bar
	<b>Spraycoats:</b>	1
Apply ONYX BLENDER PRO to the blending area (in this example the driver's door). ONYX BLENDER PRO should be wet when applying the basecoat on top.		

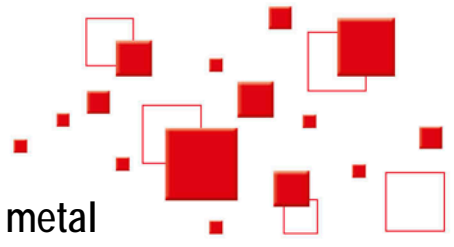
#### 4) ONYX HD liquid metal

	<b>Mixing ratio:</b>	
	ONYX HD liquid metal	100% by vol.
	HYDROMIX	60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP, 1.5 bar
	<b>Spraycoats:</b>	1, fading out in the surrounding area
Starting from the transition area (panel to be repaired – adjacent panel), apply the basecoat by fading out into both directions.		


# Process Information

## Blend-in repair


### R-M ONYX HD – Porsche chrome blue / silver liquid metal




#### 5) ONYX HD liquid metal

	<b>Mixing ratio:</b> ONYX HD liquid metal      100% by vol. HYDROMIX                              60% by vol.
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP, 2.0 bar <b>Spraycoats:</b> 1 <b>Flash-off:</b> until matt Apply a full spraycoat that is not too wet to the panel to be repaired to achieve coverage and to match the colour.


#### 6) ONYX HD liquid metal

	<b>Mixing ratio:</b> ONYX HD liquid metal      100% by vol. HYDROMIX                              60% by vol.
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP, 0.8 – 1.5 bar <b>Spraycoats:</b> ½ coat, fading out into the surrounding area To match the colour, blend into both directions starting from the transition area (panel to be repaired – adjacent panel).

#### 7) ONYX HD liquid metal

	<b>Mixing ratio:</b> ONYX HD liquid metal      100% by vol. HYDROMIX                              60% by vol.
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP, 2.0 bar <b>Spraycoats:</b> ½ The first half coat helps to create a uniform colour effect.

#### 8) ONYX HD liquid metal

	<b>Mixing ratio:</b> ONYX HD liquid metal      100% by vol. HYDROMIX                              60% by vol.
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP, 0.8 – 1.5 bar <b>Spraycoats:</b> ½ coat, fading out into the surrounding area To match the colour, blend into both directions starting from the transition area (panel to be repaired – adjacent panel).




# Process Information


Blend-in repair

R-M ONYX HD – Porsche chrome blue / silver liquid metal

## 9) ONYX HD liquid metal

	<b>Mixing ratio:</b>	<b>ONYX HD liquid metal</b> 100% by vol.
		<b>HYDROMIX</b> 60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP, 2.0 bar
	<b>Spraycoats:</b>	½ coat, fading out into the surrounding area
		Apply another half coat to the panel to be repaired and lightly blend into the adjacent panel.

## 10) SUPREMELUX CP

	<b>Mixing ratio:</b>	<b>SUPREMELUX CP</b> 300% by vol.
		<b>H 420</b> 100% by vol.
		<b>SC 820</b> 100% by vol.
	<b>Spraygun:</b>	1.3 – 1.5 mm HVLP, 2.0 – 2.5 bar
	<b>Spraycoats:</b>	1 coat stopping at the edge and then 1 full coat
	<b>Drying:</b>	30 min. at 60°C