

## BLEND'ART

### Blend-in repair with ONYX HD, fading out on the adjacent panel

#### A 2.3

#### Process description

BLEND'ART is a universally suitable system of three processes, providing solutions for all types of blend-in repairs. This process for blend-in repairs on the panel being repaired using ONYX HD has been developed for professional refinish centers. The goal is to reliably achieve invisible repairs for all shades of the color range.

#### Substrates

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

#### Products required

- PK 1000 / PK 2000
- ONYX HD
- ONYX EASY BLENDER A 2520
- HYDROMIX
- RAPIDCLEAR C 2570

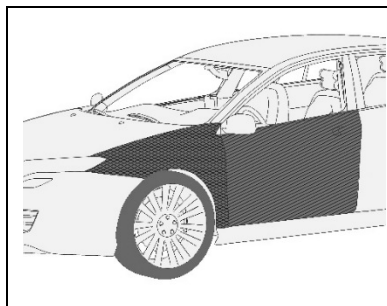
#### Safety instructions

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.

#### Pre-treatment



- 1) Filler sanding  
Degrease with PK 1000.  
Sand with P400 / P500 and then with P1000 to remove filler overspray from the surrounding area.
- 2) Sanding of ONYX HD blending area  
Sand with P1000 / P2000.  
Degrease with PK 2000.

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.mppaint.com](http://www.mppaint.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.

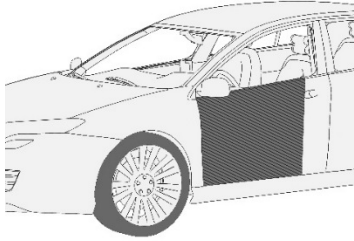
R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 03/2016

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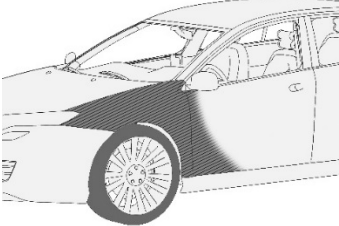
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#### 1) ONYX EASY BLENDER A 2520

	<b>Mixing ratio:</b>	ONYX EASY BLENDER A 2520 HYDROMIX/ HYDROMIX SLOW	100% by vol. 60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	2.0 bar	
	<b>Application:</b>	1 full, wet coat on the adjacent panel.	
	<b>Flash-off:</b>	No flash-off! It has to be wet during the whole blending process. At higher temperatures, it can also be applied after the first coat of ONYX HD.	

#### 2) First coat of ONYX HD

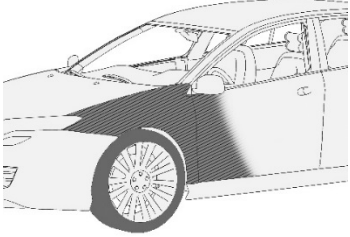
	<b>Mixing ratio:</b>	ONYX HD HYDROMIX / HYDROMIX SLOW	100% by vol. 60% by vol.
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Pressure:</b>	2.0 bar	
	<b>Application:</b>	1 full spraycoat on the repaired panel fading out to the adjacent panel (~ 2cm)	
	<b>Flash-off:</b>	Flash off the area coated with ONYX HD by using the ventury system	

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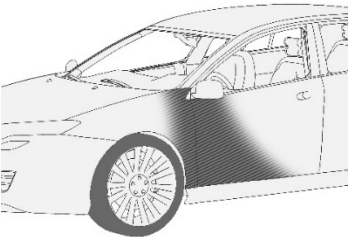
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#### 3) Second coat of ONYX HD

	<p><b>Pressure:</b> 2.0 bar</p> <p><b>Application:</b> 1 normal spray coat on the repaired panel fading out to the adjacent panel (~ 5cm)</p> <p><b>Flash-off:</b> no flash off</p>
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#### 3a) Blending of transition area on adjacent panel (only for light and sensitive colors needed)

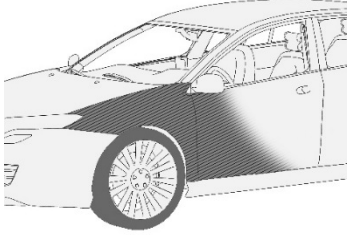
	<p><b>Mixing ratio:</b></p> <table><tr><td>ONYX HD + HYDROMIX (RFU)</td><td>100% by vol.</td></tr><tr><td>ONYX EASY BLENDER A 2520 + HYDROMIX (RFU)</td><td>100% by vol.</td></tr></table> <p><b>Pressure:</b> 1.0 – 1.5 bar</p> <p><b>Application:</b> 2 – 3 thin coats</p> <p><b>Flash-off:</b> Flash off repaired and adjacent panel until matt by using the ventury system</p>	ONYX HD + HYDROMIX (RFU)	100% by vol.	ONYX EASY BLENDER A 2520 + HYDROMIX (RFU)	100% by vol.
ONYX HD + HYDROMIX (RFU)	100% by vol.				
ONYX EASY BLENDER A 2520 + HYDROMIX (RFU)	100% by vol.				

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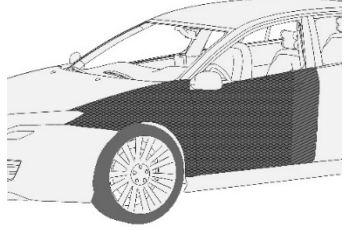
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#### 4) ONYX HD effect coat

	<b>Mixing ratio:</b>	<b>ONYX HD</b> <b>HYDROMIX</b> or mixture from Step 3a	100% by vol. 60% by vol.
	<b>Pressure:</b>	1.5 – 2.0 bar	
	<b>Application:</b>	1 thin spraycoat to match the effect on the panel being repaired and fade out on the adjacent panel.	
	<b>Flash-off:</b>	Flash off until mat.	

#### 5) RAPIDCLEAR C 2570

	<b>Mixing ratio:</b>	<b>RAPIDCLEAR C 2570*</b> H 2550 R 2200	300% by vol. 100% by vol. 100% by vol.
		* Option CHRONOLUX CP	
	<b>Spraygun:</b>	1.4 – 1.5 mm HVLP	
	<b>Application:</b>	1 thin and 1 full spraycoat, overlapping.	
	<b>Flash-off:</b>	not necessary	
<b>Drying:</b>	10 min at 60°C		