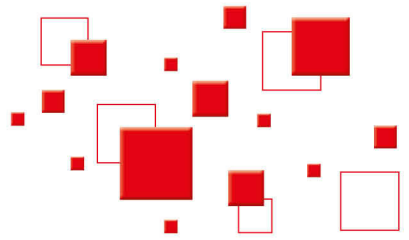


Process Information

Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2)

B 3.5



Process description

This system describes the Blending in on the adjacent panel with ONYX HD tri-coat colors with translucent Step 2 (like e. g. Mazda 41V / 46V or Renault NNP Rouge Flamme). With all translucent colors there is the need to verify the number of spray coats required for each color match and for each vehicle. Therefore, and due to differences in application techniques we recommend applying different numbers of spray coats of Step 2 (translucent coat) on test panels coated with Step 1.

This process provides paint material and time saving advantages:

- Easier and safer blending process
- Do not use ONYX EASY BLENDER A 2520.

Recommendation: Please check the color first on test panels before applying to the vehicle.

Please refer to the following Blending Process

Properties

In principle, panel repairs with translucent ONYX HD tri-coat colors are possible. 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 panel, depending on the damage. This procedure can be considerably more efficient and economical than time-consuming color matching.

Remarks

- 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).
- By brief increase of temperature in combined spray booths or by intermediate drying at 40°C in the oven after the final coat the surface properties can be optimised .
- An increasing basecoat thickness needs more flash off time.

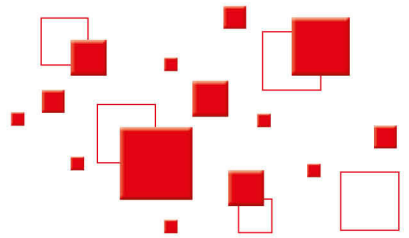
Final sanding of the filler surfacer with orbital sander, not coarser than P500, and not finer than P1000.

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.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.

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Process Information



Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2)

B 3.5

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
- HYDROMIX
- RAPIDCLEAR C 2570

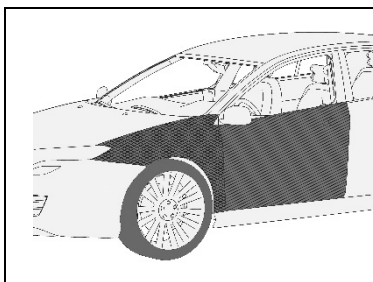
Safety instructions

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 of the adjacent panel



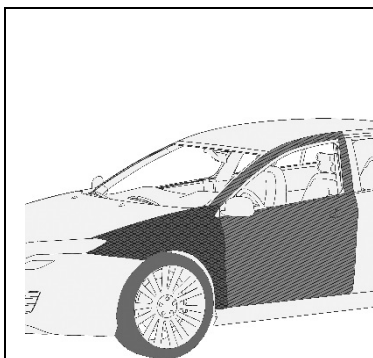
Degrease with **PK 1000**.

Sanding with foam pad P1000 – P1200.

Degrease with **PK 2000**.

Mask the adjacent panel if necessary.

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



Masking: Mask the adjacent panel

Mixing ratio: **ONYX HD Step 1** 100% by vol.
HYDROMIX 60% by vol.

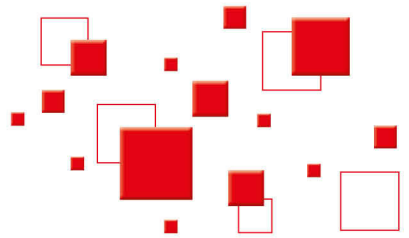
Spray gun: 1.4 – 1.5 mm HVLP

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 Step 1 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. ONYX EASY BLENDER A 2520 is not needed for this process.

Process Information



Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2)

B 3.5

2.1) Refinishing of the blend transition area into the adjacent panel Step 1

	Mixing ratio:	ONYX HD 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 Step 1 has dried, use tack rag on the blended panel to remove any loose overspray.		

2.2) Refinishing of the transition area [optional]

	Mixing ratio:		
	Mixture A	HB 100	100% by vol.
		HYDROMIX	60% by vol.
	Mixture B	HB 100 RFU	100% by vol.
		ONYX HD Step 1 RFU	30% by vol.
	Spray gun:	1.4 – 1.5 mm HVLP	
Pressure:	1.0 – 1.5 bar		
Application:	2 – 3 spray coats		
Flash-off:	Flash off until mat		
Notes:	For some colours it can be helpful to blend smoother into the transition area. This optional step can be used for that. For a smoother transition, 2 – 3 coats should be sprayed from the outside to the inside. Loose overspray should again be removed by a tack rag when dry.		

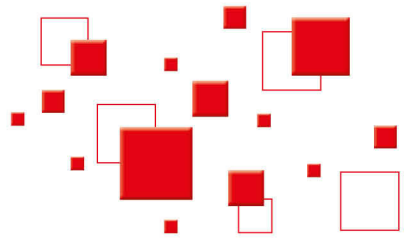
3) Refinishing of the new panel / the panel to be repaired and of the adjacent panel Step 2

	Mixing ratio:	ONYX HD Step 2	100% by vol.
		HYDROMIX	60% by vol.
	Spray gun:	1.4 – 1.5 mm HVLP	
	Pressure:	2.0 bar on the repaired panel. 1.5 bar on blending zone	
	Application:	1 - 2 + ½ spray coats to match the effect	
	Flash-off:	Flash off until mat	
Notes:	Fade out and overlap each spray coat into the adjacent panel. Reduce pressure when blending into the adjacent panel. 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.		

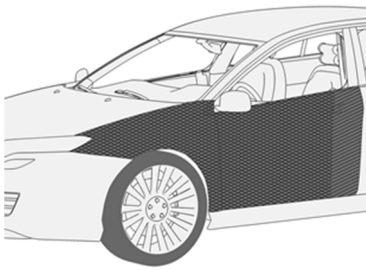


Process Information

Blending in on the adjacent panel with R-M ONYX HD
tri-coat colors (translucent step 2)
B 3.5



4) RAPIDCLEAR C 2570

	Mixing ratio:	RAPIDCLEAR C 2570* H 2500, H 2520, H 2550 R 2200	300% by vol. 100% by vol. 100% by vol.
	Spray gun:	1.3 – 1.4	
	Application:	1½ spray coats	
	Flash-off:	not necessary	
	Drying:	15 min at 60°C	