

# Process Information



## eSense process

### Process description

In the production process a combination of fossil (crude-oil based) and renewable ingredients are used. These ingredients can be separated into volumes of products that are based on fossil and biobased. The biobased volumes are now marketed under the label "eSense" for R-Mt. The "eSense" product offer for R-M consists out of six products. The formulation is identical with the already existing "fossil-based" part of the production. By the use of renewable instead of fossil material, a reduction of the CO<sub>2</sub> emission is achieved."

### Substrates

- Automotive OEM finishes, fully cured and solvent-resistant

### Products required

- PK 700 / PK 1000 / PK2000
- STOP QUICK B 2445E eSense
- LIGHT FILLER GREY P2530E eSense
- ONYX HD Basecoat
- RAPIDCLEAR C 2570 E eSense




### 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

	Degreasing PK 1000
	Sanding P80 – P150      Sand damaged areas to the bare metal
	Degreasing PK 1000
	Please note: Alternatively, you may use PK 700.

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### Body Filler

	<b>STOP QUICK B 2445E eSense Hardener</b>	100 g 3 g	
	<b>Time</b> 4 min.	<b>Temperature increase</b> 20°C / min.	<b>Max. surface temperature</b> 80°C
	Alternative: <b>Time</b> 20 – 30 min	<b>Temperature</b>	
	Coarse sanding P80 / P150	Fine sanding P240 / P320	
	Clean PK2000		

### Primerfiller

	<b>LIGHT FILLER GREY P 2530E eSense</b>	100% by vol.	
	<b>HVLP gravity-feed spraygun</b> <b>Compliant gravity-feed spraygun</b>	1.1 mm 1.1 mm	0.7 bar at the nozzle 2.0 bar
	Spray coats Film thickness If higher film thicknesses are necessary, a second layer LIGHT FILLER GREY P 2530E eSense can be applied with intermediate sanding after having dried the first layer. LIGHT FILLER GREY P 2530E eSense appears transparent and should not be applied to achieve hiding power.	<b>Primer surfacer for metal</b> ½ + 1 max. 120 µm	<b>Primer surfacer for plastics</b> ½ + 1 max. 80 µm
	Flash off at 20°C When applying higher film builds a longer intermediate flash-off and a flash-off before drying is recommended.	20 s between spray coats	
	UV drying (shortwave UV-A > 6 mW/cm²)	5 min.	

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### Basecoat

	Stir ONYX HD mixing bases on the mixing machine twice a day for 15 minutes		
	<b>ONYX HD basecoat</b>	100% by vol.	depending on colour
	<b>HYDROMIX</b>	60% by vol.	60 g
	Mix intensively immediately after weighing. Strain before application. Attention: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat.		
	<b>HVLP gravity-feed spraygun</b>	1.4 – 1.5 mm	0.7 bar at the nozzle
	Spray coats:	<b>Solid colors</b>	<b>Metallic or pearl-effect colors</b>
	Film thickness:	2 – 3	1 or 2 + 1 coat to match the effect
		20 – 25 µm	12 – 15 µm
	Flash off until mat between spray coats and before clearcoat application		
	Alternative:		
	<b>Time</b>	<b>Temperature increase</b>	<b>Max. surface temperature</b>
	4 min.	15°C / min.	60°C

### Clear

	<b>RAPIDCLEAR C 2570E eSense</b>	300% by vol.	
	<b>H 2550E eSense</b>	100% by vol.	
	<b>AIRFLASH A 2140E eSense/ SPEEDFLASH S A 2120E eSense</b>	100% by vol.	
	<b>HVLP gravity-feed spraygun</b>	1.3 – 1.5 mm	2.0 bar
	Spray coats:	½ + 1	
	Film thickness:	40 – 50 µm	
	<b>Time</b>	<b>Temperature increase</b>	<b>Max. surface temperature</b>
	10 min.	15°C / min.	60°C
	Alternative:		
	<b>Time</b>	<b>Temperature</b>	
	10 min	60°C	