

ONYX HD

HB 004

Variant ONYX ACTIVATOR

Application:

- For special applications recommended by car manufactures, the usage of ONYX HD ACTIVATOR could be necessary in ONYX HD basecoats.
- Additive for solid-colour ONYX HD and for use in solid-color basecoats applied as a ground coat in ONYX HD 3-layer systems to improve tape resistance and hardness.

Remarks:

New mixing bases must be stirred manually before use and additionally for 15 minutes in the mixing machine. Stir all products stored in the mixing machine twice a day for 15 minutes.

Storage temperature

5-45 °C



Cleaning

Clean with PK 2000. Sand with P400 (sanding filler and well-cured or solvent-resistant old paintwork). Clean with PK 2000.

Safety advice:

2004/42/IIIB(d)(420)419: The EU limit value for this product (product category: IIB.d) in ready-for-use form is max 420 grams of VOC per liter. The VOC content of this product is 419 g/l.

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

The products are suitable for professional use only.

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.





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	Mixing Ratio	100 Parts by volume	ONYX HD mixing bases (acc. to mixing formula)* Mix the ONYX HD basecoat to the formula and stir it carefully. *Mixing formulas that contain HB 100, HYDROMIX, MIXINGBASE W cannot be used with ONYX HD ACTIVATOR.
	Hardener	5 Parts by volume	A 2210 Waterborne basecoat activator Add ONYX HD ACTIVATOR and stir again carefully.
	Thinner	80 Parts by volume	HB 034 HYDROMIX slow Add HYDROMIX slow and stir carefully. Strain before application.
	Spray viscosity at 20°C	DIN 4: 18-25 s ISO 4: 42-68 s	Potlife at 20°C 2 h

	 HVLP spray gun	 Compliant gravity-feed spray gun
Nozzle pressure	bar	0.7
Nozzle size		1.4-1.5
Number of spray coats		2 – 3 For some colors, one further spraycoat may be necessary.
Flash off at 20°C	min	Flash off until mat after each spraycoat.
Film thickness	µm	20-25

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Drying



Drying at 20°C 15 min

Drying at 60°C 10 min

Drying Remark The drying time depends on climatic conditions and equipment used.

Remark Apply one of the recommended R-M clears. ONYX HD basecoats may be over coated with the same product after the indicated drying times.

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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