Technical Information

ONYX HD

Waterborne basecoat line

Product Category: C 3.1

Fields of use
Mixing system for waterborne basecoats used in automotive refinishing.

Additional Information
Mixing formulas for the whole range of (solid, metallic and pearl-effect) colors needed in automotive refinishing are available.
When using white colors with high spray viscosity the mixing ratio can be changed to 100 : 80.

Technical characteristics

<table>
<thead>
<tr>
<th>Solids content 15 % ± 2</th>
<th>Density 0.850 – 0.950 g/cm³</th>
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</thead>
<tbody>
<tr>
<td>Storage temperature</td>
<td>Shelf life</td>
</tr>
<tr>
<td>min. 5°C to max. 45°C</td>
<td>60 months (tinting base)</td>
</tr>
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</table>

Application
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.
At rather high temperatures or when refinishing large surfaces, it is possible to replace HB002 by HB004 slow, while replacing HYDROMIX adjusting base by HYDROMIX slow at the same time.
Attention: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat.
When using HB004 slow in the mixing formula, HYDROMIX slow must also be used.
Use of ONYX HD ACTIVATOR, if recommended by car manufactures, see Technical Information.

Substrate / Pre-treatment / Cleaning
Clean with PK 2000.
Sand with P400 (sanding filler or well-cured, solvent-resistant old paintwork).
Clean with PK 2000.
Alternative: apply to R-M wet-on-wet filler or sealer
## Technical Information

### ONYX HD

<table>
<thead>
<tr>
<th>ONYX HD mixing bases</th>
<th>100% by vol.</th>
<th>depending on color</th>
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<tbody>
<tr>
<td>HYDROMIX</td>
<td>60% by vol.</td>
<td>60 g</td>
</tr>
</tbody>
</table>

**Viscosity at 20°C:**
- ISO 4 cup: 42 to 68 seconds
- DIN 4 cup: 18 to 25 seconds

**Potlife:** ONYX HD colors mixed to formula: 6 months in a sealed plastic vessel. ONYX HD ready for use: 1 week in a sealed plastic vessel.

**HVLP gravity-feed spraygun**
- 1.4 – 1.5 mm
- 0.7 bar at the nozzle

**Spraycoats:**
- Solid colors
  - 2 – 3
  - 20 – 25 µm
- Metallic or pearl-effect colors
  - 1 or 2 + 1 coat to match the effect
  - 12 – 15 µm

**Film thickness:**
- Solid colors 2 – 3
- Metallic or pearl-effect colors 1 or 2 + 1 coat to match the effect

**Flash off until mat after each spraycoat.**

**Drying at 20°C:**
- approx. 15 min.
- Possibility to speed up the process with additional air flow

**Drying at 45°C:**
- approx. 10 min. + cooling

**Drying IR**
- 1st spraycoat, flash off at room temperature until mat.
- 2nd spraycoat, at 40 – 50°C (max. 60°C) surface temperature to mat surface + cooling. Harmonizing coat, flash off at room temperature until mat.

### Finishing

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

### Safety instructions

2004/42/EC(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...