

Technical Information

ONYX HD Factory pack with HB002

Product Category: **C 3.1**

Waterborne basecoatline

Fields of use

Mixture ONYX HD Factory pack with HB002 (e. g. with the colour TOY 8Y0). Observe the mixing ratio on the label!

Additional Information

When using white colors with high spray viscosity the mixing ratio can be changed to 100 : 80.

Technical characteristics

Solids content 15 % ± 2	Density 0.850 – 0.950 g/cm ³
Storage temperature min. 5°C to max. 45°C	Shelf life 6 months (tinting base)

Application

Attention: Do not insert a filter in the spraygun when applying a metallic or pearl-effect basecoat.

Substrate / Pre-treatment / Cleaning

Clean with PK 2000.

Sand with P400 (sanding filler or well-cured, solvent-resistant old paintwork).

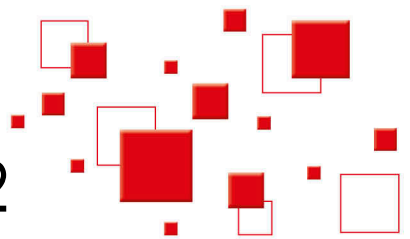
Clean with PK 2000.







Alternative: apply to R-M wet-on-wet filler or sealer

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	ONYX HD mixing bases with HB002 HYDROMIX	100% by vol. 60% by vol.
	Viscosity at 20°C: ISO 4 cup: DIN 4 cup:	42 to 68 seconds 18 to 25 seconds
	Potlife: 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: Film thickness: Flash off until mat after each spraycoat.	Solid colors Metallic or pearl-effect colors 2 – 3 1 or 2 + 1 coat to match the effect 20 – 25 µm 12 – 15 µm
	Drying at 20°C: Drying at 45°C:	approx. 15 min. Possibility to speed up the process with additional air flow 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/II B(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