

Technical Information

ONYX HD Factory pack without HB002

Waterborne basecoatline

Product Category: **C 3.1**

Fields of use

Mixture ONYX HD Factory pack without HB002 (e. g. with colour TOY 8Y0).

Additional Information

Observe the mixing ratio on the label!

Technical characteristics

Solids content -	Density -
Storage temperature min. 5°C to max. 45°C	Shelf life 24 months (tinting base)

Application

Attention: Do not insert a filter into 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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	65% by weight 35% by weight	HB002 ONYX HD Factory pack	100% by vol. 60% by vol.	depending on color 60 g
	Viscosity at 20°C:			
	ISO 4 cup:	42 to 68 seconds		
	DIN 4 cup:	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:	Solid colors	Metallic or pearl-effect colors	
	Film thickness:	2 – 3	1 or 2 + 1 coat to match the effect	
	Flash off until mat after each spraycoat.	20 – 25 µm	12 – 15 µm	
	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/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