

ONYX HD

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Variant ONYX ACTIVATOR

Application:

- For special applications recommended by car manufacturers or for use under C 2A40 clear coat, the usage of ONYX ACTIVATOR would be necessary in ONYX HD basecoat.
- Additive for 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.
- If clear coat will be applied after the base coat application, please ensure this is done within 4 hours.

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 R-M waterborne cleaner (base-/topcoat). Sand with P400 (sanding filler and well-cured or solvent-resistant old paintwork). Clean with R-M waterborne cleaner (base-/topcoat).

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 % by volume	<p>ONYX HD mixing bases (acc. to mixing formula)* Mix the ONYX HD basecoat to the formula and stir it carefully. *Mixing formulas that contain MIXINGBASE W cannot be used with ONYX ACTIVATOR.</p>
	Hardener	5 % by volume	<p>A 2210 Waterborne basecoat activator Add ONYX ACTIVATOR and stir again carefully.</p>
	Thinner	80 % by volume	<p>HB 032 HYDROMIX Add HYDROMIX and stir carefully. Strain before application. When using HB 004 in the mixing formula, HB 034 HYDROMIX SLOW must also be used.</p>
	Potlife at 20°C	30 min	

		HVLP spray gun		Compliant gravity-feed spray gun
Nozzle pressure	0.7 bar			
Nozzle size	1.4-1.5			
Number of spray coats	1 or 2 (spray to cover) plus ½ to match effect. For some colors, one further spray coat may be necessary.			
Flash off at 20°C	Flash off until mat after each spray coat.			
Film thickness	20-25 µm			

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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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