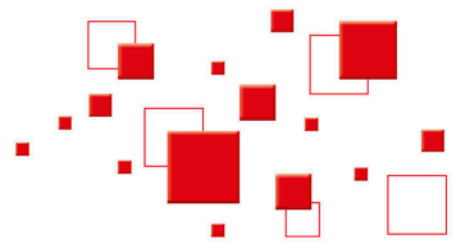


Process Information

Tri-coat colours ONYX HD



Process description

Refinishing process for ONYX HD tri-coat colours, to improve hiding power and curing properties. The process is based on the filler blending concept. The filler in the matching grey shade replaces the first basecoat layer.

2. Properties

The additional basecoat layer in ONYX HD tri-coat application processes may lead to (significantly) longer drying times. Consequently, the coating can become more sensitive to stone chipping and, in extreme cases, it may cause wrinkling (deformation of the paint film) on pressure marks.

This may be caused by:

- higher basecoat thickness
- insufficient flash-off times

How to avoid that:

- Stick to the recommended flash-off times
- Flash off after each spray coat until the surface is completely mat.
- Flash-off times can be reduced by additional ventilation with blow equipment (e.g. Dry Jet), brief increase of temperature in combined spray booths or by intermediate drying at 60°C in the oven.
- An increasing basecoat thickness needs more flash-off time.

Note:

For certain colours it may be necessary to apply more basecoat to achieve the required hiding power. To make up for this limitation as good as possible, we recommend to use a coloured ground coat (step I) for colours that do not have sufficient hiding power. This ground coat colour can be defined directly when the respective basecoat colours are formulated and is assigned to the mixing formula as step I.

This step 1 can either be an ONYX HD basecoat mixing formula or a grey shade mixed from PERFECTFILLER WHITE and BLACK or EXTRASEALER WHITE and BLACK:

We specifically recommend our filler mixtures because of the following advantages:

- Better drying properties
- Lower risk of applying too much basecoat
- Lower materials costs
- Better hiding power

3. Additional information

In order to avoid the application of too much basecoat, you should apply a filler coat in a matching grey shade for certain tri-coat colours that require two colouring basecoat layers.

Please also observe the instructions given in the Technical Data Sheets of the products.

Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.mppaint.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

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Process Information

Tri-coat colours ONYX HD



Substrates

- Automotive OEM finishes








Products required

- PK 1000 / PK 2000
- PERFECTFILLER WHITE /BLACK
- ONYX HD basecoat
- ONYX HD ACTIVATOR
- CRYSTALCLEAR CP

Pre-treatment

	Degreasing PK 1000
	Degreasing PK 2000

Primer

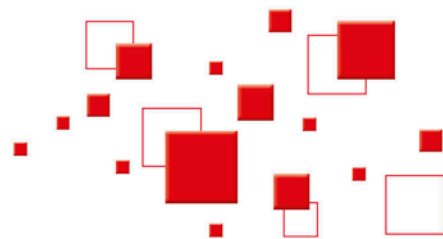
	Stir well before use		
	PERFECTFILLER WHITE / BLACK	100% by vol.	100 g
	D 70 / D 80	25% by vol.	15 g
	FR 500	25% by vol.	13 g
	HVLP gravity-feed spray gun	1.7 – 1.9 mm	0.7 bar at the nozzle
	Compliant gravity-feed spray gun	1.6 – 1.8 mm	2.0 – 2.5 bar
	Spray coats:	2	
	Film thickness:	50 – 70 µm	
	60°C	20 min.	
	(short wave)	9 min.	
	Dry: use P400		
	Degreasing PK 2000		

Note:

The filler blending concept consists of one white and one black filler that can be mixed with each other in order to achieve many different grey shades.





Process Information

Tri-coat colours ONYX HD







Alternative: When using solid colours as the first colouring basecoat layer, you may add ONYX HD ACTIVATOR to improve curing. Always check colour accuracy when using ONYX HD ACTIVATOR. Please consult the technical data sheets of ONYX HD ACTIVATOR and ONYX HD for further details.

Basecoat (Step 1)

	Stir ONYX HD mixing bases on the mixing machine twice a day for 15 minutes		
	ONYX HD basecoat 100% by vol. 100 ml ONYX HD ACTIVATOR 5% by vol. 5 g HYDROMIX 80% by vol. 80 g Mix intensively immediately after weighing. Strain before application.		
	HVLV gravity-feed spray gun	1.4 – 1.5 mm	2.0 bar
	Spray coats: Film thickness:	2 – 3 12 – 20 µm	
	Flash off for about 5 min. between spray coats and about 15 min. before basecoat application (step II)		

Note: The flash-off time can be reduced by using blow equipment or by briefly increasing the temperature to up to 50°C. ONYX HD ACTIVATOR cannot be used in mixing formulas containing CRYSTAL BASE CB 86R, CB 760 or CB 83R. Please note that ONYX HD ACTIVATOR reduces the potlife of ONYX HD to 2 hours.

Basecoat (Step 2)

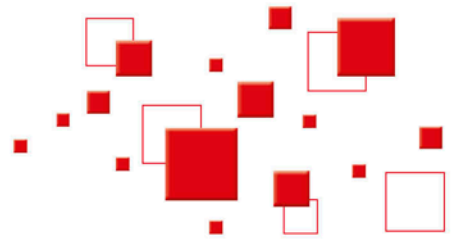
	Stir ONYX HD mixing bases on the mixing machine twice a day for 15 minutes		
	ONYX HD basecoat 100% by vol. depending on colour ONYX HD ACTIVATOR 60% by vol. 60 g Mix intensively immediately after weighing. Strain before application.		
	HVLV gravity-feed spray gun	1.4 – 1.5 mm	2.0 bar
	Spray coats: Film thickness:	Solid 2 20 – 25 µm	Metallic 2 ½ 12 – 15 µm
	Flash off until mat between spray coats and before clearcoat application		

Note: The flash-off time can be reduced by using blow equipment or by briefly increasing the temperature to up to 50°C.







Process Information

Tri-coat colours ONYX HD



Clear

	CRYSTALCLEAR CP H 420 SC 850	300% by vol. 100% by vol. 100% by vol.	100 g 37 g 29 g
	HVLP gravity-feed spray gun	1.3 – 1.5 mm	2.0 bar
	Spray coats: Film thickness:	2 40 – 60 µm	
	60°C	30 min.	

Note: The product can be applied to vertical surfaces in ½ + 1 spray coats without intermediate flash-off.