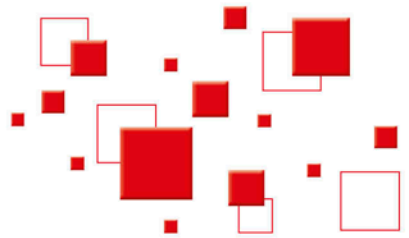


System Information



Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2)

Mazda 41V

This repair process is only valid with the below mentioned service mixing formulas.

Process description

In principle, panel repairs with translucent ONYX HD basecoats are possible. Therefore, it is in general not necessary to respray adjacent body parts. But when color differences beyond allowable limits are to be expected, the more appropriate method to balance color differences may be to blend into the damaged area and/or the adjacent part. This procedure can be considerably more efficient and economical than time-consuming color matching.

Substrates

- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Refinishes, fully cured and solvent-resistant

Substrates

- 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 40°C in the oven.
- An increasing basecoat thickness needs more flash-off time.

Products required

- PK 1000 / PK 2000
- ONYX HD Mazda 41V
- HYDROMIX
- RAPIDCLEAR C 2570

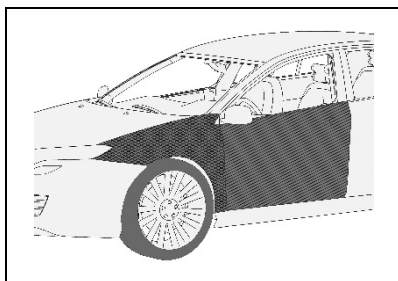
Safety instructions

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.

1) Pre-treatment



Degrease with PK 1000.

Sanding with foam pad P1000 – P2000.

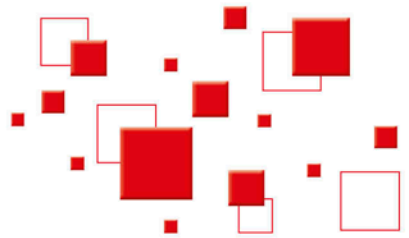
Degrease with PK 2000.

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.mpaint.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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System Information

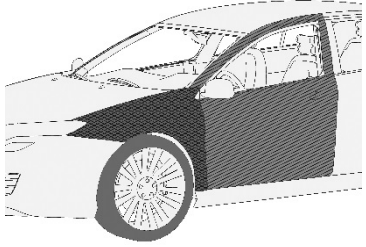


Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2)

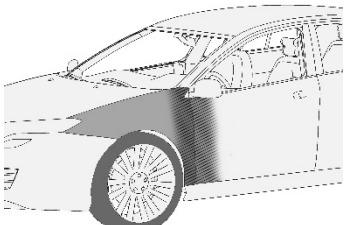
Mazda 41V

This repair process is only valid with the below mentioned service mixing formulas.

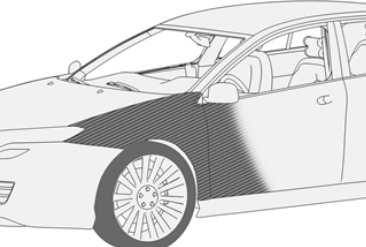
2) Refinishing of the panel to be repaired / the new panel Step 1

	Masking: Mask the adjacent panel
	Mixing ratio: ONYX HD Mazda 41V Step 1 100% by vol. HYDROMIX 60% by vol.
Spray gun: 1.4 – 1.5 mm HVLP	
Pressure: 2.0 bar	
Application: 2 (spray to cover) + ½ coat to match the effect	
Notes: Viscosity 20 – 21 sec DIN4 / 23°C Demask the adjacent panel, after the last spray coat has dried. Using Step 1 fade out and overlap each spray coat into the adjacent panel. Keep the blend small and keep the edge transition soft and gradual.	

2.1) Refinishing of the transition area to the adjacent panel Step 1

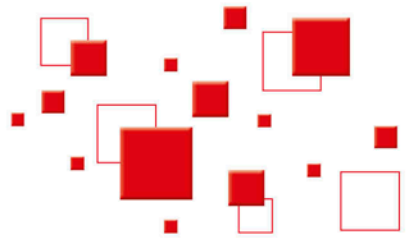
	Mixing ratio: ONYX HD Mazda 41V Step 1 100% by vol. HYDROMIX 60% by vol.
	Spray gun: 1.4 – 1.5 mm HVLP
Pressure: 1.0 – 1.5 bar	
Application: 1 - 2 spray coats on fading out on the adjacent panel	
Flash-off: Flash off until mat	
Notes: After Step 1 has dried, use tack rack on the blended panel to remove any loose over spray.	

3) Refinishing of the panel to be repaired / the new panel and of the adjacent panel Step 2

	Mixing ratio: ONYX HD Mazda 41V Step 2 100% by vol. HYDROMIX 60% by vol.
	Spray gun: 1.4 – 1.5 mm HVLP
Pressure: 2.0 bar on repaired panel. 1.5 bar on blending area	
Application: 1 – 2 spray coats fading out on the adjacent panel (overlapping).	
Flash-off: Flash off until mat	



System Information



Blending in on the adjacent panel with R-M ONYX HD tri-coat colors (translucent step 2)

Mazda 41V

This repair process is only valid with the below mentioned service mixing formulas.

4) RAPIDCLEAR C 2570

	Mixing ratio:	RAPIDCLEAR C 2570*	300% by vol.
		H 2550	100% by vol.
		R 2200	100% by vol.
		* Option CHRONOLUX CP	
	Spray gun:	1.3 HVLP	
Application:	2 spray coats.		
Flash-off:	not necessary		
Drying:	30 min at 60°C		

Mazda 41V mixing formulas:

The two Service mixing formulas are recommended to be used in conjunction with this blending process.

With all translucent colors there is the need to verify the amounts of spray coats needed for each color match for each vehicle. Therefore, and due to differences in application techniques we recommend to apply different amounts of spray coats of Step 2 (translucent coat) to test panels of Step 1 to match the process and color of the vehicle to be repaired.

Service Formula 1

Mazda 41V	Step 1
HB002	66,67
HB861	14,86
HB140	10,19
HB88N	5,61
HB831W	2,66

Service Formula 2

Mazda 41V	Step 1
HB002	65,52
HB861	15,87
HB88N	12,50
HB140	3,26
HB831W	2,85

Mazda 41V	Step 2
HB002	11,87
HB100	80,28
HB80T	3,47
HB832	3,00
HB88N	1,27
CB63L	0,10

Mazda 41V	Step 2
HB002	11,87
HB100	80,28
HB80T	3,47
HB832	3,00
HB88N	1,27
CB63L	0,10

Remark: Service formula 1 is lighter in color to Service formula 2.

Recommendation: Service formula 1 usually needs 2½ coats of Step 2; Service formula 2 required based on our experiences 1½ coats of Step 2.

Please check color and application first on test panels before applying to the vehicle.

