

Process Information

Paint system ONYX HD Nissan GT-R

Process description

R-M process ONYX HD. Special paint system for the Nissan GT-R, colour KAB

Substrates

- original OEM paint Nissan

Required products

- PK 700 / PK 900 / PK 1000 / PK 2000
- EUROXY CP
- Ground coat
- Blending clear
- ONYX HD KAB colour
- SUPREME LUX CP

Safety instructions

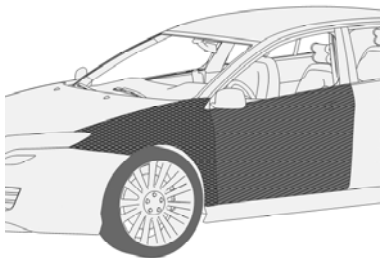
It cannot be ruled out that these products contain particles < 0.1 µm.

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.

Edge to edge repair

1.1 Application of surfacer / Pre-treatment

	<p>Clean with PK 700 or PK 900. Sand (steel with P80, aluminium with P150-P180, galvanised steel and old paintwork with P240). Clean with PK 1000.</p> <p>Apply EUROXY CP according to EUROXY CP technical information. Apply EUROXY CP for excellent durability performance.</p> <ol style="list-style-type: none">1) Sand surface with a dual action sander P500.2) Sand with dual action sander P600 to cover the sanding mark of P500.3) Sand with dual action sander P800 to cover the sanding mark of P600.4) Sand with dual action sander P1000 to cover the sanding mark of P800.5) Degrease with PK 2000
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Note:

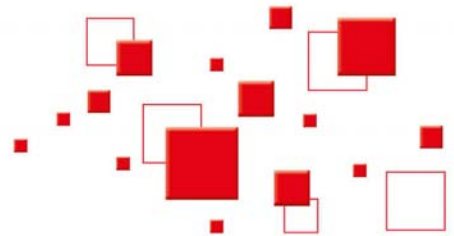
- If the rough surface of primer filler remains, it will result in a scaly appearance
- If the sand-scratch marks of P500, P600 or P800 remains, it will affect the surface quality by mottling or telegraphing the sand-scratches
- Use guide coat prior to sanding to avoid over sanding.
- Use guide coat prior to sanding, then sand until it disappears in order to confirm that the sanding mark of the prior process does not remain.
- Use soft inter face pad for orbital sander.

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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1.2 Application of ground coat

	Formulation of ground coat:		
	HB 002	} 100% by vol.	46.5 g
	HB 990		48.9 g
	HB 250		4.7 g
	ONYX HD ACTIVATOR	5% by vol.	5.0 g
	HYDROMIX	80% by vol.	80.0 g
	Spray gun:	1.5 mm HVLP	
	Application:	1 wet	
	Pressure:	2.0 bar	
	Flash-off:	15 min. at 20°C	
<p>For ground coat, apply wet coat to avoid generating peel on the surface. Allow the total dry time to expire in order to avoid creating a scaly surface.</p>			

1.3 Application of blending clear

	Formulation of blending clear:		
	HB 100		100% by vol.
	HYDROMIX		60% by vol.
	Spray gun:	1.5 mm HVLP	
	Application:	1	
	Pressure:	2.0 bar	
	Drying:	15 min. at 60°C	

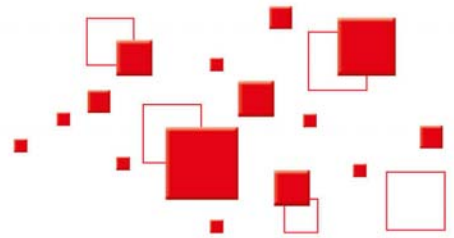
1.4 Application of KAB colour

	Formulation of KAB:		
	KAB colour in ONYX HD is only provided as factory package.		
	KAB-Factory pack includes HB 002		100% by vol.
	HYDROMIX		60% by vol.
	(Stir immediately after having added adjusting base)		
	Spray gun:	1.5 mm HVLP	
Application:	5 – 6 flash off until mat		
Pressure:	2.0 bar		
Drying:	15 min. at 60°C		
<p>For KAB base coat, apply medium coat. Apply 2-3 mist coats after hiding has been achieved. Allow the total dry time to expire in order to avoid creating a scaly surface.</p>			

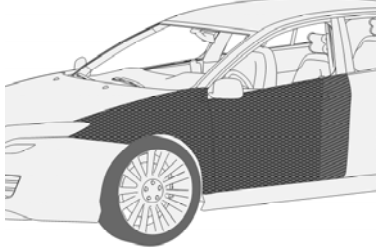


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1.5 Application of SUPREMELUX CP

	Mixing ratio:	SUPREMELUX CP	300% by vol.
		H 420	100% by vol.
		SC 820	100% by vol.
	Spray gun:	1.4 – 1.5 mm HVLP	
	Application:	1 – 2	
	Drying:	30 min. at 60°C	
	On a vertical surface, apply 1 normal coat followed by a wet coat		
	On a horizontal surface, apply 2 coats to ensure a smooth surface.		
	The drying time is 60°C (surface temperature) 30min.		

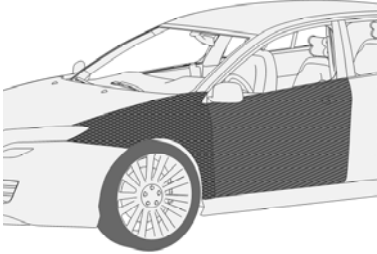


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Spot-Repair

2.1 Application of surface / Pre-treatment

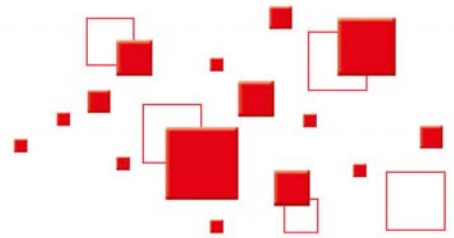
	<p>Clean with PK 700 or PK 900. Sand (steel with P80, aluminium with P150-P180, galvanised steel and old paintwork with P240). Clean with PK 1000.</p> <p>Apply EUROXY CP according to EUROXY CP technical information. Apply EUROXY CP for excellent durability performance.</p> <ol style="list-style-type: none">1) Sand surfacer with a dual action sander P500.2) Sand with dual action sander P600 to cover the sanding mark of P500.3) Sand with dual action sander P800 to cover the sanding mark of P600.4) Sand with dual action sander P1000 to cover the sanding mark of P800.5) Degrease with PK 2000
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Note:

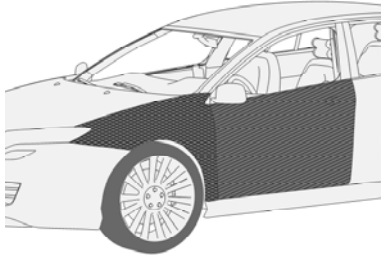
- If the rough surface of surfacer remains, it will result in a scaly appearance.
- If the sand-scratch marks of P500, P600 or P800 remains, it will affect the surface quality by mottling or telegraphing the sand-scratches.
- Use guide coat prior to sanding to avoid over sanding.
- Use guide coat prior to sanding, then sand until it disappears in order to confirm that the sanding mark of the prior process does not remain.
- Use soft inter face pad for orbital sander

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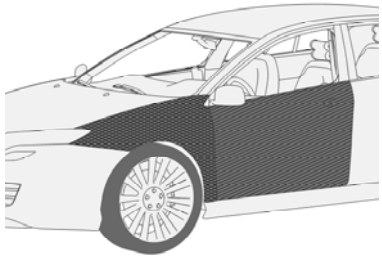
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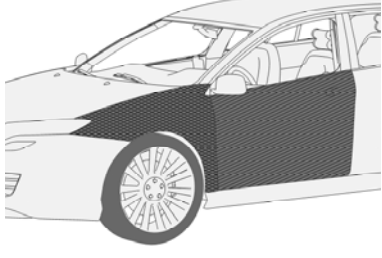
2.2 Application of blending clear (1)

	Formulation blending clear:	
	HB 100	100% by vol.
	HYDROMIX	60% by vol.
	Spray gun:	1.5 mm HVLP
	Application:	1 wet
	Pressure:	2.0 bar
	Drying:	15 min. at 60°C
	For blending clear, apply wet coat.	
	After dry time has expired allow part to cool to room temperature before applying KAB base coat	

2.3 Application of KAB colour (1)

	Formulation of KAB:	
	KAB colour in ONYX HD is only provided as factory package.	
	KAB-Factory pack includes HB 002	100% by vol.
	HYDROMIX	60% by vol.
	(Stir immediately after having added adjusting base)	
	Spray gun:	1.5 mm HVLP
	Application:	3 – 4 wet, flash off until mat
	Pressure:	1.0 – 1.5 bar
	For KAB base coat, apply medium coat.	
	Apply 2-3 mist coats after hiding has been achieved.	
	Allow the total dry time to expire in order to avoid creating a scaly surface.	

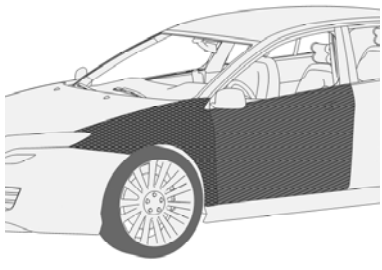
2.4 Application of blending clear (2)

	Formulation blending clear:	
	HB 100	100% by vol.
	HYDROMIX	60% by vol.
	Spray gun:	1.5 mm HVLP
	Application:	1 wet
	Pressure:	2.0 bar
	Flash-off:	/
	Before the mist coat of KAB base coat, apply a wet coat of blending clear on the blending area to avoid overspray mist.	

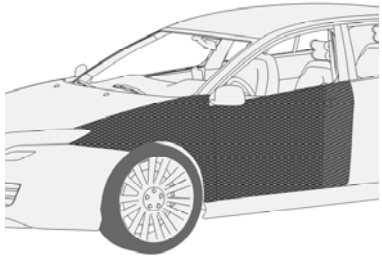
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2.5 Application of KAB colour (2)

	Formulation of KAB : KAB colour in ONYX HD is only provided as factory package. KAB Factory pack includes HB 002 HYDROMIX (Stir immediately after having added adjusting base)
	Spray gun: 1.5 mm HVLP Application: 2 – 3 flash off until mat Pressure: 0.8 – 1.5 bar Drying: 15 min. at 60°C

2.6 Application of SUPREMELUX CP

	Mixing ratio: SUPREMELUX CP 300% by vol. H 420 100% by vol. SC 820 100% by vol.
	Spray gun: 1.4 – 1.5 mm HVLP Application: 2 Drying: 30 min. at 60°C On a vertical surface, apply 1 normal coat followed by a wet coat On a horizontal surface, apply 2 coats to ensure a smooth surface. The drying time is 60°C (surface temperature) 30min.