

Process Information

R-M ONYX HD - Porsche chrome blue / silver liquid metal

Process description

Special refinishing system for Porsche 918 Spyder in chrome blue and silver (liquid metal).

Substrates

- OEM finishes
- R-M fillers and R-M primer fillers
- Sand existing substrate carefully to avoid any sanding scratches! Be sure to use only the recommended grit sizes!




Products required

- PK 1000 / PK 2000
- STOP UNI
- ONYX HD Basecoat liquid metal
- DIRECTFILLER
- ONYX BLENDER PRO
- SUPREMELUX CP

Safety instructions

The products are suitable for professional use only.
It cannot be ruled out that this product contains particles < 0.1 µm.
Comply with present safety instructions and personal protective equipment.

Pre-treatment

	Clean with PK 1000.
	Sand very carefully; use only recommended grit sizes. Sand with P80 - P1500, depending on the damaged area.
	Clean with PK 1000.




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R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 05/2013







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Putty

	STOP UNI STOP Hardener	100 g 3 g
	20°C	20-30 min.
	Coarse sand with P80, P150; use a guide coat. Fine sand with P240, P320; then clean with PK 2000.	
	Or alternatively: STOP FLEX	

Primer filler

	Stir well before use.		
	DIRECTFILLER	100% by vol.	100 g
	D 701	20% by vol.	16 g
	FR 500	20% by vol.	14 g
	HVLP gravity-feed spraygun Compliant gravity-feed gun	1.7 - 1.9 mm 1.6 - 1.8 mm	0.7 bar at the nozzle 2.0 - 2.5 bar
	Number of spraycoats: Film thickness:	½ + 1 50 – 70 µm	
	60°C	35 min.	
	Dry sand with P400.		
	Clean with PK 1000.		
	Or alternatively: EXTRASEALER GREY		




Ground coat

	ONYX BLENDER PRO HYDROMIX	100% by vol. 60% by vol.	
	HVLP gravity-feed spraygun	1.4 - 1.5 mm	0.7 bar at the nozzle
	Number of spraycoats:	2, flash off until matt.	





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Basecoat

	<p>Stir the ONYX HD mixing bases on the mixing machine twice a day for 15 minutes.</p> <p>ONYX HD Basecoat liquid metal 100% by vol. depending on colour HYDROMIX 60% by vol. 60 g</p> <p>Mix intensively immediately after weighing. Strain before application. Please note: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat.</p>
	<p>HVLP gravity-feed spraygun 1.4 - 1.5 mm 0.7 bar at the nozzle</p>
	<p>Metallic or pearl-effect colours Number of spraycoats: 2 + 2x ½ coat to match the effect Flash off until matt after each spraycoat.</p>

Clearcoat

	<p>Stir well before use.</p> <p>SUPREMELUX CP 300% by vol. 100 g H 420 100% by vol. 37 g SC 820 100% by vol. 29 g</p>
	<p>HVLP gravity-feed spraygun 1.3 - 1.5 mm 0.7 bar at the nozzle</p>
	<p>Number of spraycoats: 2</p>
	<p>60°C 30 min.</p>
	<p>Please refer to blend-in process for chrome-blue / silver liquid metal for detailed information on the blend-in repair.</p>