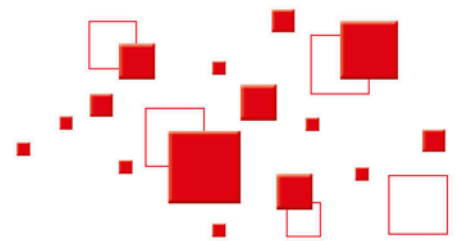


Process Information

Fast refinishing process with SPEEDFLASH



Process description

Process for fast refinishing by adding SPEEDFLASH and SPEEDFLASH S to R-M products.

By replacing the thinner in the standard mixing ratio with SPEEDFLASH or SPEEDFLASH S, you can shorten the drying time. That leads to

- a reduction of throughput times,
- lower energy costs,
- shorter process times,
- improved tape resistance and
- improved curing performance enabling you to continue working (such as polishing) earlier.

We recommend this refinishing method especially for vertical surfaces.

Please note that the use of SPEEDFLASH / SPEEDFLASH S shortens the potlife.

Substrates

- Automotive OEM finishes, fully cured and solvent-resistant

Products required

- PK 700 / PK 1000 / PK 2000
- STOP UNI
- STOP EXTRA FIN
- STARFILL
- PERFECTFILLER WHITE / GREY / BLACK
- ONYX HD Basecoat
- CHRONOLUX CP / DIAMONTCLEAR 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.

Pre-treatment

	Degreasing PK 1000
	Sand P80 – P150 Sand damaged areas down to the bare metal
	Degreasing PK 1000
	Please note: Alternatively, you may use PK 700.

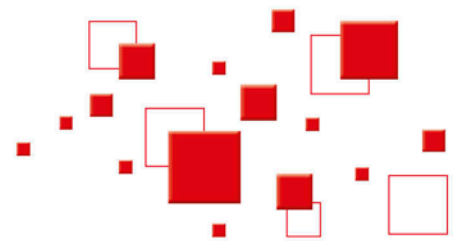
The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any 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.

R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 02/2013









Process Information





Fast refinishing process with SPEEDFLASH



Body Filler

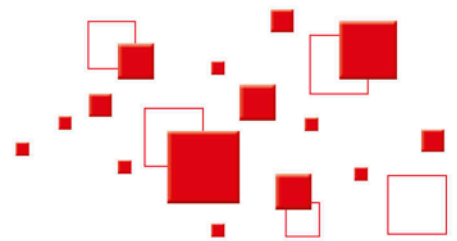
	STOP UNI STOP Hardener	100 g 3 g
	Coats:	2 – 3
	(short wave) or alternative	4 min.
	20°C	20 min.
	Coarse sanding Fine sanding	P80 / P150 P240 / P320
	Clean PK 2000	
	Please note: Depending on the damaged area, you can also use STOP EXTRA FIN.	

Primer








	STARFILL D 30 Activator FR 500	100% by vol. 100% by vol. 30% by vol.
	HVLP gravity-feed spray gun	1.3 – 1.7 mm 0.7 bar at the nozzle
	Spray coats: Film thickness:	1 5 – 10 µm
	20°C	10 – 15 min.
	Please note: After a flash-off time of > 24 h it is necessary to de-nib the surface.	

Process Information





Fast refinishing process with SPEEDFLASH



Primer Filler

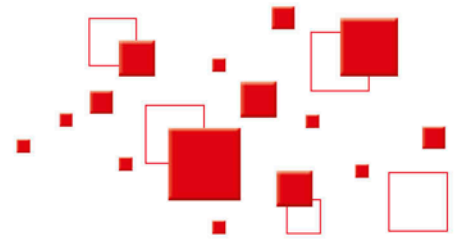
	PERFECTFILLER WHITE / GREY / BLACK D 70 / D 80 SPEEDFLASH / SPEEDFLASH S	100% by vol. 25% by vol. 25% by vol.	
	HVLP gravity-feed spray gun	1.7 – 1.9 mm	0.7 bar at the nozzle
	Spray coats: Film thickness:	2 50 – 70 µm	
	60°C	SPEEDFLASH 15 min.	SPEEDFLASH S 10 min.
	or	6 min.	4 min.
	P400		
	Clean PK 2000		

Basecoat





	ONYX HD HYDROMIX	100% by vol. 60% by vol.	
	HVLP gravity-feed spray gun	1.4 – 1.5 mm	0.7 bar at the nozzle
	Spray coats: Film thickness:	2 ½ 12 – 15 µm	
	Flash off until mat between spray coats and before clearcoat application		
	Please note: The flash-off time can be reduced by using blow equipment or by briefly increasing the temperature to up to 45°C.		

Process Information

Fast refinishing process with SPEEDFLASH



Clear

	<p>Stir well before use</p> <table border="0"> <tr> <td>CHRONOLUX CP</td> <td>300% by vol.</td> </tr> <tr> <td>H 420</td> <td>100% by vol.</td> </tr> <tr> <td>SPEEDFLASH</td> <td>100% by vol.</td> </tr> <tr> <td colspan="2"> </td> </tr> <tr> <td>DIAMONTCLEAR CP</td> <td>300% by vol.</td> </tr> <tr> <td>H 420</td> <td>100% by vol.</td> </tr> <tr> <td>SPEEDFLASH S</td> <td>100 % by vol.</td> </tr> </table>	CHRONOLUX CP	300% by vol.	H 420	100% by vol.	SPEEDFLASH	100% by vol.			DIAMONTCLEAR CP	300% by vol.	H 420	100% by vol.	SPEEDFLASH S	100 % by vol.
CHRONOLUX CP	300% by vol.														
H 420	100% by vol.														
SPEEDFLASH	100% by vol.														
DIAMONTCLEAR CP	300% by vol.														
H 420	100% by vol.														
SPEEDFLASH S	100 % by vol.														
	<table border="0"> <tr> <td>HVLP gravity-feed spray gun</td> <td>1.3 – 1.5 mm</td> <td>0.7 bar at the nozzle</td> </tr> </table>	HVLP gravity-feed spray gun	1.3 – 1.5 mm	0.7 bar at the nozzle											
HVLP gravity-feed spray gun	1.3 – 1.5 mm	0.7 bar at the nozzle													
	<table border="0"> <tr> <td>Spray coats:</td> <td>½ + 1</td> </tr> <tr> <td>Film thickness:</td> <td>40 – 50 µm</td> </tr> </table>	Spray coats:	½ + 1	Film thickness:	40 – 50 µm										
Spray coats:	½ + 1														
Film thickness:	40 – 50 µm														
	<table border="0"> <tr> <td>60°C</td> <td>CHRONOLUX CP</td> <td>10 min.</td> </tr> <tr> <td>60°C</td> <td>DIAMONTCLEAR CP</td> <td>15 min.</td> </tr> </table>	60°C	CHRONOLUX CP	10 min.	60°C	DIAMONTCLEAR CP	15 min.								
60°C	CHRONOLUX CP	10 min.													
60°C	DIAMONTCLEAR CP	15 min.													
	<p>Please note: Apply clear to vertical surfaces only</p>														