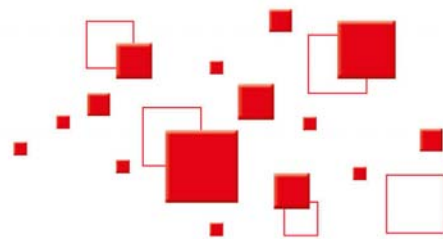


Matt Shade concept

B 6



Application

R-M Matt Shade Concept was designed to achieve equal mat surfaces on ONYX HD basecoat with the clears SILICATOP und SATINTOP. With the mixture of both mat clears gloss levels of 12 up to 65 units at an angle of 60 could be achieved.

Background:

The gloss level of the OEM and repair finishes may occasionally vary on one and the same car. This may lead to additional work in the refinishing process.

Possible reasons:

- Gloss level deviations or variations within the original coating (original mat finishes applied at the carmakers' production lines, for example, show gloss level differences between vertically and horizontally coated panels)
- Carmakers use different paint products with different gloss levels
- In the refinishing process, insufficient flash-off times after the spraycoats and too high or too low film builds may lead to different gloss levels of the mat clearcoat. Other reasons may be that the recommended basecoat film build was not respected or that the spraycoats applied did not overlap correctly.

Measures:

- In order to avoid the above described different gloss levels, R-M recommends to respect the specified basecoat and clearcoat film builds and to flash off the clearcoat sufficiently after each spraycoat, i.e. until the surface is completely (Flash off until mat between spraycoats and before stoving. After the first spraycoat, allow to flash off for 10 – 15 min, after the second spraycoat for 15 – 20 min.) Do not flash off for more than 25 minutes after each spraycoat.
- R-M recommends the R-M Matt Shade concept swatch to determine the gloss level of the vehicle to be repaired.
- These specifications refer to finishes for solid-color and metallic basecoats. Light and pure silver colors can increase the gloss level. Therefore, we recommend producing a spray-out sample before each refinishing job.
- SILICATOP and SATINTOP can be used without FLEX Additive for plastic parts!
- Mat surfaces cannot be polished in order to remove dust inclusions.
- Matt clears cannot be faded out. Therefore application of whole panel is necessary.

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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Technical Information

Matt Shade concept

B 6

Additional Information:

It is imperative to avoid:

- Polishing or sanding of clearcoat surface
- usage of wax or polish
- usage of "scratching" sponges (e.g. household sponge, rag, etc.)
- usage of any aggressive agents (cleaner, oil, fat, etc.)

Cleaning instruction:

- do not use car wash sides
- never wash a car with mat clear in direct sunlight
- Not adherent particles (dust, leaves, etc.) should be removed with compressed air before washing the car
- Soak any remaining dead insects, bird droppings etc. with plenty of water and remove them with a high-pressure cleaner.
- The vehicle should preferably be washed by hand, using a soft sponge, a neutral cleaning agent and plenty of water.
- The washed car should be preferably dried with compressed air or by wiping with a soft leather rag

Substrates

- R-M fillers (R-M PREP'ART System)
- Automotive OEM finishes, fully cured and solvent-resistant
- Refinishes, fully cured and solvent-resistant

Products required

- PK 2000
- ONYX HD
- SATINTOP / SILICATOP / CRYSTALCLEAR CP
- H 420
- SC 850

Safety instructions

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

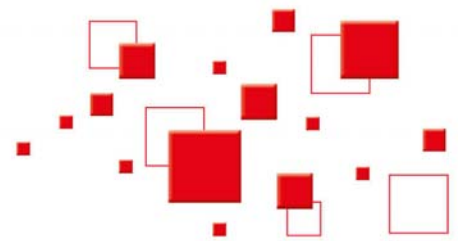
The products are suitable for professional use only.

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



Matt Shade concept






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Pre treatment

	Cleaning PK 2000
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
Applying the basecoat

	<p>Stir the ONYX HD mixing bases on the mixing machine twice a day for 15 minutes.</p> <table border="0"> <tr> <td>ONYX HD mixing bases</td> <td>100% by vol.</td> <td>depending on color</td> </tr> <tr> <td>HYDROMIX</td> <td>60% by vol.</td> <td>60 g</td> </tr> </table> <p>Mix intensively immediately after weighing. Strain before application. Attention: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat. When using HB004 slow in the mixing formula, HYDROMIX slow must also be used.</p>	ONYX HD mixing bases	100% by vol.	depending on color	HYDROMIX	60% by vol.	60 g	
ONYX HD mixing bases	100% by vol.	depending on color						
HYDROMIX	60% by vol.	60 g						
	42 to 68 seconds ISO 4 cup at 20°C							
	<p>Potlife: ONYX HD colours mixed to formula: 6 months in a sealed plastic vessel. ONYX HD ready for use: 1 week in a sealed plastic vessel.</p>							
	<table border="0"> <tr> <td>HVLP gravity-feed spraygun</td> <td>1.4 – 1.5 mm</td> <td>0.7 bar at the nozzle</td> </tr> </table>	HVLP gravity-feed spraygun	1.4 – 1.5 mm	0.7 bar at the nozzle				
HVLP gravity-feed spraygun	1.4 – 1.5 mm	0.7 bar at the nozzle						
	<table border="0"> <tr> <td rowspan="3"> Spraycoats: Film thickness: Flash off until mat after each spraycoat </td> <td>Solid colors</td> <td>Metallic-or pearl-effect colors</td> </tr> <tr> <td>2 – 3</td> <td>1 or 2 + 1 coat to match the effect</td> </tr> <tr> <td>20 – 25 µm</td> <td>12 – 15 µm</td> </tr> </table>	Spraycoats: Film thickness: Flash off until mat after each spraycoat	Solid colors	Metallic-or pearl-effect colors	2 – 3	1 or 2 + 1 coat to match the effect	20 – 25 µm	12 – 15 µm
Spraycoats: Film thickness: Flash off until mat after each spraycoat	Solid colors		Metallic-or pearl-effect colors					
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	20 – 25 µm	12 – 15 µm						
	<table border="0"> <tr> <td>Drying at 20°C</td> <td>approx. 15 min.</td> </tr> <tr> <td>Drying at 60°C</td> <td>Possibility to speed up the process with additional air flow approx. 10 min. + cooling</td> </tr> </table>	Drying at 20°C	approx. 15 min.	Drying at 60°C	Possibility to speed up the process with additional air flow approx. 10 min. + cooling			
Drying at 20°C	approx. 15 min.							
Drying at 60°C	Possibility to speed up the process with additional air flow approx. 10 min. + cooling							

Matt Shade concept

B 6

Applying the clear

	Mixing ratio of R-M clears to achieve a gloss level of 12 – 65 units when using hardener H 420:							
	Mixing ratio % by vol.	Gloss level +/- 2 at an angle of 60°						
		12	20	25	30	40	53	65
	SILICATOP	100	60	40	20	/	/	/
	SATINTOP	/	40	60	80	100	90	80
	CRYSTALCLEAR CP	/	/	/	/	/	10	20
Stir well before use								
Clear coat mixture		100 g						
H 420		23 g						
SC 850		36 g						
	HVLP gravity-feed spraygun	1.3 – 1.5 mm			0.7 bar at the nozzle			
	Compliant gravity-feed spraygun	1.3 – 1.4 mm			2.0 – 2.5 bar			
	Spraycoats:	2						
	Film thickness:	40 – 50 µm						
Flash off until mat between spraycoats and before stoving. After the first spraycoat, allow to flash off for 10 – 15 min, after the second spraycoat for 15 – 20 min.) Do not flash off for more than 25 minutes after each spraycoat.								
	Drying at 60°C	30 min.						