

# Technical Information

## ONYX HD



Waterborne basecoat line

Product Category: **C 3.1**

### Fields of use

Mixing system for waterborne basecoats used in automotive refinishing.

### Additional Information

Mixing formulas for the whole range of (solid, metallic and pearl-effect) colors needed in automotive refinishing are available.

When using white colors with high spray viscosity the mixing ratio can be changed to 100 : 80.

### Technical characteristics

Solids content 15 % ± 2	Density 0.850 – 0.950 g/cm <sup>3</sup>
Storage temperature min. 5°C to max. 45°C	Shelf life 60 months (tinting base)

### Application

New mixing bases must be stirred manually before use and additionally for 15 minutes in the mixing machine. Stir all products stored in the mixing machine twice a day for 15 minutes.

At rather high temperatures or when refinishing large surfaces, it is possible to replace HB002 by HB004 slow, while replacing HYDROMIX adjusting base by HYDROMIX slow at the same time.

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.

Use of ONYX HD ACTIVATOR, if recommended by car manufactures, see Technical Information.

### Substrate / Pre-treatment / Cleaning

Clean with PK 2000.

Sand with P400 (sanding filler or well-cured, solvent-resistant old paintwork).

Clean with PK 2000.

Alternative: apply to R-M wet-on-wet filler or sealer

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](http://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.

R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 12/2017



## ONYX HD



	<b>ONYX HD mixing bases</b> HYDROMIX	100% by vol. 60% by vol.	depending on color 60 g
	<b>Viscosity at 20°C:</b> ISO 4 cup: DIN 4 cup:	42 to 68 seconds 18 to 25 seconds	
	<b>Potlife:</b> ONYX HD colors mixed to formula: 6 months in a sealed plastic vessel. ONYX HD ready for use: 1 week in a sealed plastic vessel.		
	<b>HVLP gravity-feed spraygun</b>	1.4 – 1.5 mm	0.7 bar at the nozzle
	Spraycoats: Film thickness: Flash off until mat after each spraycoat.	<b>Solid colors</b> 2 – 3 20 – 25 µm	<b>Metallic or pearl-effect colors</b> 1 or 2 + 1 coat to match the effect 12 – 15 µm
	Drying at 20°C:  Drying at 45°C:	approx. 15 min. Possibility to speed up the process with additional air flow approx. 10 min. + cooling	
	Drying IR	1st spraycoat, flash off at room temperature until mat. 2nd spraycoat, at 40 – 50°C (max. 60°C) surface temperature to mat surface + cooling. Harmonizing coat, flash off at room temperature until mat.	

### Finishing

Apply one of the recommended R-M clears. ONYX HD basecoats may be over coated with the same product after the indicated drying times.

### Safety instructions

2004/42/IIIB(d)(420)419: The EU limit value for this product (product category: IIB.d) in ready-for-use form is max 420 grams of VOC per liter. The VOC content of this product is 419 g/l.

It cannot be ruled out that this product contains particles < 0.1 µm.

The products are suitable for professional use only.

For the use of this product please adhere to the actual safety recommendations and the personal protective equipment