

ONYX HD

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Waterborne basecoat line

Application:

Mixing system for waterborne basecoats used in automotive refinishing.

Key Features:

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

Remarks:

- 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, 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.
- Use of ONYX HD ACTIVATOR, if recommended by car manufactures, see Technical Information.
- Potlife: 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.
- When using white colors with high spray viscosity the mixing ratio can be changed to 100 : 80.

Storage temperature

5-45 °C

**Cleaning**

Clean with R-M waterborne cleaner (base-/topcoat). Sand with P400 (sanding filler or well-cured, solvent-resistant old paintwork). Clean with R-M waterborne cleaner (base-/topcoat). Alternative: apply to R-M wet-on-wet filler or sealer

Safety advice:

2004/42/IIB(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. 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.rmpaint.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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**Mixing Ratio**

100 % by volume

ONYX HD mixing bases (acc. to mixing formula)

**Thinner**

60 % by volume

HB 032 HYDROMIX

(Stir IMMEDIATELY after having added adjusting base.)

When using HB 004 in the mixing formula, HB 034 HYDROMIX SLOW must also be used.

**HVLP spray gun****Compliant gravity-feed spray gun****Nozzle pressure**

0.7 bar

Nozzle size

1.3-1.5

Number of spray coats

Solid colors (2 – 3 / 20 – 25 µm)

Metallic or pearl-effect colors (1 or 2 + 1 coat to match the effect / 12 - 15 µm)

Flash off at 20°C

Flash off until mat after each spray coat.

Application Remark

For more detailed information about spray guns and nozzle sizes see the approved spray gun list in Info R-M.

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Drying



Drying at 20°C

15 min
Possibility to speed up the process with additional air flow.

Drying at 40°C

10 min

Remark

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

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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