



ONYX HD

Waterborne basecoat line

C 3.1

Product description

Mixing system for waterborne basecoats used in automotive refinishing. Mixing formulas for the whole range of (solid, metallic and pearl-effect) colours needed in automotive refinishing are available.

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.

2004/42/II B(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 litre. The VOC content of this product is 419 g/l.

Technical characteristics

Shelf life: 60 months (tinting base) Density: 0.899 g/cm³ Theoretical spreading rate: m²/l at 1 µm
 Colour: Solids content: approx. 15% by weight








Pre-treatment

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.

|  <p>Mixing ratio</p> | <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 (vol.)</td> <td>depending on colour</td> </tr> <tr> <td>HYDROMIX</td> <td>60 (vol.)</td> <td>60 g</td> </tr> </table> <p>Mix intensively immediately after weighing. Strain before application.</p> <p>Attention: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat.</p> | ONYX HD mixing bases | 100 (vol.) | depending on colour | HYDROMIX | 60 (vol.) | 60 g | | | |
|---|---|---|----------------------|---|-----------------|-----------|-------------------------------------|-----------------|------------|------------|
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| HYDROMIX | 60 (vol.) | 60 g | | | | | | | | |
|  <p>Spray viscosity</p>  <p>Potlife</p> | <p>When using HB004 slow in the mixing formula, HYDROMIX slow must also be used. 42 to 68 seconds ISO 4 cup at 20°C</p> <p>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> | | | | | | | | | |
|  <p>Sprayguns</p> | <p>HVLP gravity-feed spraygun 1.4 – 1.5 mm 0.7 bar at the nozzle</p> | | | | | | | | | |
|  <p>Application</p> | <table border="0"> <thead> <tr> <th></th> <th>Solid colours</th> <th>Metallic or pearl-effect colours</th> </tr> </thead> <tbody> <tr> <td>Spraycoats:</td> <td>2 – 3</td> <td>1 or 2 + 1 coat to match the effect</td> </tr> <tr> <td>Film thickness:</td> <td>20 – 25 µm</td> <td>12 – 15 µm</td> </tr> </tbody> </table> <p>Flash off until mat after each spraycoat.</p> | | Solid colours | Metallic or pearl-effect colours | Spraycoats: | 2 – 3 | 1 or 2 + 1 coat to match the effect | Film thickness: | 20 – 25 µm | 12 – 15 µm |
| | Solid colours | Metallic or pearl-effect colours | | | | | | | | |
| Spraycoats: | 2 – 3 | 1 or 2 + 1 coat to match the effect | | | | | | | | |
| Film thickness: | 20 – 25 µm | 12 – 15 µm | | | | | | | | |
|  <p>Drying</p> | <p>Drying at 20°C: approx. 15 min. Possibility to speed up the process with additional air flow</p> <p>Drying at 60°C: approx. 10 min. + cooling</p> | | | | | | | | | |
|  <p>Infrared arch</p> | <p>Drying IR</p> <p>1st spraycoat, flash off at room temperature until mat. 2nd spraycoat, at 40-50°C (max 70°C) surface temperature to mat surface + cooling. Harmonising coat, flash off at room temperature until mat.</p> | | | | | | | | | |
| <p>Further treatment</p> | <p>Apply one of the recommended R-M clears. ONYX HD basecoats may be overcoated with the same product after the indicated drying times.</p> | | | | | | | | | |

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules. The products are suitable for professional use only.

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