

# ONYX HD

## ONYX HD

### 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.

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**Storage temperature** 5-45 °C

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#### 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

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#### Safety advice:

**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

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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**

1.4-1.5

**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.

**Drying**



**Drying at 20°C**

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

**Drying at 40°C**

10 min

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**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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