

UNO HD 420 gms/liter (3.5 lbs/gal) VOC

Application Procedures for Complete Repair



Products	UNO HD Colors 812 Fisheye Eliminator 851 Prep and Wash 909 Final Wipe AM900 Aero-Max Pre-Kleano AM960 Spot Blender DF21 Flex Agent DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener SCM103 Mixing Clear RMR15 Low VOC Reducer VR Series Reducers
Cleaning	See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.
Pretreatments	See Undercoat Section
Color	Mix color with SCM103 as per the intermix formula.
Mixing Ratio	3:1:1 3 parts UNO HD Color 1 part DH42, DH44, DH46 or DH47 1 part VR Reducer or RMR15
Application	Apply 1 medium wet coat. 5 minutes flash between coats. Apply a 2nd full wet coat. Bake immediately after final coat for best results.
Drying	20°C/68°F 2 hours tack free; 30 to 60 minutes to dust free 60°C/140°F 30 minutes
Sanding/ Polishing	Wet Sand - 1200 grit or finer
Notes	Intermix formula must contain SCM103. Mix 3 parts UNO HD color to 1 part (by volume) SCM103.



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Complete Repair Technical Data



Characteristics

R-M UNO HD is a high solids single stage, two component, topcoat system. This formulation is based on a unique acrylic/polyurethane technology that offers high solids and high performance. UNO HD comes in a wide range of **solid** colors that can assure success in completes, panel replacements and spot repairs. The ease of mix as well as application are just the beginning. Expect excellent flow and leveling, exceptional hiding and mirror like gloss. Superior hardness and chemical resistance completes the package.

Technical Data

Viscosity	15-17 sec. #4 Ford cup
Fluid Tip (HE Gravity)	1.3-1.5 mm
Fluid Tip (HVLP Gravity)	1.3-1.5 mm
Air Pressure (HVLP/HE)	8-10 psi at air cap
Number of Coats	2 coats
Thickness	2.0-3.0 mils
Pot Life	5 hours
Coverage	370 sq ft/gal @ 2.0 mils
VOC as Applied	420 gms/ltr max. (3.5 lbs/gal)

Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Do use R-M 812 Fisheye Eliminator if necessary, add 1/4 to 1/2 cap full per quart or gun cup.
- Do use UNO HD color mixture within 5 hours for best results.
- Do use AM960 Spot Blender to melt in UNO HD Color when completing a color blend.
- Do measure amount of hardener and reducer - DO NOT ESTIMATE.
- Do use JET95 0.5 to 1% with DH46 or DH47 if **necessary**.
- Do shake tinting bases for 10 to 15 minutes on a paint shaker before using or placing on a mixing rack.
- Do mechanically agitate all bases at the start of the day and every 4 hours throughout the day to ensure good color matching.
- Do use DF21 Flex Agent when painting flexible parts. See Flexible Parts section of manual.

Things NOT to DO:

- Do not attempt to recoat, sand or compound until the final coat has dried a minimum of 24 hours.
- Do not use if the shop temperature is below 15°C/60°F.
- Do not use any hardeners other than DH42, DH44, DH46 or DH47 or reducers other than VR Series or RMR15.
- Do not use Jet95 in UNO HD 3.5 VOC Colors when using DH42.