

ONYX HD

Application Procedures for exterior



Products	ONYX HD Toners 851 Prep and Wash 909 Final Wipe AM900 Aero-Max Pre-Kleano BCH10 Basecoat Hardener HB002 Hydrobase HB005 Hydrobase Slow HB020 Hydromix	HB040 Hydromix Slow HB055 Onyx Blender Pro HB100 Mixing Clear All R-M Refinish Clears All R-M Refinish Undercoats
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Cleaning See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.

Pretreatments See Undercoat Section

Color Mix color with Hydrobase and HB100 as per formula.

Mixing Ratio **Without hardener**

100% ONYX HD Toner
60-80% Hydromix

It is important to follow these steps during the preparation of ONYX HD:

- Prepare the ONYX HD toner
- Stir well until uniform
- Add Hydromix
- Stir well until uniform

Strain before application.

With hardener

100% ONYX HD Toner
80% Hydromix
* 5% BCH10

It is important to follow these steps during the preparation of ONYX HD:

- Prepare the ONYX HD toner
- Stir well until uniform
- Add Hydromix
- Stir well until uniform
- Add BCH10 Basecoat Hardener
- Stir well until uniform

Strain before application.

Application 2 medium wet coats (to hiding) + 1 mist coat for metallic / effect colors
5 minutes flash between coats and before clearcoat until matte. The use of air jets will reduce flash-off time of the ONYX HD paint.

Drying **20°C/68°F** 15 minutes under ventilation

Sanding/ Polishing See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.

Notes Intermix formula **must** contain Hydrobase.

Please observe the following shelf life recommendations:

HB002 - 12 months	HB040 - 12 months
HB005 - 12 months	HB055 - 12 months
HB020 - 12 months	HB100 - 12 months

* If applying to underhood/interior part, see technical data sheet for Application procedures for undercoat/interior parts.



Characteristics

The R-M ONYX HD Waterborne is an advanced water-based topcoat that provides all the drying advantages of a solvent based product while having the environmentally safe properties of a water-base topcoat. ONYX HD uses 80% less solvent when compared to conventional basecoats and has a ready for use VOC of 3.5 lbs/gal or less. Has OEM approval and is good for multi-colors and solid colors.

Technical Data

Viscosity	21-26 sec. #4 Ford cup
Fluid Tip (HE Gravity)	1.5-1.6 mm
Fluid Tip (HVLP Gravity)	1.5-1.6 mm
Air Pressure (HVLP/HE)	8-10 psi at air cap
Number of Coats	2+ coats
Thickness	0.5-1.0 mil
Pot Life	6 months (in plastic or lined containers)
Pot Life using 5% BCH10	90 minutes
Coverage	230 sq ft/gal @ 1.0 mil
VOC as Applied	420 gms/ltr (3.5 lbs/gal)

Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Do use HB055 Onyx Blender Pro to melt in ONYX HD Color when completing a color blend.
- Do measure amount of hardener and reducer - DO NOT ESTIMATE.
- Do use ONYX HD toner mixture with hardener within 90 minutes for best results.
- Do shake tinting bases for 10 to 15 minutes on a paint shaker before 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 keep the following products from freezing: HB002 Hydrobase, HB005 Hydrobase Slow, HB020 Hydromix, HB040 Hydromix Slow, HB055 Onyx Blender Pro and HB100 Mixing Clear.
- Do refer to the ONYX HD underhood/interior parts technical data sheet for mixing instructions.
- Do use plastic or lined cans for storage of ONYX HD paint.

Things NOT to DO:

- Do not use if the shop temperature is below 15°C/60°F.
- Do not use any hardeners other than BCH10 or reducers other than HB020 Hydromix or HB040 Hydromix Slow.