



## TECHNICAL SERVICE BULLETIN

# Adjusting Onyx-HD™ for Various Application Conditions

**Number: RMBUL2189-E**

**Date: May 1, 2009**

Recently, a study was conducted by the R-M Technical Laboratory using R-M's Onyx-HD Waterborne Basecoat in hot conditions. The results have yielded the following recommendations.

### **60°F – 75°F & Humidity of 40% or higher**

Mix and apply Onyx-HD basecoat per Technical Data Sheet Specifications (100% Onyx-HD color, 60% HB020 Hydromix ).

Recommended spray guns: Tekna® HVLP 1.5mm tip & 909 air cap.

### **75°F – 85°F & Humidity of 40% or higher**

**Option 1:** Mix and apply Onyx-HD basecoat per Technical Data Sheet Specifications (100% Onyx-HD color, 60% HB020 Hydromix ).

**Option 2:** Mix Onyx-HD basecoat per color formula using HB004 (slow) (or HB005 in California) in place of HB002, then reduce with HB040 (slow). If metal temp is above 85°F reduce 60% with HB040.

Recommended spray guns: Tekna® HVLP 1.5mm tip & 909 air cap

Recommended spray pressure is 22 PSI for first two coats, then 15 PSI for effect coat.

### **85°F – 100°F or whenever Humidity 40% or lower**

Mix Onyx-HD basecoat per color formula using HB004 (or HB005) in place of HB002, then reduce with HB040. If metal temp is above 85°F reduce up to 100% with HB040.

Recommended spray guns: Tekna® HVLP 1.5mm tip & 909 air cap

Recommended spray pressure is 22 PSI for first two coats, then 15 PSI for effect coat.

**Note:** The drying of this product is dependent upon the **humidity** conditions of your shop. **Dry** conditions either during hot or cold weather will speed the drying. If the booth heat is on, the humidity will be lower than outside the booth. To slow down the drying utilize HB004 Hydrobase Slow (or HB005 in California) and HB040 Hydromix Slow.

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