



ONYX HD ACTIVATOR

Activator for waterborne basecoats

C 5

Product description

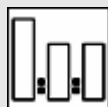





Additive for solid-colour ONYX HD basecoats to improve tape resistance and hardness.
Also suitable for use in solid-colour basecoats applied as a ground coat in ONYX HD 3-layer systems.

Technical characteristics

Shelf life:	24 months	Density:	1.080 g/cm ³	Theoretical spreading rate:	m ² /l at 1 µm
Colour:	transparent	Solids content:	78.2 % by weight		

Pre-treatment

Clean with PK 2000.
Sand with P400 (sanding filler and well-cured or solvent-resistant old paintwork).
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Alternative: apply to R-M wet-on-wet filler or sealer.

	Mixing ratio	<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 solid colour*</td> <td>100 (vol.)</td> <td>0.1 l</td> </tr> <tr> <td>ONYX HD ACTIVATOR</td> <td>5 (vol.)</td> <td>5 g</td> </tr> <tr> <td>HYDROMIX</td> <td>80 (vol.)</td> <td>80 g</td> </tr> </table> <p>Mix the ONYX HD basecoat to the formula and stir it carefully. Add ONYX HD ACTIVATOR and stir again carefully. Add HYDROMIX and stir carefully. Strain before application. * ONYX HD ACTIVATOR is unsuitable for use in mixing formulas which contain the waterborne dispersions CB760, CB86R or CB 83R.</p>	ONYX HD solid colour*	100 (vol.)	0.1 l	ONYX HD ACTIVATOR	5 (vol.)	5 g	HYDROMIX	80 (vol.)	80 g
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	Spray viscosity	42 to 68 seconds ISO 4 cup at 20°C									
	Potlife	Two hours at 20°C.									
	Sprayguns	HVLP gravity-feed spraygun 1.4 – 1.5 mm 0.7 bar at the nozzle									
	Application	<table border="0"> <tr> <td></td> <td>Solid colour or ground coat</td> </tr> <tr> <td>Spraycoats:</td> <td>2 – 3</td> </tr> <tr> <td>Film thickness:</td> <td>20 – 25 µm</td> </tr> </table> <p>For some colours, one further spraycoat may be necessary. Flash off until mat after each spraycoat.</p>		Solid colour or ground coat	Spraycoats:	2 – 3	Film thickness:	20 – 25 µm			
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	Drying	<p>The drying time depends on climatic conditions and equipment used.</p> <table border="0"> <tr> <td>Drying at 20°C:</td> <td>approx. 15 min.</td> </tr> <tr> <td>Drying at 60°C:</td> <td>approx. 10 min. + cooling</td> </tr> </table>	Drying at 20°C:	approx. 15 min.	Drying at 60°C:	approx. 10 min. + cooling					
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	Infrared drying	<table border="0"> <tr> <td>1st spraycoat:</td> <td>flash off at room temperature until mat.</td> </tr> <tr> <td>2nd spraycoat:</td> <td>at 40 – 50°C (max 70°C) surface temperature to mat surface + cooling.</td> </tr> </table>	1st spraycoat:	flash off at room temperature until mat.	2nd spraycoat:	at 40 – 50°C (max 70°C) surface temperature to mat surface + cooling.					
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	Further treatment	Apply one of the recommended R-M clears. ONYX HD basecoats may be overcoated with the same product after the indicated drying times.									

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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