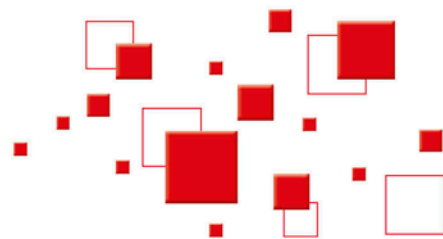


# Process Information

## Paint system Ford Electric Orange



### Process description

Paint system with improved surface hardness for ONYX HD colour shade FD 7 / Ford electric orange pearl

### Substrates

- e-coat Primer
- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Refinishes, fully cured and solvent-resistant

### Products required

- PK 700 / PK 2000
- PERFECTFILLER WHITE / GREY / BLACK
- EXTRASEALER WHITE (UNO HD CP)
- ONYX HD FD 7
- CRYSTALCLEAR CP



### Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

### Pre-treatment

	Degreasing PK 700
	Sanding P240 – P400
	Degreasing PK 2000

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at [www.mpaint.com](http://www.mpaint.com) or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.






R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 02/2013








# Process Information

## Paint system Ford Electric Orange

### Primer

	Stir well before use  <b>PERFECTFILLER GREY</b> 100% by vol. <b>D 70 / D 80</b> 25% by vol. <b>FR 500</b> 25% by vol. You may use <b>PROFILLER WHITE / GREY &amp; BLACK</b> or <b>PERFECTFILLER WHITE / BLACK</b> instead of <b>PERFECTFILLER GREY</b>
	HVLP gravity-feed spray gun 1.7 – 1.9 mm 0.7 bar at the nozzle Compliant gravity-feed spray gun 1.6 – 1.8 mm 2.0 – 2.5 bar
	Spray coats: 2 Film thickness: 50- 70 µm
	60°C 20 min.
	Dry: use P400





### Sealer

	Stir well before use  <b>EXTRASEALER WHITE*</b> 300% by vol. <b>D 80</b> 100% by vol. <b>FR 500 / SC 820 / SC 850 / SC 880</b> 100% by vol.
	HVLP gravity-feed spray gun 1.3 – 1.5 mm 0.7 bar at the nozzle Compliant gravity-feed spray gun 1.3 – 1.4 mm 2.0 – 2.5 bar
	Spray coats: 1 Film thickness: 20- 35 µm
	60°C 30 min.
	* Alternatively, EXTRASEALER WHITE could be tinted with UNO HD CP in order to reduce the contrast to ONYX HD basecoat. This provides the benefit of achieving lower film builds and a homogenous appearance without clouding of ONYX HD.
	<b>EXTRASEALER WHITE</b> 85.0 g <b>SC 07</b> 0.8 g <b>SC 82</b> 1.2 g <b>SC 17</b> 2.3 g <b>SC 62</b> 10.7 g





# Process Information

## Paint system Ford Electric Orange

### Basecoat

	ONYX HD FD 7 HYDROMIX	100% by vol. 60% by vol.	
	HVLP gravity-feed spray gun	1.4 – 1.5 mm	0.7 bar at the nozzle
	Spray coats: Film thickness:	2 ½ 15 – 20 µm max.	
	60°C	10 min.	

### Clear

	Stir well before use CRYSTALCLEAR CP H 420 SC 850 / SC820 / SC 880	300% by vol. 100% by vol. 100% by vol.	
	HVLP gravity-feed spray gun Compliant gravity-feed spray gun	1.3 – 1.5 mm 1.3 – 1.4 mm	0.7 bar at the nozzle 2.0 – 2.5 bar
	Spray coats: Film thickness:	2 40 – 60 µm	
	60°C	30 min.	