

# Process Information

## Paint system Rolls Royce bare metal

### Process description

Customer-specific paint system for Rolls Royce bare metal

### Substrates

- Galvanised steel
- Aluminium
- Steel
- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Electro-coated surfaces

### Products required

- PK 700 / PK 900 / PK 1000 / PK 2000
- STOP UNI
- EUROXY CP
- STOP FILLER II
- PERFECTFILLER WHITE / GREY / BLACK
- R-M topcoat




### 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 or PK 900
	<b>Sanding</b> P80 / P150 In order to avoid corrosion, do not sand bare steel with sanding paper that has already been used on pure magnesium and aluminium alloys.
	Degreasing PK 700 or PK 1000

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.mppaint.com](http://www.mppaint.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.






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



### Putty

	STOP UNI STOP Hardener	100 g 3 g
	Coats:	2 – 3
	20°C 60°C	20 min. 10 min.
	(short wave) (medium wave)	4 min. 50% 6 min.
	Dry: use P80, P150, P240, then clean with PK 1000	

### Sealer

	EUROXY CP EUROXY CP REACTIVE FR 500	100% by vol. 25% by vol. 25% by vol.
	Spray coats: Film thickness:	1 15 – 20 µm
	60°C:	20 min.
	(short wave)	11 min. at 100%






### Spray putty

	STOP FILLER II STOP FILLER hardener	100% by vol. 5% by vol.
	Spray coats: Film thickness:	3 200 – 300 µm
	Drying at 20°C Drying at 60°C	4 hours 20 min.
	(short wave) (medium wave)	8 min. at 50% 10 min.


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### Filler

	<p><b>PERFECTFILLER GREY</b></p> <p>D 70 / D 80</p> <p>FR 500</p> <p>You may use <b>PERFECTFILLER WHITE / BLACK</b> or <b>PROFILLER WHITE / GREY &amp; BLACK</b> instead of <b>PERFECTFILLER GREY</b></p>	<p>100% by vol.</p> <p>25% by vol.</p> <p>25% by vol.</p>	<p>100 g</p> <p>15 g</p> <p>13 g</p>
	<p>Spray coats:</p> <p>Film thickness:</p>	<p>2</p> <p>50 – 70 µm</p>	<p>3</p> <p>80 – 120 µm</p>
	<p>Drying at 20°C</p> <p>Drying at 60°C</p>	<p>3 hours</p> <p>20 min.</p>	
	<p>(short wave)</p>	<p>9 min.</p>	
	<p>Dry: use P400, then degrease with PK 2000</p>		

### Topcoat

	<p><b>DIAMONT, ONYX HD, UNO HD, UNO HD CP</b></p> <p>Apply in accordance with the Technical Data Sheet</p>
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