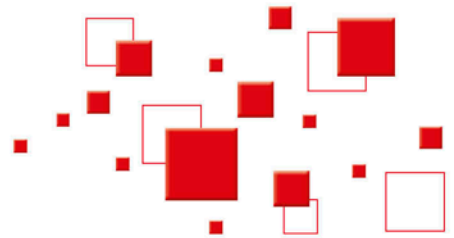


Process Information

Infrared Paint system



Process description

Special process for refinishing with infrared drying using a cassette heater with temperature regulation.

Infrared drying significantly shortens the drying time.

That leads to

- a reduction of throughput times,
- lower energy costs,
- shorter process times and
- improved curing performance enabling you to continue working (such as polishing) earlier.

We recommend this refinishing method especially for small vertical surfaces that can be dried with a cassette heater with temperature regulation in one drying cycle.

Substrates

- Automotive OEM finishes, fully cured and solvent-resistant

Products required

- PK 700 / PK 1000 / PK2000
- STOP UNI
- STOP EXTRA FIN
- STARFILL
- PERFECTFILLER WHITE / GREY / BLACK
- ONYX HD Basecoat
- 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 1000
	Sanding P80 – P150 Sand damaged areas down to the bare metal
	Degreasing PK 1000
	Please note: Alternatively, you may use PK 700.

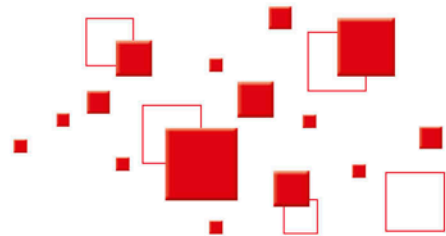
The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any 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 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





Infrared Paint system



Body Filler

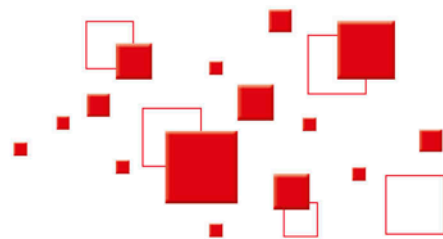
	STOP UNI STOP Hardener	100 g 3 g	
	Time 4 min.	Temperature increase 20°C / min.	Max. surface temperature 80°C
	Coarse sanding P80 / P150	Fine sanding P240 / P320	
	Clean PK 2000		
Please note: Depending on the damaged area, you can also use STOP EXTRA FIN.			

Primer







	STARFILL D 30 Activator FR 500	100% by vol. 100% by vol. 30% by vol.	
	HVLP gravity-feed spray gun	1.3 – 1.7 mm	0,7 bar at the nozzle
	Spray coats: Film thickness:	1 5 – 10 µm	
	Time 4 min.	Temperature increase 15°C / min.	Max. surface temperature 60°C
Please note: After a flash-off time of > 24 h it is necessary to de-nib the surface.			

Process Information





Infrared Paint system



Primer filler

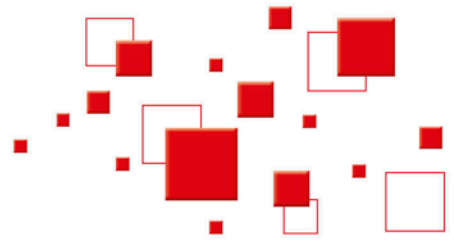
	Stir well before use		
	PERFECTFILLER GREY D 70 / D 80 FR 500	100% by vol. 25% by vol. 25% by vol.	
	HVLP gravity-feed spray gun	1.7 – 1.9 mm	0.7 bar at the nozzle
	Spray coats: Film thickness:	2 50 – 70 µm	
	Time 4 min. 5 min.	Temperature increase 15°C / min. 20°C / min.	Max. surface temperature 60°C 80°C
	Dry: use P400		
	Clean PK 2000		
	Alternatively, all R-M primer fillers can be used.		

Basecoat





	Stir ONYX HD mixing bases on the mixing machine twice a day for 15 minutes		
	ONYX HD basecoat HYDROMIX Mix intensively immediately after weighing. Strain before application. Attention: Do not insert a screen in the spraygun when applying a metallic or pearl-effect basecoat.	100% by vol. 60% by vol.	depending on colour 60 g
	HVLP gravity-feed spray gun	1.4 – 1.5 mm	0.7 at the nozzle
	Spray coats: Film thickness: Flash off until mat between spray coats	2 + ½ 12 – 15 µm	
	Time 4 min.	Temperature increase 15°C / min.	Max. surface temperature 60°C

Process Information

Infrared Paint system



Clear

	CRYSTALCLEAR CP H 420 SC 850	300% by vol. 100% by vol. 100% by vol.	
	HVLP gravity-feed spray gun	1.3 – 1.5 mm	2,0 bar
	Spray coats: Film thickness:	$\frac{1}{2} + 1$ 40 – 50 μm	
	Time 4 min. 4 min.	Temperature increase 15°C / min. 20°C / min.	Max. surface temperature 60°C 90°C
Please note: Apply clear to vertical surfaces only.			