

# Process information

## Overall respray R-M ONYX HD – Brilliant red / Radom steel

### Process description

Special refinishing process for overall respray of CITROËN DS 3 in Brilliant red and Radom steel.

### Substrates:

- Fully cured CITROËN old paintwork


### Products required

- PK 700, PK 900 and PK 1000
- ONYX HD Brilliant red with SPECIAL CRYSTAL BASE 12L and HB80T
- ONYX HD Radom steel
- DIRECTFILLER WHITE / GREY / BLACK
- GLOSSCLEAR C 2550
- CRYSTALCLEAR CP
- SATINTOP / SILICATOP
- MT 900

### Safety instructions

The products are suitable for professional use only.  
It cannot be ruled out that this product contains particles < 0.1 µm.  
Comply with present safety instructions and personal protective equipment.

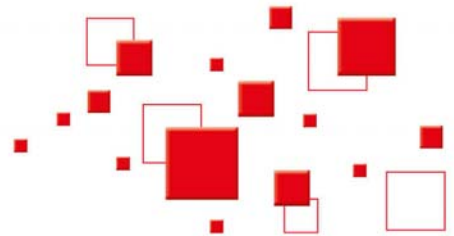
### Pretreatment for overall respray and roof

	<p>Clean with PK 700 or PK 900. Sand with P500. Then clean with PK 1000.</p>
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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 statements 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.

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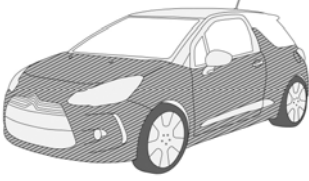
## Overall respray R-M ONYX HD – Brilliant red / Radom steel

### Instructions for overall respray without roof

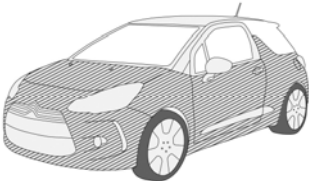
#### 1) Filler

	Clean the surface with PK 1000 before applying DIRECTFILLER.	
	<b>Mixing ratio:</b> DIRECTFILLER D 70120% by vol. FR 500	100% by vol.  20% by vol.
	<b>Spraygun:</b> 1.7 – 1.9 mm HVLP <b>Spraycoats:</b> ½ + 1 <b>Film thickness:</b> 50 – 70 µm <b>Drying:</b> 35 min at 60°C As an alternative to DIRECTFILLER, you may also use PERFECTFILLER, PROFILLER or EXTRASEALER.	2.0 – 2.5 bar


#### 2) ONYX HD Brilliant red Step 1

	<b>Mixing ratio:</b> ONYX HD Brilliant red Step 1 100% by vol. HYDROMIX 60% by vol. Mixture contains 9.29% SPECIAL CRYSTAL BASE 12 L (glass flakes)	
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP <b>Spraycoats:</b> 2 - 3 <b>Flash-off:</b> until matt	2.0 bar

#### 3) ONYX BLENDER HD Brilliant red Step 2

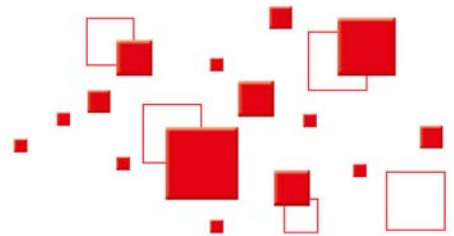
	<b>Mixing ratio:</b> ONYX HD Brilliant red Step 2 100% by vol. HYDROMIX 60% by vol. Mixture contains 3.77% exclusive HB 80T mixing base	
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP <b>Spraycoats:</b> 2 ½ <b>Flash-off:</b> between spraycoats, until mat	2.0 bar

#### 4) Clearcoat

	Primarily, use the new GLOSSCLEAR C 2550. Before market launch in the first half of 2015 please use:	
	<b>Mixing ratio:</b> CRYSTALCLEAR CP 300% by vol. H 420 100% by vol. SC 850 100% by vol.	
<b>Spraygun:</b> 1.3 – 1.5 mm HVLP <b>Spraycoats:</b> 2 <b>Flash-off:</b> 3 – 5 min between spraycoats <b>Drying:</b> 30 min at 60°C or short-wave infrared, 8 min at 100%	2.0 – 2.5 bar	



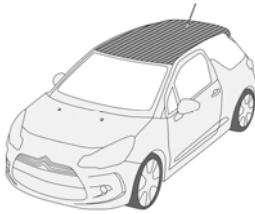
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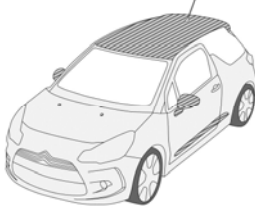
## Overall respray R-M ONYX HD – Brilliant red / Radom steel

### Instructions for overall respray of roof and add-on parts


#### 1) Filler

	Clean the surface with PK 1000 before applying DIRECTFILLER.	
	<b>Mixing ratio:</b> DIRECTFILLER <b>D 701</b> FR 500	100% by vol. 20% by vol. 20% by vol.
	<b>Spraygun:</b> 1.7 – 1.9 mm HVLP <b>Spraycoats:</b> ½ + 1 <b>Film thickness:</b> 50 – 70 µm <b>Drying:</b> 35 min at 60°C	2.0 – 2.5 bar
As an alternative to DIRECTFILLER, you may also use PERFECTFILLER, PROFILLER or EXTRASEALER.		

#### 2) ONYX HD Radom steel

	<b>Mixing ratio:</b> ONYX HD Radom steel HYDROMIX	
	100% by vol. 60% by vol.	
	<b>Spraygun:</b> 1.4 – 1.5 mm HVLP <b>Spraycoats:</b> 2 ½ <b>Flash-off:</b> until matt	2.0 bar

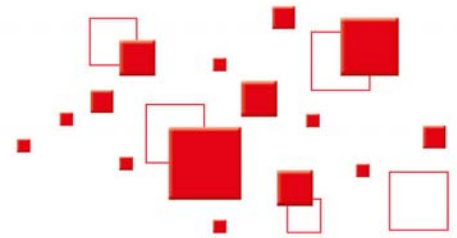
#### 3a) Clearcoat application for mirror caps and side bumpers

	<b>Step 1</b> <b>Mixing ratio:</b> SATINTOP SILICATOP	
	40% by vol. 60% by vol.	
	<b>Step 2</b> <b>Mixing ratio:</b> Mixture Step 1 H 420 SC 850	
	100 g 23 g 36 g	
	<b>Spraygun:</b> 1.3 – 1.5 mm HVLP <b>Spraycoats:</b> 2 <b>Flash-off:</b> Flash off for 10 – 15 min after the first spraycoat and for 15 – 20 min after the second spraycoat. Do not flash off for more than 25 minutes after each spraycoat.	2.0 – 2.5 bar
	<b>Drying:</b> 30 min at 60°C	




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R-M ONYX HD – Brilliant red / Radom steel



## 3b) Clearcoat application on the roof

	Primarily, use the new GLOSSCLEAR C 2550. Before market launch in the first half of 2015 please use:		
	<u>Step 1</u>		
Mixing ratio:	CRYSTALCLEAR CP MT 900	100% by vol. 50% by vol.	
<u>Step 2</u>			
Mixing ratio:	Mixture Step 1 H 420100% by vol. SC 850	300% by vol. 100% by vol.	
Spraygun:	1.3 – 1.5 mm HVLP	2.0 – 2.5 bar	
Spraycoats:	2		
Flash-off:	3 – 5 min between spraycoats		
Drying:	30 min at 60°C		