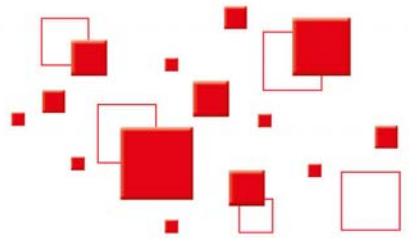


Process Information

Repair of two-colour paintwork with ONYX HD on the 208 GTI 30th, textured finishes



Description of the repair process:

Repair of two-color paintwork with ONYX HD on the 208 GTI 30th, textured finishes is a system designed for the repair of textured finishes of the Peugeot 206 GTI 30th with ONYX HD by professional refinish centres.

On the 208 GTI 30th special edition model, the KAH coloring is a combination of textured matt black (Ice Black) and glossy red (Red Hot).

For the repair of a textured matt panel the entire panel have to be repaired, to avoid deviations in the final appearance. After accurate masking of the adjacent areas apply textured clear, black basecoat and flat clear coat on the entire repair panel.

Substrates:

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

Products required:

- PK 2000
- ONYX HD
- HYDROMIX
- MT 900
- DIAMONTCLEAR CP
- SILICATOP




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.

1) Pretreatment

	Clean with PK 2000, mask and demarcate the area to be repaired
	Sand the textured blending area with P280 – P320 using an orbital sander Sand by hand with P400 until a smooth and uniform surface is obtained.
	Blow off and clean with PK 2000 Mask and carefully place the fine line tape on the colour transition and the foam tape on the demarcations.

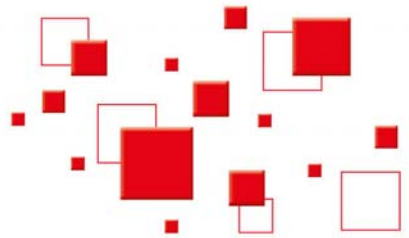
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Prozess Information

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The textured matt black is a three-layer system:






1st coat = texture coat

2nd coat = matt black basecoat

3rd coat = matt clearcoat

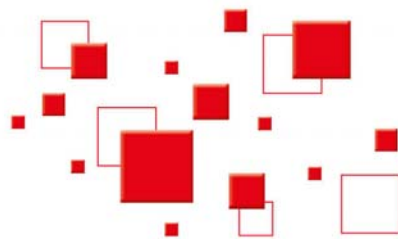


2) Application of the texture coat with MT 900 on the complete matt black panel

	DIAMONTCLEAR CP MT 900 H 420 SC 850 Mix. Do not filter	300 Vol.-% 100 Vol.-% 100 Vol.-%	117 g 183 g 36 g 29 g
	Viscosity at 20°C ISO 4-cup: DIN 4-cup:	38 to 42 seconds 17 to 19 seconds	
	Portlife: 2 h at 20°C		
	Compliant gravity feed spraygun	1,3 mm	2,0 – 2,5 bar
	Spraycoats: Film thickness: After the first coat, allow to flash off until matt. Before drying, allow to flash off until a totally matt surface is obtained.	2 40 – 50 µm	
	Drying at 60°C	30 min	

Prozess Information

Repair of two-colour paintwork with ONYX HD on the 208 GTI 30th, textured finishes

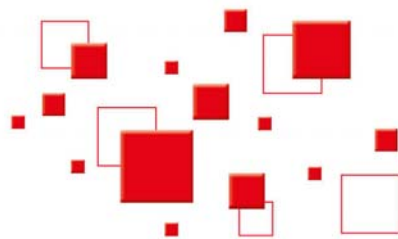


3) Application of ONYX HD "Ice Black" on the complete panel






	<p>ONYX HD color HYDROMIX Mix and filter before use</p>	<p>100 by vol. 60 by vol.</p>	<p>depending on color shade 60 g</p>
	<p>Viscosity at 20°C ISO 4-cup: DIN 4-cup:</p>	<p>42 to 68 seconds 18 to 25 seconds</p>	
	<p>Potlife: ONYX HD colour: 6 months in a closed plastic container. ONYX HD ready for use: 1 week in a closed plastic container.</p>		
	<p>HVLP-gravity feed spraygun</p>	<p>1,4 – 1,5 mm</p>	<p>0,7 bar at nozzle</p>
	<p>Spraycoats: Film thickness: After each coat, allow to flash off until matt.</p>	<p>Metallic-pearl 2 + 1 mist coat 15 – 20 µm</p>	
	<p>Drying at 20°C Drying at 45°C</p>	<p>approx. 15 min Note: Drying can be accelerated with the aid of an additional air flow approx. 10 min + cooling</p>	

Prozess Information

Repair of two-colour paintwork with ONYX HD on the 208 GTI 30th, textured finishes



4) Application of the matt clearcoat on the complete panel

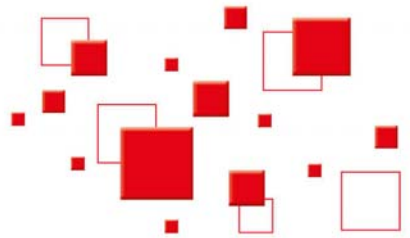
	SILICATOP H 420 SC 850 Mix and filter.	100 g 23 g 36 g	
	Viscosity at 20°C ISO 4-cup: DIN 4-cup:	38 to 42 seconds 17 to 19 seconds	
	Potlife: 2 h at 20°C		
	HVLP- gravity feed spraygun Compliant gravity feed spraygun	1,3 – 1,5 mm 1,3 – 1,4 mm	0,7 bar at the nozzle 2,0 – 2,5 bar
	Spraycoats: Film thickness: After the first coat, allow to flash off until matt. Before drying, allow to flash off until a totally matt surface is obtained.	2 40 – 50 µm	
	Drying at 60°C	30 min	

Important note: The appearance achieved may differ slightly from the result desired if the application conditions, in particular the number of coats and film thickness, are not observed.



Prozess Information

Repair of two-colour paintwork with ONYX HD on the 208 GTI 30th, textured finishes



Special precautions:

Painting must be carried out in the cleanest possible conditions. Any surface defects cannot be removed through polishing.

Removing a surface defect, if necessary, requires repainting of the complete panel, which means that the complete system consisting of a texture coat, a basecoat and a matt clearcoat must be re-applied.

Maintenance of the textured paint:

Always avoid:

- polishing of the paint surface
- the use of wax and polish
- the use of abrasive sponges (e.g. household sponges, cloths etc.)
- car wash
- the use of aggressive products (cleaning agents, oils, greases etc.)

Cleaning:

Do not wash the vehicle in bright sunlight.

Before washing, remove soiling such as dust, leaves etc, using compressed air.

Soak the remains of insects and bird droppings in water before removing them using a high-pressure cleaner.

Wash preferably by hand, using a soft sponge, neutral soap and lots of water. Dry preferably with compressed air and a piece of soft chamois leather.

