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AM900 Aero-Max Pre-Kleano N2

AM902 Aero-Max Plastic Prep and Cleaner N2

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EP569 Gray Chromate Free Epoxy Primer as a Pre-Coat, as a wow

EP669 White Chromate Free Epoxy Primer as a Pre-Coat, as a wow

EP769 Black Chromate Free Epoxy Primer as a Pre-Coat , as a wow

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870 High Solids Adhesion Promoter for Plastics , on Flex / LOW VOC

DP200 Exempt Low VOC 2K Primer as a wow LOW VOC

DP321 Low VOC Tintable Sealer as a wow LOW VOC, on Flex

DP322 Low VOC White Sealeras a wow LOW VOC, on Flex

DP323 Low VOC Dark Grey Sealeras a wow LOW VOC, on Flex

DS40 LVOC Transparent Sealer LOW VOC

EP369 Grey Epoxy Primer LVOC as a surfacer LOW VOC, as a wow

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Topcoats NAT Splash Page

Topcoats Success Page(s)

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R-M Extreme Colors

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Topcoats LOW VOC Splash Page

UNO HD 340 gms/liter (2.8 lbs/gal) VOC for Spot Repairs LOW VOC,

for Complete Repairs

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for Complete Repairs

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Diamont Basecoat Diamont Basecoat for Spot Repairs

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DC01NB Energy Saving Speed Clear, for Flex, for Suede

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DC5100 CTR Clear, for Flex, for Low Gloss, for Suede, for Cut In

DC5300 CTR Baking Clear, for Flex, for Low Gloss

DC5335 Glamour Clear, for Flex, for Low Gloss, for Suede

DC5600 CTR Production Clear, for Flex, for Low Gloss,

for Suede, for Cut In

DC100 Jammin' Clear, for Suede

DC5775 Ultra Flat Clear_National Rule, for Suede

Clearcoats LOW VOC Splash Page

DC21NB Low VOC Energy Saving Speed Clear LOW VOC , for Flex, for Suede

DC98 2.0 VOC Clearcoat LOW VOC, for Low Gloss, for Suede

DC5775 Ultra Flat Clear LOW VOC, for Suede

DC5800 2.0 CTR Clear LOW VOC, for Flex

DC5900 Low VOC Pre-Flexed Clear LOW VOC, for Suede

DC5995 Low VOC Glamour Clear LOW VOC, for Flex

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Specialty/AUX NAT Splash Page

Specialty/AUX Success Page(s)

822 Adhesion Promoter

R-M 855 SharkBITE Scuff and Clean

BC00 Base Clear

BC100 Base Clear

BCH2 Basecoat Hardener

BCH10 Basecoat Hardener

HB10S Ultra Flash Flake

HR50 Blending Solvent A2

MT900 Suede Texture

PA20NB Low VOC Productive Primer Activator

SB01 Low VOC Mixing Clear

SM09 Flattener - Special MAT09

UBR200 Blending Solvent

Specialty/AUX LOW VOC Splash Page

801 Metal Conditioner LOW VOC

809 Fisheye Eliminator LOW VOC

812 Fisheve Eliminator LOW VOC

R-M 825 Hydropure LOW VOC

869 1K Low VOC Adhesion Promoter A2

915 Waterborne Gun Cleaner LOW VOC

DF21 Flex Agent LOW VOC

HB055 Onyx Blender Pro II LOW VOC

HR5 Jet Accelerator LOW VOC

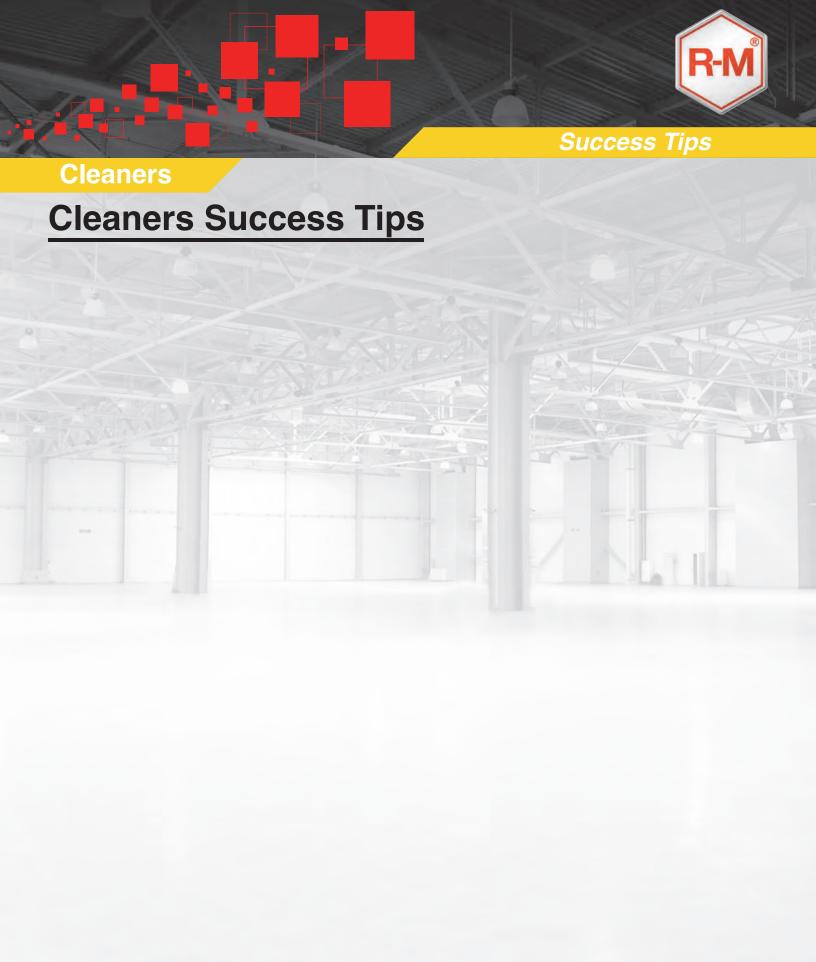
Jet95 Accelerator LOW VOC

SM10 Low VOC Matte Additive LOW VOC

- Safety Pages

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Cleaners

R-M 855 SharkBITE Scuff and Clean

Product Details



R-M 855 SharkBITE Scuff and Clean is a fast, convenient method for cleaning and prepping a substrate for coating. Use on any non-porous, previously coated surface or raw plastic.

Mixing



Ready for Use

Application



To Use 855 SharkBITE Scuff and Clean:

- 1. Submerge a new, unused R-M 855 SharkBITE Scuff and Clean pad in a pail of clean, warm water for a few seconds.
- 2. Scuff the bumper or plastic part completely using a moistened R-M 855 SharkBITE Scuff and Clean pad. Repeat a second time to ensure comprehensive abrasion. There is no need to bake an unprimed plastic part before scuffing.
- 3. Do not allow residue to dry on the plastic. Immediately scrub and rinse surface thoroughly with clean water. Make sure that all residue is removed.
- 4. Inspect the part to ensure it is uniformly abraded. If not, repeat above steps on any areas you have missed and make sure that all residue has been removed.
- 5. Continue with your normal paint process. Refer to the R-M manual to determine the plastic adhesion promoter or primer/sealer that is appropriate for the plastic. You do not need to degrease the part.
- 6. Discard the used R-M 855 SharkBITE Scuff and Clean pad as it is designed to prep a single bumper or part.

Safety









900 Pre-Kleano

Product Details



900 Pre-Kleano is an aggressive solvent used primarily as a first clean after soap and water. Designed to be slow drying targeting silicone, wax, grease and oil based road contaminants. 900 Pre-Kleano is an integral part of successful finishes.

- First clean
- Aggressive cleaning
- · Wax and grease remover
- OEM approved
- · Key item for success

Not to be used on plastics due to flash point

Required:

- All cleaners are designed to be wiped clean after application
- Clean lint free towels are to be used BASF #PPW300
- · Gloves, glasses and proper ventilation required
- · Adhere to all safety precautions
- Understand cautions relating to substrates

Key Points:

- Pre cleaner to be used after soap and water wash
- Aggressive wax and grease remover
- Not to be used on Plastics

Safety









901 Solvent Final Wipe

Product Details



- Final clean
- · Spot cleaning
- · Very fast final clean solvent
- OEM approved
- Optional final cleaner

Not to be used on plastics due to flash point

Required:

- Wipe immediately, cleaning only small sections
- All cleaners are designed to be wiped clean after application
- Clean lint free towels are to be used BASF #PPW300
- · Gloves, glasses and proper ventilation required
- · Adhere to all safety precautions
- · Understand cautions relating to substrates

Key Points:

- · Optional solvent final wipe
- · Small area fast final cleaner
- Not to be used on Plastics

<u>Safety</u>











Cleaners

902 Raw Plastics Cleaner

Product Details



902 Raw Plastics Cleaner is a plastic prep cleaner designed to remove mold release agents, silicone, wax grease and oils from plastic substrates.

- · Aggressive plastics cleaner
- · Mold release targeted deep cleaner
- · Excellent for all raw plastics
- · Prefers airflow assisted drying
- · Optional final cleaner with proper flash time before topcoat

Designed to clean raw OEM plastics

Required:

- Wipe immediately
- Spray bottle application recommended
- All cleaners are designed to be wiped clean after application
- Clean lint free towels are to be used BASF #PPW300
- Gloves, glasses and proper ventilation required
- Adhere to all safety precautions

Key Points:

- · Aggressive plastics cleaner
- First clean for all raw plastics

<u>Safety</u>











903 Anti-Stat Final Wipe

Product Details



903 Anti-Static Final Wipe solution is specially made for unpainted automotive plastic parts and/ or gelcoated fiberglass. R-M 903 was designed and formulated to clean and reduce static charge, minimize dirt and dust pick-up and/or prevent static electricity build-up. Excellent when used as anti-static pretreatment spray before adhesion promoter application, primer or topcoat application. Excellent anti-static wipe-on cleaner unpainted plastic parts

- Final clean
- · Alcohol based cleaner
- · Fast final clean solvent
- OEM approved
- Optional final cleaner

Can be used as a final anti stat when spray applied to raw plastic

Required:

- · Wipe immediately, cleaning only small sections
- All cleaners are designed to be wiped clean after application
- Clean lint free towels are to be used BASF #PPW300
- · Gloves, glasses and proper ventilation required, adhere to all safety precautions
- Understand cautions relating to substrates

Key Points:

- Aggressive cleaner can attack one component products
- · Optional alcohol final clean
- · Plastics compatible

<u>Safety</u>













Cleaners

AM865 Plastic Adhesion Promoter

Product Details



AM865 Plastic Adhesion Promoter is designed to give adhesion to flexible plastic parts.

Mixing



Ready to Spray

Product Tips:

Tack off substrate prior to application of AM865 Plastic Adhesion Promoter.

Application



Apply 1 light wet coat

VOC as Applied: 767 gms/ltr (6.3 lbs/gal)

Post Application



Drying:

Tack Time Dry Time

20°C/68°F 5 minutes 15 to 30 minutes (no longer than 8 hours)

60°C/140°F N/A 10 minutes

Sanding:

If AM865 has been dried for more than 8 hours, scuff with 320 grit and reapply AM865.









Cleaners

AM865 Plastic Adhesion Promoter

Safety











Cleaners

AM900 Aero-Max Pre-Kleano

Product Details



AM900 Pre-Kleano is a silicone, wax, grease, tar and road-oil dissolving solvent. AM900 will remove contamination from existing paint films, slightly penetrate existing paint for good adhesion of subsequent coats, and clean sanded OEM finishes for repairing.

Mixing



Ready to Spray

Product Tips:

Do not use on plastic parts.

Application



Shake aerosol can and spray to test. Spray distance 6"-8" Apply 1 coat. Do not let dry. While still wet, wipe AM900 off with clean, dry cloth. VOC as Applied 708 gms/ltr (5.9 lbs/gal)

Notes

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Safety











Cleaners

AM902 Aero-Max Plastic Prep and Cleaner

Product Details



AM902 is a plastic prep cleaner designed to remove mold release agents, silicone, wax grease and oils from plastic substrates.

Mixing



Ready to Spray

Product Tips:

For use on plastic parts.

Application



Shake aerosol can and spray to test. Spray distance 6"-8" Apply 1 coat. Do not let dry. While still wet, wipe AM902 off with clean, dry cloth. VOC as Applied 742 gms/ltr (6.2 lbs/gal)

<u>Notes</u>

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Safety

















Cleaners

851 Prep Wash

Product Details



851 Prep Wash is a fast, convenient method for cleaning and prepping the substrate for coating. Use on any nonporous, previously coated surface or raw plastic.

- · Water rinse plastics cleaner
- · Mold release targeted deep cleaner
- · Excellent for all raw plastics
- · Rinse thoroughly after application
- Scotchbrite[™] assisted application

Designed to clean raw plastics

Required:

- Water rinse thoroughly
- 851 must be completely rinsed before next steps
- · Gloves and glasses required
- Adhere to all safety precautions

Key Points:

Aggressive plastics cleaner

<u>Safety</u>











909 Water Based Cleaner

Product Details



909 Final Wipe solution will remove light contamination from existing paint films, and clean sanded OEM finishes, enabling good adhesion of subsequent coats. R-M 909 can be used for unpainted automotive plastic parts and/or gelcoated fiberglass and can be used as anti-static pretreatment before adhesion promoter application, primer or topcoat application.

- · Excellent for removing sanding residue
- Water based anti stat
- · Great for in booth final wipe
- · Prefers airflow assisted drying
- Optional final cleaner

Required:

- · Wipe immediately
- Spray bottle application recommended
- All cleaners are designed to be wiped clean after application
- Clean lint free towels are to be used BASF #PPW300
- · Gloves, glasses and proper ventilation required
- Adhere to all safety precautions

Key Points:

- · Water based cleaner
- Substrate friendly cleaner

Safety























869 1K Low VOC Adhesion Promoter

used over Flexible Parts

Product Details



R-M 869 1K Low VOC Adhesion Promoter is a multipurpose adhesion promoter for all paintable plastics on cars. It is supplied ready to spray. No hardeners or reducers are required.

Mixing



Ready to Spray

Must shake by hand for a few minutes, as it contains aluminum flakes for visibility.

Pot Life of Mixed Product:

Indefinite

Application



Apply 1 to 2 uniform coats

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.2-1.3 mm (HVLP Gravity) 1.2-1.3 mm

Tech Data:

Viscosity: 14-16 sec. #4 Ford cup

Thickness: 0.2-0.4 mils

Coverage: 165-330 sq ft/gal @ 0.25 mil VOC as Applied 540 gms/ltr (4.5 lbs/gal)

Post Application



Drying:

Tack Time Dry Time

20°C/68°F 5 Minutes 15 to 30 minutes





Plastics

869 1K Low VOC Adhesion Promoter

used over Flexible Parts

<u>Notes</u>	
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Safety







Plastics

870 High Solids Adhesion Promoter for Plastics

used over Flexible Parts

Product Details



R-M 870 High Solids Adhesion Promoter for Plastics is an adhesion promoter for all paintable plastics on cars. 870 eliminates two steps in the process of repairing automotive plastic parts since a sealer or basecoat can be directly applied over it.

Reducers

UR30 Polar UR40 Fast

UR50 Normal

UR60 Mid to Hot

UR70 High Temp

UR100 Retarder

Products:

Hardeners

PH60 Fast Hardener PH61 Medium Hardener



Mixing

Mixing Ratio: 4:1:1

4 parts 870

1 part PH60 or PH61

1 part UR Reducer

Pot Life of Mixed Product:

7 hours

Application



Apply 1 medium wet coat.

On surfaces with imperfections (higher film build) apply 1 light coat and 1 medium wet coat

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.6-1.8 mm (HVLP Gravity) 1.1-1.3 mm

Tech Data:

Viscosity: 18-20 sec. #4 Ford cup

Thickness: 0.5-1.0 mils

Coverage: 353 sq ft/qal @ 0.5 mil

VOC as Applied: 600 gms/ltr (5.0 lbs/gal)

Post Application



Drying:

20°C/68°F 30 minutes 60°C/140°F 30 minutes

When used on surfaces with imperfections (higher film build) it must be baked. For standard application let flash for 30 minutes.



50-70 Single Panel

70-85 Multi Panel

80+ Multi Panel

Overall Slow







Plastics

870 High Solids Adhesion Promoter for Plastics

used over Flexible Parts for Low VOC System

Product Details



R-M 870 High Solids Adhesion Promoter for Plastics is an adhesion promoter for all paintable plastics on cars. 870 eliminates two steps in the process of repairing automotive plastic parts since a sealer or basecoat can be directly applied over it.

Products:

Hardeners

DH99 Low VOC Fast Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 4:1:1

4 parts 870

1 part DH99

1 part UR30, UR40 or UR50

Up to 50% additional reducer may be added as necessary for specific applications. (8:2:3 mix ratio)

Pot Life of Mixed Product:

7 hours

Application



Apply 1 medium wet coat.

On surfaces with imperfections (higher film build) apply 1 light coat and 1 medium wet coat

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.6-1.8 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 22-28 sec. #4 Ford cup Thickness: 0.75-1.0 mils (1 coat) 1.0-1.5 mils (1/2 + 1 coat) Coverage: 645 sq ft/gal @ 1.5 mil

VOC as Applied: 540 gms/ltr (4.5 lbs/gal)

R-M 870 When the familian is a constant of the constant of t

Post Application



Drying:

20°C/68°F 30 minutes 60°C/140°F 30 minutes

When used on surfaces with imperfections (higher film build) it must be baked. For standard application let flash for 30 minutes.









Plastics

870 High Solids Adhesion Promoter for Plastics

ed over Flevible Parts for Low VOC System

Safety















Plastics

868 1K Plastic Primer

used over flexible parts

Product Details



R-M 868 1K Plastic Primer is a multi-purpose adhesion promoter for all paintable plastics on cars. It is supplied ready to spray. No hardeners or reducers are required.

Products:

851 Prep and Wash902 Plastic Prep Cleaner909 Final WipeAM902 Aero-Max Plastic Prep and Cleaner

Mixing



Ready to spray

Application



Apply 1 to 2 uniform coats

Spray Pressure:

(HVLP/HE) : 8-10 psi at air cap

Fluid Tip:

Fluid Tip (HE Gravity): 1.3 mm Fluid Tip (HVLP gravity): 1.3 mm

Tech Data:

Viscosity: 10 sec. #4 Ford cup

Thickness: 0.2-0.4 mil Pot Life: Indefinite

Coverage: 165-330 sq ft/gal @ 0.25 mil VOC as Applied: 803 gms/ltr (6.7 lbs/gal)









Plastics

868 1K Plastic Primer

used over flexible parts

Post Application



Drying: 20°C/68°F

Tack Time:

5 Minutes

Dry Time:

15 to 30 minutes

Sanding/Polishing:

If 868 has been dried for more than 4 hours reapply a uniform coat.

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Safety









Primers ERO MAX AERO MA R-M R-M R-M R-M R-M R-M R-M AM700 DP21 **DE17** DP20 AM2759 AM800 Chromate Free Etch Primer Apprilt décapant sans chromate Primario decapante sin cromate D 815 0-815 0-845 R-M R-M R-M R-M R-M CB DP25 CB DP26 **DP100** DP22 2K Productive Primer Apprets productives 2K rimano Productives de 2K CB DP27 II-865 R-M R-M R-M R-M R-M DP200 **EP369 DP226 DP236 DP237** Epsny Primer 3.5 VOC - Gray Apprêt d'éposyde COV 3.5 - Gris Primario de aposta COV 3.5 - Gris D BES I BUS .basfrefinish.com .bastrofinish.co ww.bastrefinish.com ww.bastrefinish.com www.basfrefinish.com R-M R-M R-M R-M R-M **EP569 EP669 EP769 EP869** NP80 DIBLE







Primers

Specialty Product

AM2759 Aero-Max 2K Epoxy Gray Undercoat

Product Details



AM2759 Epoxy is designed to be used as a wet-on-wet sealer and as a DTM primer sealer for R-M topcoats.

Application



Shake aerosol can for two minutes after mixing ball begins to rattle and spray to test. Spray distance 6"-8"

Apply 2 to 3 coats allowing 5 to 10 minutes flash between coats.

Tech Data:

Thickness: 1.0-2.0 mils

Coverage: 359 sq ft/gal @ 1 mil

PWMIR: 1.20 Aerosol General Coating, Primer VOC as Applied: 563 gms/ltr (4.7 lbs/gal)

Mixing



- · Shake aerosol for 2 minutes.
- Take red button from cap and attach it to the pin on the aerosol bottom.
- Put aerosol with cap upside down on a stable ground.
- Press red button with ball of your hand until stop is reached.
- Shake vigorously for minimum of 2 minutes.
- Contents good for only 1 day after activation.

Pot Life of Shaken Product:

1 day

Product Tip:

Use for spot repairs and small sand throughs, as a wet-on-wet sealer.

Post Application



Drying:

20°C/68°F Topcoats should be applied after 30 minutes flash for single stage and after 2 hours for basecoat, but no longer than 24 hours for any topcoat.

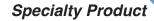
Drying at room temperature:

Tack Free - 1 hour
Dry to touch/handle - 4 hours









Primers

AM2759 Aero-Max 2K Epoxy Gray Undercoat

<u>Notes</u>		

Safety











Primers

Specialty Product

AM700 Aero-Max Prime Etch

Product Details



AM700 Prime Etch is a 1K, fast drying, weld-thru primer that provides excellent adhesion and corrosion protection to properly prepared steel, stainless steel, aluminum and galvanized metals.

Application



Shake aerosol can for one minute after mixing ball rattles and spray to test. Spray distance 6"-8"

Apply 1 to 2 coats allowing 2 to 5 minutes flash between coats.

Tech Data:

Thickness: .25 to .50 mils

Coverage: 189.8 sq ft/gal @ 1 mil VOC as Applied: 586 gm/ltr (4.9 lbs/gal)

Mixing



Ready-to-Spray

Post Application



Drying:

20°C/68°F 15 to 20 minutes

Product Tips: Use for spot repairs and small sand throughs.

Do not apply 2K polyester putties, 2K epoxy coatings or waterborne basecoats over.









Primers

AM700 Aero-Max Prime Etch

<u>Notes</u>		

Safety











Primers

Specialty Product

AM800 Aero-Max Spot Prime

Product Details



AM800 Spot Prime is a 1K, fast drying, easy sanding primer that provides excellent adhesion plus good color hold-out. AM800 can be applied over cured, cleaned and sanded paint finishes and bare steel.

Tech Data:

Number of Coats: 2 to 3 coats

Thickness: 2.0-3.0 mils

Coverage: 189.8 sq ft/gal @ 1 mil

VOC as Applied: 580 gms/ltr (4.8 lbs/gal)

Product Tip: Use for spot repairs and small sand throughs.

Application



Shake aerosol can for one minute after mixing ball rattles and spray to test.

Spray distance 6"-8"

Apply 2 to 3 coats allowing 2 to 5 minutes flash between coats.

Mixing



Ready-to-Spray

Post Application



Drying:

20°C/68°F 15 to 30 minutes

Sanding:

Wet Sand by Hand - 320 to 400 grit Dry Sand by Hand - 320 grit Dry Sand by Machine - 280 grit







Specialty Product

Primers

AM800 Aero-Max Spot Prime

<u>Notes</u>		

Safety











Primers

Specialty Product

AM826 Aero-Max Flash Fill UV Primer

Product Details



AM826 Aero-Max Flash Fill UV Primer is a one component, high build, UV curable primer for application over galvanized, aluminum alloys, steel, old paint, fiberglass, SMC, and body fillers. AM826 produces an easy to use, high build, fast automotive undercoat. It also has an excellent sag resistance and is easy to apply. The highly durable, solvent resistant film, is superior to many conventional acrylic polyurethane primers.

Mixing



Ready to spray

Application



Apply 2 to 3 wet coats allowing 1 to 2 minutes minimum flash between coats Allow 3 to 5 minutes minimum flash before UV curing Shake aerosol can for one minute after mixing ball rattles and spray to test. Spray distance 6"-8"

Tech Data:

Number of Coats: 2 to 3 wet coats

Thickness: 2.0-4.0 mils

Coverage: 350 sq ft/gal @ 1.0 mil

VOC as Applied: 587 gms/ltr (4.9 lbs/gal)

Post Application



Drying:

UV cure with UVA lamp 3 to 10 inches away for 2 to 3 minutes UV primer can be cured by sunlight.

- Exposure time is dependant on UV intensity (average time is 5 to 20 mins).
- Allow to flash before exposing to sunlight.
- · Surface cure will indicate extent of cure.
- · Can not be cured in the rain.

Sanding:

May be sanded immediately after UV cure.

- Sand with 320 to 500 grit paper.
- Surface will be slightly tacky and will be removed quickly after initial sanding with paper.
- For dry sanding, surface can be wiped with R-M 900, 901, 909 or AM900.
- For wet sanding, sand without wiping surface.









Primers

AM826 Aero-Max Flash Fill UV Primer

<u>Notes</u>	
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Safety









Primers

Filling Primer

DP20 2K Urethane Primer-Filler

as a Primer-Filler

Product Details



DP20 2K Urethane Primer-Filler is a two part urethane primer-filler. DP20 2K Urethane Primer-Filler is the undercoat recommended under UNO HD Color, ONYX HD or Diamont Basecoat Color. DP20 can be applied over cured, cleaned and sanded OEM finishes, cured air dried finishes, treated bare metals, body filler and fiberglass. The primer dries in 90 minutes and sands very easily.

Products:

Hardeners

PH12 Primer/Sealer Hardener X-Fast PH36 Medium Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 4:1:1

4 parts DP20

1 part PH12 or PH36 1 part UR Reducer

Pot Life of Mixed Product:

30 minutes @ 20°C/68°F

Product Tips:

Use the guide coat to locate imperfections that need to be sanded out.

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats Apply a light guide coat.







Filling Primer

Primers

DP20 2K Urethane Primer-Filler

as a Primer-Filler

Application (cont.)



Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm **Tech Data:**

Viscosity: 19-21 sec. #4 Ford cup

Thickness: 1.5-2.5 mils

Coverage: 297 sq ft/gal @ 2.0 mils VOC as Applied: 551 gms/ltr (4.6 lbs/gal)

Post Application



Drying:

20°C/68°F 90 minutes

60°C/140°F 35 to 45 minutes 70°C/160°F 25 to 35 minutes Infra Red short wave 5 to 7 minutes

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit

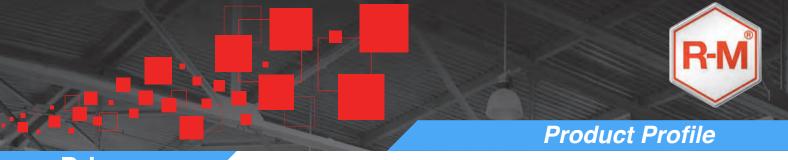
Remove sanding residue with 900, 901, 909 or AM900.

Notes









Primers

Filling Primer

DP20 2K Urethane Primer-Filler

as a Rollable Primer

Product Details



DP20 2K Urethane Primer-Filler is a two part urethane primer-filler. DP20 2K Urethane Primer-Filler is the undercoat recommended under UNO HD Color, ONYX HD or Diamont Basecoat Color. DP20 can be applied over cured, cleaned and sanded OEM finishes, cured air dried finishes, treated bare metals, body filler and fiberglass. The primer dries in 90 minutes and sands very easily. DP20 can be applied as a spray coating or a roller coating.

Products:

Primers

DE17 Chromate Free Etch Primer EP369 Grey Epoxy Primer LVOC EP569 Gray Chromate Free Epoxy Primer EP669 White Chromate Free Epoxy Primer

Primers (cont.)

EP769 Black Chromate Free Epoxy Primer EP869 Red Chromate Free Epoxy Primer PH12 Primer/Sealer Hardener X-Fast PH36 Medium Hardener

Mixing



Mixing Ratio: 4:1

4 parts DP20 1 part PH12 or PH36

Pot Life of Mixed Product:

30 minutes @ 20°C/68°F

Product Tips:

Use the guide coat to locate imperfections that need to be sanded out.

Application



Apply 2 even wet coats using 4" ultra-fine polyurethane foam roller cover allowing 10 minutes flash between coats. Apply a light guide coat.

Over-reduced Diamont Color such as BC200 works well.

Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat.

Tech Data:

Roller cover: 4" ultra-fine polyurethane

Thickness: 1.5-2.5 mils

Coverage: 329 sq ft/gal @ 2.0 mils VOC as Applied:520 gms/ltr (4.3 lbs/gal)







Filling Primer

Primers

DP20 2K Urethane Primer-Filler

as a Rollable Primer

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 35 to 45 minutes 70°C/160°F 25 to 35 minutes

Sanding:

Wet Sand - 400 to 600 grit
Dry Sand - 320 to 400 grit
Remove sanding residue with 900, 901, 909 or AM900.

as a Primer-Filler on Flexible Parts

Product Details



DP20 2K Urethane Primer-Filler is a two part urethane primer-filler.
DP20 2K Urethane Primer-Filler is the undercoat recommended under UNO HD, ONYX HD or Diamont Basecoat Color. DP20 can be applied over properly prepared flexible parts.

Products:

Flex Agents

DF21 Flex Agent

Hardeners

PH12 Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

<u>Mixing</u>



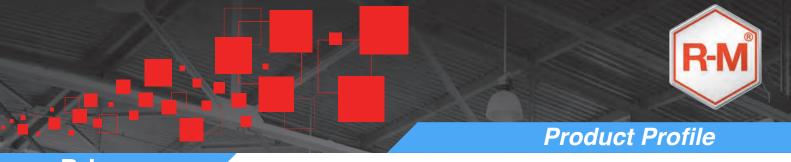
Mixing Ratio: 3:1:1:1

3 parts DP20 1 part DF21 1 part PH12 1 part UR Reducer

Pot Life of Mixed Product:

3 hours @ 20°C/68°F





Primers

Filling Primer

DP20 2K Urethane Primer-Filler

as a Primer-Filler on Flexible Parts

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 19-21 sec. #4 Ford cup

Thickness: 2 mils

Coverage: 270 sq ft/gal @ 2.0 mils VOC as Applied: 527 gms/ltr (4.4 lbs/gal)

Post Application



Drying:

20°C/68°F 3 hours 60°C/140°F 45 minutes 70°C/160°F 35 minutes

Sanding:

Wet Sand - 400 grit or finer Dry Sand - 320 grit or finer

Safety











Primers

Filling Primer

DP21 2K Color-It Primer

as a Primer-Filler

Product Details



DP21 2K Color-It Primer can be used as a wet-on-wet sealer or as a primer-filler. DP21 1K Color-It Primer MUST be mixed with Diamont or UNO HD before it can be used. Select a color that is similar in color to the topcoat being applied, this will result in a colored undercoat that is much easier to paint over. When used as a primer-filler, Diamont Basecoat or UNO HD can be applied over DP21 with excellent holdout. DP21 also can be used for painting flexible parts, with the addition of DF21.

Products:

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener PH60 Fast HS Hardener PH61 Medium HS Hardener

Reducers

UR30 Polar UR40 Fast 50-70 Single Panel UR50 Normal 70-85 Multi Panel UR60 Mid to Hot 80+ Multi Panel UR70 High Temp Overall Slow UR100 Retarder

<u>Mixing</u>



Mixing Ratio UNO HD:

Step 1 - 1:6

1 part UNO HD Tinting Base/Color 6 parts DP21

Start with tinting base/color and then add DP21.

Step 2 - 6:1:2

6 parts UNO HD/DP21 Mixture 1 part DH42, DH44, DH46 or DH47 2 parts UR Reducer Stir thoroughly prior to use.

Mixing Ratio Diamont:

Step 1 - 1:2

1 part Diamont Tinting Base/Color 2 parts DP21

Start with tinting base/color and then add DP21.

Step 2 - 4:1

4 parts Diamont/DP21 Mixture 1 part PH60 or PH61 No Reducer

Stir thoroughly prior to use.







Filling Primer

Primers

DP21 2K Color-It Primer

as a Primer-Filler

Mixing



Pot Life of Mixed Product:

2 hours @ 20°C/68°F

Product Tips:

Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat. Use the same topcoat product to tint DP21 as you will be using to paint the vehicle/part. If topcoating with Diamont, use Diamont to tint DP21.

If topcoating with UNO HD, use UNO HD to tint DP21.

Application



Apply 2 medium wet coats allowing 5 to 10 minutes flash between coats.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 2.0 mils

Diamont Tinted with BC200

- Coverage: 282 sq ft/gal @ 2.0 mils

VOC as Applied: 575 gms/ltr max. (4.8 lbs/gal)

UNO HD Tinted with SC25

- Coverage : 250 sq ft/gal @ 2.0 mils VOC as Applied : 575 gms/ltr (4.8 lbs/gal)

Post Application



Drying:

20°C/68°F 3 to 3.5 hours 60°C/140°F 25 to 30 minutes 70°C/160°F 20 to 25 minutes

Infra Red short wave 7 to 8 minutes when tinting with UNO HD Infra Red short wave 5 to 9 minutes when tinting with Diamont

Sanding:

Wet Sand - 400 to 600 grit
Dry Sand - 320 to 400 grit
Remove sanding residue with 900, 901, 909 or AM900.









Primers

Filling Primer

DP21 2K Color-It Primer

as a Primer-Filler on Flexible Parts

Product Details



DP21 2K Color-It Primer can be used as a wet-on-wet sealer or as a primer-filler. DP21 2K Color-It Primer MUST be mixed with Diamont or UNO HD before it can be used. Select a color that is similar in color to the topcoat being applied, this will result in a colored undercoat that is much easier to paint over. When used as a primer-sealer, Diamont Basecoat or UNO HD can be applied over DP21 with excellent holdout. DP21 also can be used for painting flexible parts, with the addition of DF21.

Mixing



Mixing Ratios: UNO HD

Step 1 - 1:2

1 part Diamont Tinting Base/Color 2 parts DP21

Start with the tinting base/color and then add DP21.

Step 2 - 3:1

3 parts DP21/Color mixture 1 part DF2

Step 3 - 4:1:1

4 parts DP21/Color/DF21 mixture 1 part PH60 or PH61 1 part UR Reducer

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

Fluid Tip (HE Gravity) 1.4-1.6 mm Fluid Tip (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity 18-20 sec. #4 Ford cup Thickness 1.0-1.5 mils

Diamont Tinted -Coverage 447 sq ft/gal @ 1.5 mils VOC as Applied 550 gms/ltr max. (4.6 lbs/gal)

UNO HD Tinted -Coverage 461 sq ft/gal @ 1.5 mils VOC as Applied 550 gms/ltr (4.6 lbs/gal)

Post Application



Drying:

20°C/68°F 3 hours 60°C/140°F 45 minutes 70°C/160°F 35 minutes

Sanding:

Wet Sand - 400 grit or finer Dry Sand - 320 grit or finer







Filling Primer

Primers

DP21 2K Color-It Primer

as a Primer-Filler on Flexible Parts

<u>Notes</u>	<u> </u>	

Safety











Primers

Filling Primer

DP22 2K Productive Primer

as a Primer-Filler

Product Details



DP22 2K Productive Primer is a two part urethane primer-filler. DP22 is the undercoat recommended under UNO HD Color, ONYX HD or Diamont Basecoat Color. DP22 can be applied over cured, cleaned and sanded OEM finishes, cured air dried finishes, treated bare metals, body filler and fiberglass. The primer dries in 90 minutes and sands very easily.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Flex Agents

DF21 Flex Agent

Mixing



Mixing Ratio - 4:1

4 parts DP22 1 part DH55, DH57 or DH59

Pot Life of Mixed Product:

40-60 minutes @ 20°C/68°F

Product Notes:

Use a guide coat to locate imperfections that need to be sanded out.

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.7 mm (HVLP Gravity) 1.5-1.7 mm

Tech Data:

Viscosity: 16-21 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 292 sq ft/gal @ 2.0 mils

VOC as Applied: 539 gms/ltr (4.5 lbs/gal)







Filling Primer

Primers

DP22 2K Productive Primer

as a Primer-Filler

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 30 to 40 minutes 70°C/160°F 25 to 35 minutes Infra Red short wave 8 to 10 minutes

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit Remove sanding residue with 909.

Flex Procedures

Flex Mixing



Mixing Ratio: 4:1:1

4 parts DP22 1 part DF21 1 part DH55, DH57 or DH59

Pot Life of Mixed Product:

1.5 hours @ 20°C/68°F

Product Tips:

The surface preparation is critical for the success of DP22 over plastic parts. 868 or 870 must be used over raw flexible plastics.

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.7 mm (HVLP Gravity) 1.5-1.7 mm

Tech Data:

Viscosity: 16-21 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 346 sq ft/gal @ 2.0 mils VOC as Applied: 491 gms/ltr (4.1 lbs/gal)





Primers

Filling Primer

DP22 2K Productive Primer

as a Primer-Filler on Flexible Parts

Flex Post Application



Drying:

20°C/68°F 3 hours

60°C/140°F 45 to 60 minutes 70°C/160°F 35 to 40 minutes

Sanding:

Wet Sand - 400 grit Dry Sand - 320 or finer grit

Notes	
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Safety











Primers

Filling Primer

DP25 Power Fill 2K Primer White

as a Primer-Filler

Product Details



DP25 Power Fill 2K Primer White is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area of any size on any type of substrate. Excellent adhesion and corrosion resistance on galvanized, aluminum, aluminum alloys, steel, old paint, plastics, fiberglass, SMC and body filler. When the DP Power Fill 2K Primer Series is used with PA20NB Low VOC Productive Primer Activator, it offers paint technicians exceptional dry times without the need for baking.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 4:1

4 parts DP25

1 part DH55, DH57 or DH59

High Speed Mixing Ratio: 3:1:1

3 parts DP25

1 part DH55 or DH57

1 part PA20NB

Pot Life of Mixed Product:

40 mins w/ DH55 @ 20°C/68°F 60 mins w/ DH57 @ 20°C/68°F 2 hours w/ DH59 @ 20°C/68°F with PA20NB 15-20 minutes @ 20°C/68°F

Product Tips:

Use the guide coat to locate imperfections that need to be sanded out. No need for any pretreatment primers, except for use on plastics.













Filling Primer

Primers

DP25 Power Fill 2K Primer White

as a Primer-Filler

Mixing (cont.)



Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP25	24.7	49.4	74.1	98.8	123.5	148.2	172.9	197.6
DH55 or DH57	5.8	11.6	17.4	23.2	29.0	34.8	40.6	46.4
PA20NB	7.5	15.0	22.5	30.0	37.5	45.0	52.5	60.0
	38	76	114	152	190	228	266	304
	grams							

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Color such as BC200 works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

High Speed Process - PA20NB

Viscosity: 19-22 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 285 sq ft/gal @ 2.0 mils

VOC as Applied: 515-533 gms/ltr (4.3-4.45 lbs/gal) with PA20NB 514-532 gms/ltr (4.3-4.4 lbs/gal)

Post Application



Drying:

20°C/68°F 75 to 90 minutes 15 to 20 minutes 60°C/140°F 30 minutes 10 minutes

Infra Red short wave 8 to 10 minutes N/A

Sanding:

Wet Sand - 400 to 600 grit

Dry Sand - 320 to 400 grit

Remove sanding residue with 900, 901, 909 or AM900.















Primers

Filling Primer

DP25 Power Fill 2K Primer White

as a Primer-Filler on Flexible Parts

Product Details



DP25 Power Fill 2K Primer is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area. DF21 is designed to give flexibility to DP Power Fill Primers.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Flex Agents

DF21 Flex Agent

Mixing



Mixing Ratio: 4:2:1

4 parts DP25 2 parts DH55, DH57 or DH59 1 part DF21

Pot Life of Mixed Product:

Pot Life 50 minutes with DH55 @ 20°C/68°F 60 minutes with DH57 @ 20°C/68°F 2 hours with DH59 @ 20°C/68°F

Application



Apply 2 to 3 medium wet coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 19-20 sec. #4 Ford cup

Thickness: 2-3 mils

Coverage: 621 sq ft/gal @ 1.0 mil

VOC as Applied: 504 gms/ltr (4.2 lbs/gal)













Filling Primer

Primers

DP25 Power Fill 2K Primer White

as a Primer-Filler on Flexible Parts

Post Application



Drying:

20°C/68°F 2 to 2.5 hours 60°C/140°F 30 minutes Infra Red short wave 8 to 10 minutes

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit

as a Wet-On-Wet Sealer on Flexible Parts

Product Details



DP25 Power Fill 2K Primer White is a fast curing, easy sanding primer that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area of any size on any type

> **UR30** Polar UR40 Fast

UR50 Normal

UR60 Mid to Hot

UR70 High Temp

UR100 Retarder

VR0 Exempt Slow

VR29 Exempt Fast

Products: Reducers

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

SM09 Flattener - Special MAT09 **Flex Agents**

of substrate. DF21 is designed to give flexibility to DP Power Fill Primers.

SC01 Base Booster SC10 Mixing Clear

DF21 Flex Agent

UNO HD Color







50-70 Single Panel

70-85 Multi Panel

80+ Multi Panel

Overall Slow









Primers

Filling Primer

DP25 Power Fill 2K Primer White

as a Primer-Filler on Flexible Parts

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Safety

















Primers

Filling Primer

DP26 Power Fill 2K Primer Grey

as a Primer-Filler

Product Details



DP26 Power Fill 2K Primer Grey is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area of any size on any type of substrate. Excellent adhesion and corrosion resistance on galvanized, aluminum, aluminum alloys, steel, old paint, plastics, fiberglass, SMC and body filler. When the DP Power Fill 2K Primer Series is used with PA20NB Low VOC Productive Primer Activator, it offers paint technicians exceptional dry times without the need for baking.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 4:1

4 parts DP26

1 part DH55, DH57 or DH59

High Speed Mixing Ratio: 3:1:1

3 parts DP26

1 part DH55 or DH57

1 part PA20NB

Pot Life of Mixed Product:

40 mins w/ DH55 @ 20°C/68°F 60 mins w/ DH57 @ 20°C/68°F 2 hours w/ DH59 @ 20°C/68°F with PA20NB 15-20 minutes @ 20°C/68°F

Product Tips:

Use the guide coat to locate imperfections that need to be sanded out. No need for any pretreatment primers, except for use on plastics.















Filling Primer

Primers

DP26 Power Fill 2K Primer Grey

as a Primer-Filler

Mixing (cont.)



Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP26	24.7	49.4	74.1	98.8	123.5	148.2	172.9	197.6
DH55 or DH57	5.8	11.6	17.4	23.2	29.0	34.8	40.6	46.4
PA20NB	7.5	15.0	22.5	30.0	37.5	45.0	52.5	60.0
	38	76	114	152	190	228	266	304
	grams							

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Color such as BC200 works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

High Speed Process - PA20NB

Viscosity: 19-22 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 285 sq ft/gal @ 2.0 mils

VOC as Applied: 515-533 gms/ltr (4.3-4.45 lbs/gal) with PA20NB 514-532 gms/ltr (4.3-4.4 lbs/gal)

Post Application



Drying:

20°C/68°F 75 to 90 minutes 15 to 20 minutes 60°C/140°F 30 minutes 10 minutes 15 to 20 minutes N/A

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit

Remove sanding residue with 900, 901, 909 or AM900.

















Primers

Filling Primer

DP26 Power Fill 2K Primer Grey

as a Primer-Filler on Flexible Parts

Product Details



DP26 Power Fill 2K Primer Grey is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area. DF21 is designed to give flexibility to DP Power Fill Primers.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Flex Agents

DF21 Flex Agent

Mixing



Mixing Ratio: 4:2:1

4 parts DP26 2 parts DH55, DH57 or DH59 1 part DF21

Pot Life of Mixed Product:

Pot Life 50 minutes with DH55 @ 20°C/68°F 60 minutes with DH57 @ 20°C/68°F 2 hours with DH59 @ 20°C/68°F

Application



Apply 2 to 3 medium wet coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 19-20 sec. #4 Ford cup

Thickness: 2-3 mils

Coverage: 621 sq ft/gal @ 1.0 mil

VOC as Applied: 504 gms/ltr (4.2 lbs/gal)















Filling Primer

Primers

DP26 Power Fill 2K Primer Grey

as a Primer-Filler on Flexible Parts

Post Application



Drying:

20°C/68°F 2 to 2.5 hours 60°C/140°F 30 minutes Infra Red short wave 8 to 10 minutes

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit

as a Wet-On-Wet Sealer on Flexible Parts

Product Details



DP26 Power Fill 2K Primer Grey is a fast curing, easy sanding primer that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area of any size on any type of substrate. DF21 is designed to give flexibility to DP Power Fill Primers.

Products:

Reducers

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

UF

UR30 Polar
UR40 Fast 50-70 Single Panel
UR50 Normal 70-85 Multi Panel
UR60 Mid to Hot 80+ Multi Panel
UR70 High Temp Overall Slow
UR100 Retarder
VR0 Exempt Slow

Flex Agents

DF21 Flex Agent

UNO HD Color

SM09 Flattener - Special MAT09

SC01 Base Booster SC10 Mixing Clear

VR29 Exempt Fast















Primers

Filling Primer

DP26 Power Fill 2K Primer Grey

as a Primer-Filler on Flexible Parts

Safety

















Primers

Filling Primer

DP27 Power Fill 2K Primer Black

as a Primer-Filler

Product Details



DP27 Power Fill 2K Primer Black is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area of any size on any type of substrate. Excellent adhesion and corrosion resistance on galvanized, aluminum, aluminum alloys, steel, old paint, plastics, fiberglass, SMC and body filler. When the DP Power Fill 2K Primer Series is used with PA20NB Low VOC Productive Primer Activator, it offers paint technicians exceptional dry times without the need for baking.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 4:1

4 parts DP27

1 part DH55, DH57 or DH59

High Speed Mixing Ratio: 3:1:1

3 parts DP27 1 part DH55 or DH57 1 part PA20NB

Pot Life of Mixed Product:

40 mins w/ DH55 @ 20°C/68°F 60 mins w/ DH57 @ 20°C/68°F 2 hours w/ DH59 @ 20°C/68°F with PA20NB 15-20 minutes @ 20°C/68°F

Product Tips:

Use the guide coat to locate imperfections that need to be sanded out. No need for any pretreatment primers, except for use on plastics.













Filling Primer

Primers

DP27 Power Fill 2K Primer Black

as a Primer-Filler

Mixing (cont.)



Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP27	24.7	49.4	74.1	98.8	123.5	148.2	172.9	197.6
DH55 or DH57	5.8	11.6	17.4	23.2	29.0	34.8	40.6	46.4
PA20NB	7.5	15.0	22.5	30.0	37.5	45.0	52.5	60.0
	38	76	114	152	190	228	266	304
	grams							

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Color such as BC200 works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 19-22 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 285 sq ft/gal @ 2.0 mils

VOC as Applied: 515-533 gms/ltr (4.3-4.45 lbs/gal) with PA20NB 514-532 gms/ltr (4.3-4.4 lbs/gal)

Post Application



Drying:

High Speed Process - PA20NB 20°C/68°F 75 to 90 minutes 15 to 20 minutes 60°C/140°F 30 minutes 10 minutes

Infra Red short wave 8 to 10 minutes N/A

Sanding:

Wet Sand - 400 to 600 grit

Dry Sand - 320 to 400 grit

Remove sanding residue with 900, 901, 909 or AM900.













Primers

Filling Primer

DP27 Power Fill 2K Primer Black

as a Primer-Filler on Flexible Parts

Product Details



DP27 Power Fill 2K Primer Black is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area. DF21 is designed to give flexibility to DP Power Fill Primers.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Flex Agents

DF21 Flex Agent

Mixing



Mixing Ratio: 4:2:1

4 parts DP27 2 parts DH55, DH57 or DH59 1 part DF21

Pot Life of Mixed Product:

Pot Life 50 minutes with DH55 @ 20°C/68°F 60 minutes with DH57 @ 20°C/68°F 2 hours with DH59 @ 20°C/68°F

Application



Apply 2 to 3 medium wet coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 19-20 sec. #4 Ford cup

Thickness: 2-3 mils

Coverage: 621 sq ft/gal @ 1.0 mil

VOC as Applied: 504 gms/ltr (4.2 lbs/gal)











DP27 Power Fill 2K Primer Black

as a Primer-Filler on Flexible Parts

Post Application



Drying:

20°C/68°F 2 to 2.5 hours 60°C/140°F 30 minutes Infra Red short wave 8 to 10 minutes

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit

as a Wet-On-Wet Sealer on Flexible Parts

Product Details



DP27 Power Fill 2K Primer Black is a fast curing, easy sanding primer that provide ease of handling from mixing to spraying to sanding. Fast in air dry applications and excellent when baked. Excellent sag resistance and leveling provide an easily prepared repair area of any size on any type of substrate. DF21 is designed to give flexibility to DP Power Fill Primers.

Products:

Reducers

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

UR30 Polar UR40 Fast **UR50 Normal** UR60 Mid to Hot UR70 High Temp Overall Slow **UR100** Retarder **VR0 Exempt Slow**

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel

Flex Agents

DF21 Flex Agent

SM09 Flattener - Special MAT09

SC01 Base Booster SC10 Mixing Clear

VR29 Exempt Fast















Primers

Filling Primer

DP27 Power Fill 2K Primer Black

as a Primer-Filler on Flexible Parts

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Safety

















Primers

Corrosion Restoring Undercoat

EP569 Gray Chromate Free Epoxy Primer

as a Precoat

Product Details



EP569 Gray Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP569 1 part PA897

1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr

(4.7-4.8 lbs/gal)









Corrosion Restoring Undercoat

Primers

EP569 Gray Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Primer-Filler

Product Details



EP569 Gray Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1:1

4 parts EP569 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat or use AM210 Aero-Max Satin Black.











Primers

Corrosion Restoring Undercoat

EP569 Gray Chromate Free Epoxy Primer

as a Primer-Filler

Application (cont.)



Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 337 sq ft/gal @ 2.0 mils VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 8 to 10 hours 60°C/140°F 30 minutes 70°C/160°F 20 minutes Infra Red short wave 10 to 13 minutes

Sanding:

Wet Sand - 400 to 600 grit
Dry Sand - 320 to 400 grit
Remove sanding residue with 900, 901, 909 or AM900.

<u>Safety</u>













Primers

Corrosion Restoring Undercoat

EP669 White Chromate Free Epoxy Primer

as a Precoat

Product Details



EP669 White Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP669 1 part PA897

1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr (4.7-4.8 lbs/gal)









Corrosion Restoring Undercoat

Primers

EP669 White Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Primer-Filler

Product Details



EP669 White Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1:1

4 parts EP669 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

<u>Application</u>



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat or use AM210 Aero-Max Satin Black.











Primers

Corrosion Restoring Undercoat

EP669 White Chromate Free Epoxy Primer

as a Primer-Filler

Application (cont.)



Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 337 sq ft/gal @ 2.0 mils VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 8 to 10 hours 60°C/140°F 30 minutes 70°C/160°F 20 minutes Infra Red short wave 10 to 13 minutes

Sanding:

Wet Sand - 400 to 600 grit
Dry Sand - 320 to 400 grit
Remove sanding residue with 900, 901, 909 or AM900.

<u>Safety</u>















Primers

Corrosion Restoring Undercoat

EP769 Black Chromate Free Epoxy Primer

as a Precoat

Product Details



EP769 Black Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals.

EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activatedwith PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP769 1 part PA897

1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr (4.7-4.8 lbs/gal)











Corrosion Restoring Undercoat

Primers

EP769 Black Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Primer-Filler

Product Details



EP769 Black Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1:1

4 parts EP769 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat or use AM210 Aero-Max Satin Black.













Primers

Corrosion Restoring Undercoat

EP769 Black Chromate Free Epoxy Primer

as a Primer-Filler

Application (cont.)



Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 337 sq ft/gal @ 2.0 mils VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 8 to 10 hours 60°C/140°F 30 minutes 70°C/160°F 20 minutes Infra Red short wave 10 to 13 minutes

Sanding:

Wet Sand - 400 to 600 grit
Dry Sand - 320 to 400 grit
Remove sanding residue with 900, 901, 909 or AM900.

<u>Safety</u>

















Primers

Corrosion Restoring Undercoat

EP869 Red Chromate Free Epoxy Primer

as a Precoat

Product Details



EP869 Red Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals.

EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activatedwith PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP869

1 part PA897

1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

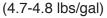
(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr











Corrosion Restoring Undercoat

Primers

EP869 Red Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Primer-Filler

Product Details



EP869 Red Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals.

EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1:1

4 parts EP869 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

<u>Application</u>



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat or use AM210 Aero-Max Satin Black.











Primers

Corrosion Restoring Undercoat

EP869 Red Chromate Free Epoxy Primer

as a Primer-Filler

Application (cont.)



Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 337 sq ft/gal @ 2.0 mils VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 8 to 10 hours 60°C/140°F 30 minutes 70°C/160°F 20 minutes Infra Red short wave 10 to 13 minutes

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit

Remove sanding residue with 900, 901, 909 or AM900.

Safety













Primers

Filling Primer / Specialty Product

NP80 Non-Isocyanate Primer

as a High-Build Primer

Product Details



NP80 is an isocyanate-free, 2 component primer/filler. NP80 offers high build, excellent topcoat holdout and dries quickly to a tough chemically resistant primer. Must activate with PA80 Non-Isocyanate Activator. All R-M topcoats can be used over NP80.

Products:

Activators

PA80 Activator

Mixing



Mixing Ratio - 2:1

2 parts NP80 1 part PA80

Pot Life of Mixed Product:

2 hours @ 20°C/68°F

Product Tips:

Use the guide coat to locate imperfections that need to be sanded out.

Application



Apply 2 to 3 medium coats allowing 5 to 10 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 19-21 sec. #4 Ford cup Thickness: 2.0-3.0 mils Coverage 279 sq ft/gal @ 2.0 mils VOC as Applied 575 gms/ltr (4.8 lbs/gal)







Filling Primer / Specialty Product

Primers

NP80 Non-Isocyanate Primer

as a High-Build Primer

Post Application



Drying:

20°C/68°F 2 hours 60°C/140°F 30 minutes 70°C/160°F 25 minutes

Infra Red short wave 9 to 10 minutes

Sanding:

Wet Sand - 400 to 600 grit
Dry Sand - 320 to 400 grit
Remove sanding residue with 900, 901, 909 or AM900.

Notes

Safety









Primers

Corrosion Restoring Undercoat / Filling Primer

Polyuroxy® Primer

as a Primer-Filler

Product Details



Polyuroxy Primer is a unique product, combining the properties of both epoxy and urethane into one easy to use package. Polyuroxy is a 3-component primer using epoxy for direct to metal performance and urethanes for their durability and speed. Polyuroxy can be applied over all bare metals including CRS, galvanized, zinc and aluminum. Polyuroxy can be sprayed as a high build primer-filler or as a wet-on-wet sealer depending upon mix ratio. All R-M topcoats can be used over Polyuroxy Primer.

Products:

Hardeners

DH46 Normal Hardener (ONLY)

Mixing



Mixing Ratio: 4:2:1

4 parts EP569, EP669, EP769 or EP869 2 parts UA97 1 part DH46

Pot Life of MIxed Product:

2 hours @ 20°C/68°F

Application



Apply 2 to 3 medium coats allowing 5 minutes flash between coats.

Product Tip:

Use the guide coat to locate imperfections that need to be sanded out.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.5-1.7 mm

Tech Data:

Viscosity: 14 sec. #4 Ford cup

Thickness: 2.5-3.0 mils

Coverage: 301 sq ft/gal @ 2 mils

VOC as Applied: 527 gms/ltr (4.4 lbs/gal)





Corrosion Restoring Undercoat / Filling Primer

Primers

Polyuroxy® Primer

as a Primer-Filler

Post Application



Drying: 20°C/68°F

20°C/68°F 3 hours 60°C/140°F 30 minutes

Infra Red short wave 8 to 10 minutes

Sanding:

Wet Sand - 400 to 600 grit Dry Sand - 320 to 400 grit Remove sanding residue with 900, 901, 909 or AM900.

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Safety











Primers

Corrosion Restoring Undercoat

DE17 Chromate Free Etch Primer

as a Pretreatment Primer

Product Details



DE17 Chromate Free Etch Primer is a non-chromated two part universal pretreatment primer for use under R-M 2K Primers. DE17 offers excellent adhesion and corrosion protection when used as a pretreatment primer over steel, aluminum, zinc or galvanized metals. DE17 must be mixed with DA17 Etch Primer Activator prior to use.

Products:

Activators

DA17 Etch Primer Activator

Primers

DP20 2K Urethane Primer-Filler DP21 2K Color-It Primer DP22 2K Productive Primer DP31 Power Fill 2K Sealer Grey DP200 Exempt Low VOC 2K Primer

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio National Rule 1:1:30%

100 parts DE17 100 parts DA17 30 parts UR Reducer

Mixing Ratio Low VOC 1:1:150%

100 parts DE17 100 parts DA17 150 parts VR Reducer

Pot Life of Mixed Product:

Pot Life: 48 hours @ 20°C/68°F

Product Tip:

Do not apply polyester body fillers over etching products.







Corrosion Restoring Undercoat

Primers

DE17 Chromate Free Etch Primer

as a Pretreatment Primer

Application



Apply 1 light coat over all bare metal areas

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Pot Life of Mixed Product:

48 hrs. @ 20°C/68°F

Tech Data:

Viscosity: 18-20 sec. #4 Ford cup Thickness: 0.25-0.5 mils

Coverage: 434 sq ft/gal @ 0.5 mil

VOC as Applied:

National Rule 690 gms/ltr (5.8 lbs/gal) Low VOC 660 gms/ltr (5.5 lbs/gal)

Post Application



Drying:

20°C/68°F 10 to 15 minutes (Before applying R-M 2K Primers)

Notes



Safety











Primers

Specialty Product

DP100 Low VOC 1K Waterborne Primer

as a Primer-Filler

Product Details



DP100 Low VOC 1K Waterborne Primer is a waterborne primer-filler. DP100 is recommended under Diamont, ONYX HD and UNO HD topcoats. DP100 can be applied over cured, cleaned and sanded OEM finishes; cured air dried finishes; large areas of bare steel, aluminum, galvanized steel that have been coated with EP Series primers as a pretreatment; and fiberglass.

Products:

Reducers

HB020 Hydromix

Mixing



Mixing Ratio - 1:10%

1 part DP100 10% HB020

Pot Life of Mixed Product:

7 days

Product Tips:

- Use the guide coat to locate imperfections that need to be sanded out.
- Do not apply DP100 directly over body fillers, or use body fillers directly over DP100. Shelf life is 18 months.

Application



Apply 2 medium wet coats allowing 5 to 10 minutes flash between coats or until matte

Spray Pressure:

(HVLP/HE) 10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 25-35 sec. #4 Ford cup Thickness: 1.6-2.4 mils

Coverage 297 sq ft/gal @ 2.0 mils VOC as Applied 180 gms/ltr (1.5 lbs/gal)







Specialty Product

Primers

DP100 Low VOC 1K Waterborne Primer

as a Primer-Filler

Post Application



Notes

Drying:

20°C/68°F 2 hours at 50% relative humidity 60°C/140°F 30 minutes Infra Red short wave 3 to 5 minutes Infra Red medium wave 15 to 20 minutes

Sanding:

Dry Sand - 320 to 400 grit

· Clean with 909 Final Wipe or deionized water.

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Safety











Primers

Filling Primer

DP200 Exempt Low VOC 2K Primer

as a Primer-Filler

Product Details



DP200 is a 250 gms/ltr (2.1 lbs/gal) solventborne primer which exhibits extremely fast filling and sanding characteristics. DP200 is a high solids urethane primer that dries quickly to a hard chemically resistant finish. DP200 is recommended under UNO HD, ONYX HD and Diamont topcoats. PA20NB may be used to significantly speed up sanding time in DP200.

Products:

Hardeners

PH10 Spot Repair Hardener PH20 Medium Hardener

Primers

DE17 Chromate Free Etch Primer

Activators

PA20NB Low VOC Productive Primer Activator

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 4:1:1

4 parts DP200

1 part PH10 or PH20

1 part VR Reducer

High Speed Mixing Ratio: 3:1:1

3 parts DP200

1 part PH10

1 part PA20NB

Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP200	29.9	59.9	89.8	119.7	149.6	179.6	209.5	239.4
PH10	6.9	13.7	20.6	27.5	34.4	41.2	48.1	55.0
PA20NB	7.5	15.0	22.5	30.0	37.5	45.0	52.5	60.0
	44.3	88.6	132.9	177.2	221.5	265.8	310.1	354.4
	grams							



30 to 45 minutes @ 20°C/68°F with PA20NB 15 to 20 minutes @ 20°C/68°F







Filling Primer

Primers

DP200 Exempt Low VOC 2K Primer

as a Primer-Filler

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color

Spray Pressure:

8-10 psi at air cap

Fluid Tip:

(HE/HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Coat Thickness: 2 to 3 medium wet coats

Coverage: 314 sq ft/gal @ 2.0 mils

VOC as Applied: 250 gms/ltr (2.1 lbs/gal) with PA20NB

240 gms/ltr (2.0 lbs/gal)

Post Application



Drying:

High Speed Process - PA20NB

20°C/68°F 90 minutes 15 to 20 minutes

60°C/140°F 30 minutes 10 minutes

Infra Red short wave 5 to 7 minutes N/A

Sanding:

Wet Sand - 320 to 400 grit Dry Sand - 320 to 400 grit

Remove sanding residue with 900, 901, 909 or AM900.

Notes











Primers

Filling Primer

DP200 Exempt Low VOC 2K Primer

as a Primer-Filler on Flexible Parts

Flex Product Details



DP200 is a 2.1 lbs/gal solventborne primer which exhibits extremely fast filling and sanding characteristics. DP200 is a high solids urethane primer that dries quickly to a hard chemically resistant finish. DP200 is recommended under UNO HD, ONYX HD and Diamont topcoats

Flex Mixing



Step 1 - 4:1

4 parts DP200 1 part DF21 Step 2 - 4:1:1

4 parts DP200/DF21 mixture 1 part PH10 or PH20 1 part VR Reducer

Pot Life of Mixed Product:

30 to 45 minutes @ 20°C/68°F

Application



Apply 2 medium wet coats allowing 5 minutes flash between coats

Spray Pressure:

8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP gravity) 1.5-1.7 mm

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Coat Thickness: 2.0 mils

Coverage: 332 sq ft/gal @ 2.0 mils

VOC as Applied

250 gms/ltr (2.1 lbs/gal)







Filling Primer

Primers

DP200 Exempt Low VOC 2K Primer

as a Primer-Filler on Flexible Parts

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Sanding:

Wet Sand - 400 grit or finer Dry Sand - 320 grit or finer Remove sanding residue with 902, 909 or AM902.

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Safety









Primers

Filling Primer

DP226 Dark Gray Low VOC DTM Primer

as a Primer-Filler

Product Details



DP226 is a fast curing, VOC compliant easy sanding primer that offers excellent sanding. The primer is exceptional when baked or cured by infrared lamps. Excellent sag resistance and leveling. Provides good topcoat holdout and invisible repairs. Good adhesion on substrates such as galvanized, aluminum, steel, old paint, plastic, fiberglass, SMC, body filler. DP226 when used with PA20NB Low VOC Productive Primer Activator offers paint technicians exceptional dry times without the need for baking.

Products:

Hardeners

PH10 Spot Repair Hardener PH20 Medium Hardener

Flex Agents

DF21 Flex Agent

Activators

PA20NB Low VOC Productive Primer Activator

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 4:1:1

4 parts DP226

1 part PH10 or PH20 1 part VR Reducer

High Speed Mixing Ratio: 3:1:1

3 parts DP226 1 part PH10 1 part PA20NB

Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP226	29.2	58.5	87.7	117.0	146.2	175.5	204.7	234.0
PH10	6.9	13.7	20.6	27.5	34.3	41.2	48.1	54.9
PA20NB	7.5	15.0	22.5	29.9	37.5	44.9	52.4	59.9
	43.6	87.2	130.8	174.4	218.0	261.6	305.2	348.8
	grams							

Pot Life of Mixed Product:

1.5 to 2 hours @ 20°C/68°F with PA20NB 15 to 20 minutes @ 20°C/68°F

Product Tip:

The surface preparation is critical for the success of DP226.





Filling Primer

Primers

DP226 Dark Gray Low VOC DTM Primer

as a Primer-Filler

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats

Spray Pressure:

8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.5-1.7 mm **Tech Data:**

Viscosity: 13-15 sec. #4 Ford cup

Thickness: 3.0-4.0 mils

Coverage: 317 sq ft/gal @ 2.0 mils VOC as Applied: 216 gms/ltr (1.8 lbs/gal) with PA20NB 181 gms/ltr (1.5 lbs/gal)

Post Application



Drying:

High Speed Process - PA20NB

20°C/68°F 90 minutes 15 to 20 minutes

60°C/140°F 20 minutes 10 minutes

Infra Red short wave 5 to 7 minutes N/A

Sanding:

Wet Sand - 320 to 500 grit Dry Sand - 320 to 500 grit Remove sanding residue with AM900 or 909.

Check your local VOC regulations to determine which R-M cleaners

are compliant in your area.

Notes









Primers

Filling Primer

DP226 Dark Gray Low VOC DTM Primer

as a Primer-Filler on Flexible Parts

Product Details



DP226 is a fast curing, VOC compliant easy sanding primer that offers excellent sanding. The primer is exceptional when baked or cured by infrared lamps. Excellent sag resistance and leveling. Provides good topcoat holdout and invisible repairs.

Mixing



Mixing Ratio Step 1 - 4:1

4 parts DP226 1 part DF21 Step 2 - 4:1:1

4 parts DP226/DF21 mixture 1 part PH10 or PH20 1 part VR Reducer

Pot Life of Mixed Product:

1.5 hours @ 20°C/68°F

Product Tip:

The surface preparation is critical for the success of DP226 over plastic parts. 868, 869 or 870 must be used over raw flexible plastics.

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats

Spray Pressure:

8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.5-1.7 mm

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Thickness: 2.0 mils

Coverage: 346 sq ft/gal@ 2.0 mils VOC as Applied: 240 gms/ltr (2.0 lbs/gal)





Filling Primer

Primers

DP226 Dark Gray Low VOC DTM Primer

as a Primer-Filler on Flexible Parts

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Sanding:

Wet Sand - 400 grit or finer Dry Sand - 320 grit or finer

Notes

Safety









Primers

Filling Primer

DP236 White Low VOC DTM Primer

as a Primer-Surfacer in Non-compliant areas

Product Details



DP236 is a fast curing primer that offers excellent sanding and reasonably long potlife. The primer is exceptional when baked or cured by infrared lamps. Excellent sag resistance and leveling. Provides good topcoat holdout and invisible repairs. Good adhesion on substrates such as galvanized, aluminum, steel, old paint, plastic, fiberglass, SMC, body filler, etc.

Products:

Hardeners

RMH94 Low VOC Fast Hardener RMH96 Low VOC Medium Hardener RMH98 Low VOC Slow Hardener

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 4:1:10%

4 parts DP236 1 part RMH94, RMH96 or RMH98 10% UR Reducer

Reduction may go up one additional part

Pot Life of Mixed Product:

60 minutes @ 20°C/68°F

Pot Life of Mixed Product:

The surface preparation is critical for the success of DP236.









Filling Primer

Primers

DP236 White Low VOC DTM Primer

as a Primer-Sealer in Non-compliant areas

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.5-1.7 mm **Tech Data:**

Viscosity: 14-16 sec. #4 Ford cup

Thickness: 3.0-4.0 mils

Coverage: 317 sq ft/gal @ 2.0 mils

VOC as Applied: 420 gms/ltr (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 20 minutes

Infra Red short wave 5 to 7 minutes

Sanding:

Wet Sand - 320 to 500 grit Dry Sand - 320 to 500 grit

Remove sanding residue with 901 or 909.

Check your local VOC regulations to determine which R-M cleaners are compliant in you area.

Notes











Primers

Filling Primer

DP236 White Low VOC DTM Primer

as a Primer-Sealer

Mixing



Mixing Ratio: 4:1:10%

High Speed Mixing Ratio: 3:1:1

4 parts DP236

1 part RMH94, RMH96 or RMH98

10% VR Reducer

3 parts DP236 1 part RMH94

1 part PA20NB

Reduction may go up to 1 part

Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP236	27.7	55.2	82.8	110.4	138.3	166.0	193.6	221.2
RMH94	6.8	13.6	20.4	27.2	34.1	40.9	47.8	54.6
PA20NB	7.5	15.0	22.5	29.9	37.4	45.0	52.4	59.9
	42.0	83.8	125.6	167.5	209.8	251.9	293.8	335.7
	grams							

Application



Tech Data:

VOC as Applied 242 gms/ltr (1.9 lbs/gal)

Post Application



Drying:

20°C/68°F 50°C/120°F

60°C/140°F Infra Red short wave N/A 20 minutes

5 to 7 minutes

90 minutes

Drying High Speed Process PA20NB 20 to 30 minutes 20 minutes

N/A N/A









Filling Primer

Primers

DP236 White Low VOC DTM Primer

as a Primer-Sealer on Flexible Parts

Mixing



Mixing Ratio:

Step 1 - 4:1

4 parts DP236 1 part DF21

Pot Life of Mixed Product:

60 minutes @ 20°C/68°F

Tech Data:

VOC as Applied 223 gms/ltr (1.9 lbs/gal)

Step 2 - 4:1:1

4 parts DP236/DF21 mixture 1 part RMH94

1 part VR Reducer

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 20 minutes

Infra Red short wave 5 to 7 minutes

Safety













Primers

Filling Primer

DP237 Dark Gray Low VOC DTM Primer

as a Primer-Sealer in Non-compliant areas

Product Details



DP237 is a fast curing primer that offers excellent sanding and reasonably long potlife. The primer is exceptional when baked or cured by infrared lamps. Excellent sag resistance and leveling. Provides good topcoat holdout and invisible repairs. Good adhesion on substrates such as galvanized, aluminum, steel, old paint, plastic, fiberglass, SMC, body filler, etc.

Products:

Hardeners

RMH94 Low VOC Fast Hardener RMH96 Low VOC Medium Hardener RMH98 Low VOC Slow Hardener

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 4:1:10%

4 parts DP237 1 part RMH94, RMH96 or RMH98 10% UR Reducer

Reduction may go up one additional part

Pot Life of Mixed Product:

60 minutes @ 20°C/68°F

Product Tips:

The surface preparation is critical for the success of DP237.

Application



Apply 2 to 3 medium wet coats allowing 5 minutes flash between coats

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.5-1.7 mm









Filling Primer

Primers

DP237 Dark Gray Low VOC DTM Primer

as a Primer-Sealer in Non-compliant areas

Application (cont.)



Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Thickness: 3.0-4.0 mils

Coverage: 317 sq ft/gal @ 2.0 mils VOC as Applied: 420 gms/ltr (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 20 minutes Infra Red short wave 5 to 7 minutes

Sanding:

Wet Sand - 320 to 500 grit Dry Sand - 320 to 500 grit

Remove sanding residue with 901 or 909.

Check your local VOC regulations to determine which R-M cleaners are compliant in your area.

Notes











Primers

Filling Primer

DP237 Dark Gray Low VOC DTM Primer

as a Primer-Sealer

Mixing



Mixing Ratio: 4:1:10%

High Speed Mixing Ratio: 3:1:1

4 parts DP237

1 part RMH94, RMH96 or RMH98

10% VR Reducer

3 parts DP237 1 part RMH94

1 part PA20NB

Reduction may go up to 1 part

Mixing of small amounts for high speed process

	1 oz	2 oz	3 oz	4 oz	5 oz	6 oz	7 oz	8 oz
DP237	26.7	53.2	79.9	106.5	133.4	160.1	186.8	213.4
RMH94	6.8	13.6	20.4	27.2	34.1	40.9	47.8	54.6
PA20NB	7.5	15.0	22.4	29.9	37.4	45.0	52.4	59.9
	41.0	81.8	122.7	163.6	204.9	246.9	287.0	327.9
	grams							

Application



Tech Data:

VOC as Applied 242 gms/ltr (1.9 lbs/gal)

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 20 minutes Infra Red short wave 5 to 7 minutes

Sanding:

Wet Sand - 320 to 500 grit Dry Sand - 320 to 500 grit

Remove sanding residue with AM900 or 909.

Check your local VOC regulations to determine which R-M cleaners are compliant in your area.









Filling Primer

Primers

DP237 Dark Gray Low VOC DTM Primer

as a Primer-Sealer on Flexible Parts

Mixing



Mixing Ratio: 4:1

4 parts DP237 1 part DF21 High Speed Mixing Ratio: 3:1:1

4 parts DP237/DF21 mixture

1 part RMH94 1 part VR Reducer

Application



Tech Data:

Viscosity 13-15 sec. #4 Ford cup VOC as Applied 242 gms/ltr (1.9 lbs/gal)

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 20 minutes Infra Red short wave 5 to 7 minutes

Sanding:

Wet Sand - 320 to 500 grit Dry Sand - 320 to 500 grit

Remove sanding residue with 909 or AM902.

Check your local VOC regulations to determine which R-M cleaners are compliant in your area.









Primers

Filling Primer

DP237 Dark Gray Low VOC DTM Primer

as a Primer-Sealer on Flexible Parts

Safety













Primers

Corrosion Restoring Undercoat

EP369 Grey Epoxy Primer LVOC

as a Primer Filler



EP369 Grey Epoxy Primer LVOC is chromate-free and recommended for 340 gms/ltr (2.8 lbs/ gal) or 420 gms/ltr (3.5 lbs/gal) VOC topcoats like ONYX HD and UNO HD.

Products:

Activators

PA38 Low VOC Activator

Reducers

VR29 Low VOC Reducer

Mixing



Mixing Ratio: 4:1:1

4 parts EP369 1 part PA38 1 part VR29

Pot Life of Mixed Product:

8 hours @ 20°C/68°F

Application



Apply 2 medium wet coats allowing 5 to 10 minutes flash time between coats

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.6 mm (HVLP Gravity) 1.7 mm

Tech Data:

Viscosity: 18-24 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 400 sq ft/gal @ 2.0 mils VOC as Applied: 250 gms/ltr (2.0 lbs/gal)

Post Application



Drying:

20°C/68°F 8 to 12 hours to sand

Sanding:

320 to 600 grit depending on topcoat used. Remove sanding residue with 909 or AM900.











Corrosion Restoring Undercoat

Primers

EP369 Grey Epoxy Primer LVOC

as a Primer Filler

<u>Notes</u>		

Safety













Primers

Corrosion Restoring Undercoat / Filling Primer / Specialty Product

VP126 Flash Fill UV Primer Surfacer

as a Primer Surfacer

Product Details



VP126 Flash Fill UV Primer Surfacer is a one component, high build, UV curable primer for application over galvanized, aluminum alloys, steel, old paint, fiberglass, SMC, and body fillers. VP126 Flash Fill produces an easy to use, high build, fast automotive undercoat. It also has an excellent sag resistance and is easy to apply. The highly durable, solvent resistant film, is superior to many conventional acrylic polyurethane primers. No hardeners or reducer is needed. All R-M topcoats can be used over VP126.

Mixing



Ready to spray

Pot Life:

No pot life if not exposed to UV or visible light for an extended period of time

Application



Apply 1 to 2 wet coats allowing 1 to 2 minutes minimum flash between coats Allow 3 to 5 minutes minimum flash before UV curing

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.0-1.5 mm (HVLP Gravity) 1.0-1.5 mm

Tech Data:

Viscosity: 18-22 sec. #4 Ford cup Wet Film Thickness: 2.0-6.0 mils Dry Film Thickness: 1.5-5.0 mils Coverage: 511 sq ft/gal @ 2.0 mils VOC as Applied: 204 gms/ltr (1.7 lbs/gal)

Post Application



Drying:

UV cure with UVA lamp 3 - 10 inches away for 2 to 3 minutes

UV primer can be cured by sunlight.

- Exposure time is dependant on UV intensity (average time is 5 to 20 mins).
- Allow to flash before exposing to sunlight.
- · Surface cure will indicate extent of cure.
- Can not be cured in the rain.



















Corrosion Restoring Undercoat / Filling Primer / Specialty Product

Primers

VP126 Flash Fill UV Primer Surfacer

as a Primer-Filler

Post Application (cont.)



Sanding:

Can be sanded immediately after UV cure.

Sand with 320 to 500 grit paper.

- · Surface will be slightly tacky but can be sanded without wiping, and will not load sandpaper when wet sanded.
- If cleaning of the primer surface is desired prior to sanding, wipe surface with R-M 900, 901, 909 or AM900.

Product Tip: Film will build rapidly with this product.

Flex Procedures

Flex Mixing



Step - 4:1

4 parts VP126 1 part DF21

Step 2 - 4:1:2

4 parts DP323/DF21 mixture 1 part RMH94, RMH96 or RMH98 2 parts VR Reducer

Pot Life:

No pot life if not exposed to UV or visible light for an extended period of time

Application



Apply 1 to 2 wet coats allowing 1 to 2 minutes minimum flash between coats 3 to 5 minutes minimum flash before UV curing

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.0-1.5 mm (HVLP Gravity) 1.0-1.5 mm

Tech Data:

Viscosity: 24-28 sec. #4 Ford cup Wet Film Thickness: 2.0-6.0 mils Dry Film Thickness: 1.5-5.0 mils Coverage: 483 sq ft/gal @ 2.0 mils VOC as Applied: 264 gms/ltr (2.2 lbs/gal)



















Primers

Corrosion Restoring Undercoat / Filling Primer / Specialty Product

VP126 Flash Fill UV Primer Surfacer

as a Primer-Filler on Flexible Parts

Flex Post Application



Drying:

UV cure with UVA lamp 3 - 10 inches away for 2 to 3 minutes

UV primer can be cured by sunlight.

- Exposure time is dependant on UV intensity (average time is 5 to 20 mins).
- · Allow to flash before exposing to sunlight.
- · Surface cure will indicate extent of cure.
- · Can not be cured in the rain.

<u>Notes</u>		
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Safety



















Sealers

Sealers









R-M

EP369

DIBLE



R-M

EP569



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R-M

EP669



R-M

DS30

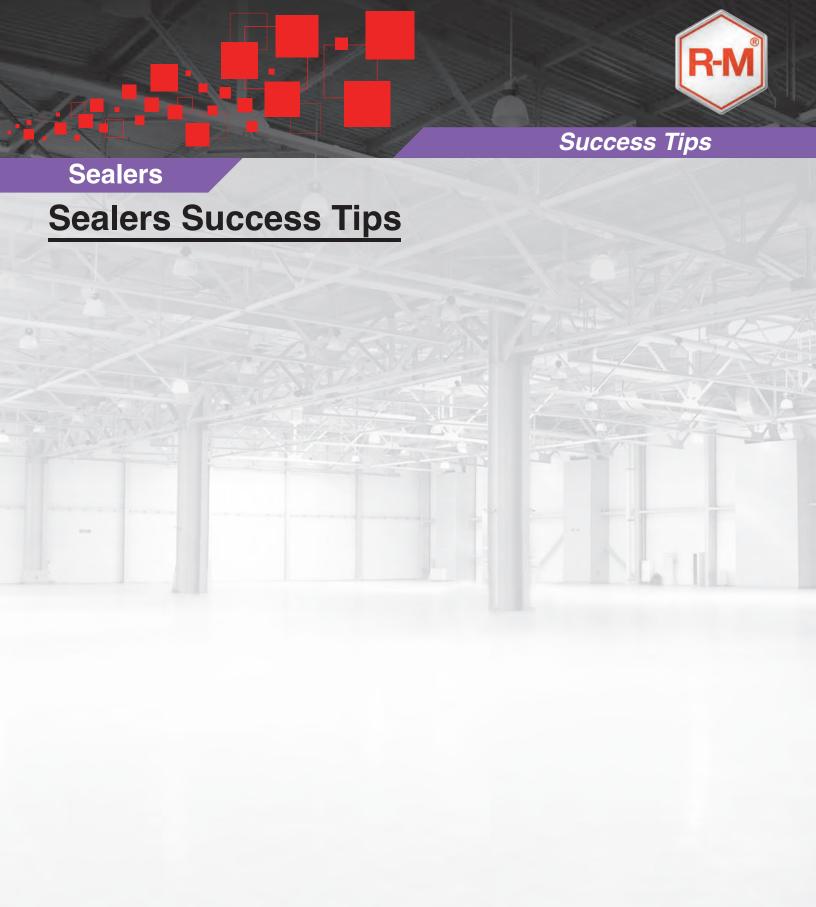
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Sealers

DP21 2K Color-It Primer

as a Wet-on-Wet Sealer

Product Details



DP21 2K Color-It Primer can be used as a wet-on-wet sealer or as a primer-surfacer. DP21 2K Color-It Primer MUST be mixed with Diamont or UNO HD before it can be used. Select a color that is similar in color to the topcoat being applied, this will result in a colored undercoat that is much easier to paint over. When used as a primer-sealer, Diamont Basecoat or UNO HD can be applied over DP21 with excellent holdout. DP21 also can be used for painting flexible parts, with the addition of DF21.

Mixing



Mixing Ratios: UNO HD

Step 1 - 1:3

1 part UNO HD Tinting Base/Color 3 parts DP21

Start with tinting base/color

and then add DP21.

Step 2 - 6:1:2

6 parts UNO HD/DP21 Mixture 1 part DH44, DH46 or DH47 2 parts UR Reducer

Stir thoroughly prior to use.

Mixing Ratios: Diamont

Step 1 - 1:2

1 part Diamont Tinting Base/Color 2 parts DP21

Start with tinting base/color and then add DP21.

Step 2 - 3:1:20%

3 parts Diamont/DP21 Mixture 1 part DH42, DH44, DH46 or DH47 20% UR Reducer

Stir thoroughly prior to use.

Pot Life of Mixed Product:

1 to 2 hours @ 20°C/68°F

Product Tips:

Use the same topcoat product to tint DP21 as you will be using to paint the vehicle/ part. If topcoating with Diamont, use Diamont to tint DP21. If topcoating with UNO HD, use UNO HD to tint DP21. When using inter-mixed color, Diamont ONLY, to tint DP21, the color should NOT be ready-for-use (no reducer). Apply 1 light coat of DE17, as a pretreatment primer or EP Series Epoxy Primer, as an anti-corrosion primer.







Sealers

DP21 2K Color-It Primer

as a Wet-on-Wet Sealer

Application



Apply 1 to 2 medium wet coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 18-20 sec. #4 Ford cup Thickness: 1.0-1.5 mils

Diamont Tinted with BC200 - Coverage: 447 sq ft/gal @ 1.5 mils VOC as Applied: 551 gms/ltr max. (4.6 lbs/gal)

UNO HD Tinted with SC25

- Coverage: 461 sq ft/gal @ 1.5 mils VOC as Applied: 551 gms/ltr (4.6 lbs/gal)

Post Application



Drying:

20°C/68°F 15 to 20 minutes Do not force dry.

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

Notes







Sealers

DP21 2K Color-It Primer

as a Wet-on-Wet Sealer on Flexible Parts

Flex Mixing



Diamont Mixing Ratio:

Step 1 - 1:1

1 part Diamont Tinting Base/Color 1 part DP21

Start with the tinting base/color and then add DP21

Step 2 - 5:1

5 parts DP21/Color mixture 1 part DF21

Step 3 - 4:2:1

4 parts DP21/Color/DF21 mixture 2 parts PH60 or PH61 1 part UR Reducer

UNO HD Mixing Ratio:

Step 1 - 3:1:20%

3 parts DP21 1 part UNO HD Tinting Base/Color 20% DF21

Start with the tinting base/color and then add DP21.

Step 2 - 6:1:2

6 parts DP21/UNO HD/DF21 mixture 1 part DH44, DH46 or DH47 2 parts UR Reducer

Pot Life:

3 hours @ 20°C/68°F

Product Tip:

Use the same topcoat product to tint DP21 as you will be using to paint the vehicle/part. If topcoating with Diamont, use Diamont to tint DP21. If topcoating with UNO HD, use UNO HD to tint DP21.

Flex Application



Apply 1 to 2 medium coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Thickness: 1.5 mils

Viscosity: 18-20 sec. #4 Ford cup Coverage: 440-460 sq ft/gal @ 1.5 mils VOC as Applied: 527 gms/liter (4.4 lbs/gal)







Sealers

DP21 2K Color-It Primer

as a Wet-on-Wet Sealer on Flexible Parts

<u>Notes</u>	
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Safety









Sealers

DP25 Power Fill 2K Primer White

as a Wet-n-Wet-Sealer

Product Details



DP25 Power Fill 2K Primer White is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. When used as a wet-on-wet sealer, DP Power Fill can be applied over most cured and sanded finishes such as original paintwork, fiberglass, SMC, body filler or any metal that has been properly pretreated. DP Power Fill 2K Primers used as a wet-on-wet sealer provide a durable and chemically resistant coating with excellent holdout for all R-M topcoat systems.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

<u>Mixing</u>



Mixing Ratio: 3:1:1:1

3 parts DP25

1 part UNO HD Tinting Base/Color

1 part DH55, DH57 or DH59

1 part VR Reducer

Pot Life of Mixed Product:

45 mins w/ DH57 @ 20°C/68°F 3 hrs w/ DH59 @ 20°C/68°F

Product Tips:

Need to use a pretreatment primer when using as a sealer over bare metal substrates.

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 15-20 sec. #4 Ford cup

Thickness: 1.0-1.5 mils

Coverage: 518 sq ft/gal @ 1.0 mil VOC as Applied 515 gms/ltr (4.3 lbs/gal)











Sealers

DP25 Power Fill 2K Primer White

as a Wet-On-Wet-Sealer

Post Application



Drying:

20°C/68°F 20 minutes Do not force dry.

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Wet-On-Wet-Sealer - Untinted

Product Details



DP25 Power Fill 2K Primer mixed as an untinted Wet-on-Wet sealer may be applied over most cured and sanded finishes such as original paintwork, fiberglass, SMC, body filler and most metal that has been properly pretreated. This primer sealer provides a quick and simple solution for production shops while maintaining a durable and chemically resistant coating with excellent holdout for all R-M topcoat systems.

Mixing



Mixing Ratio: 4:1:1

4 parts DP25

1 part DH55, DH57 or DH59

1 part VR Reducer

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 15-20 sec. #4 Ford cup

Thickness: 1.0-1.5 mils

Coverage: 518 sq ft/gal @ 1.0 mil

VOC as Applied: 515 gms/ltr (4.3 lbs/gal)













Sealers

DP25 Power Fill 2K Primer White

as a Wet-On-Wet Sealer on Flexible Parts

Mixing



Mixing Ratio - Step 1: 4:1

4 parts DP25 1 part DF21

Pot Life of Mixed Product:

3 hours with DH55@ 20°C/68°F 4 hours with DH57@ 20°C/68°F 5 hours with DH59@ 20°C/68°F

Step 2: 4:1:1

4 parts DP25/DF21 mixture 1 part DH55, DH57 or DH59 1 part VR Reducer

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 11-15 sec. #4 Ford cup

Thickness: 1 mil

Coverage: 518 sq ft/gal @ 1.0 mil VOC as Applied: 517 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 15 to 20 minutes Do not force dry.

Notes















DP25 Power Fill 2K Primer White

as a Wet-On-Wet Sealer on Flexible Parts

<u>Notes</u>	
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Safety















Sealers

DP26 Power Fill 2K Primer Grey

as a Wet-n-Wet-Sealer

Product Details



DP26 Power Fill 2K Primer Grey is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. When used as a wet-on-wet sealer, DP Power Fill can be applied over most cured and sanded finishes such as original paintwork, fiberglass, SMC, body filler or any metal that has been properly pretreated. DP Power Fill 2K Primers used as a wet-on-wet sealer provide a durable and chemically resistant coating with excellent holdout for all R-M topcoat systems.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 3:1:1:1

3 parts DP26

1 part UNO HD Tinting Base/Color

1 part DH55, DH57 or DH59

1 part VR Reducer

Pot Life of Mixed Product:

45 mins w/ DH57 @ 20°C/68°F 3 hrs w/ DH59 @ 20°C/68°F

Product Tips:

Need to use a pretreatment primer when using as a sealer over bare metal substrates.

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 15-20 sec. #4 Ford cup

Thickness: 1.0-1.5 mils

Coverage: 518 sq ft/gal @ 1.0 mil

VOC as Applied 515 gms/ltr (4.3 lbs/gal)











as a Wet-On-Wet-Sealer

Post Application



Drying:

20°C/68°F 20 minutes Do not force dry.

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Wet-On-Wet-Sealer - Untinted

Product Details



DP26 Power Fill 2K Primer Grey mixed as an untinted Wet-on-Wet sealer may be applied over most cured and sanded finishes such as original paintwork, fiberglass, SMC, body filler and most metal that has been properly pretreated. This primer sealer provides a quick and simple solution for production shops while maintaining a durable and chemically resistant coating with excellent holdout for all R-M topcoat systems.

Mixing



Mixing Ratio: 4:1:1

4 parts DP26

1 part DH55, DH57 or DH59

1 part VR Reducer

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 15-20 sec. #4 Ford cup

Thickness: 1.0-1.5 mils

Coverage: 518 sq ft/gal @ 1.0 mil

VOC as Applied: 515 gms/ltr (4.3 lbs/gal)















Sealers

DP26 Power Fill 2K Primer Grey

as a Wet-On-Wet Sealer on Flexible Parts

Mixing



Mixing Ratio - Step 1: 4:1

4 parts DP26 1 part DF21

Pot Life of Mixed Product:

3 hours with DH55@ 20°C/68°F 4 hours with DH57@ 20°C/68°F 5 hours with DH59@ 20°C/68°F

Step 2: 4:1:1

4 parts DP26/DF21 mixture 1 part DH55, DH57 or DH59 1 part VR Reducer

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 11-15 sec. #4 Ford cup

Thickness: 1 mil

Coverage: 518 sq ft/gal @ 1.0 mil VOC as Applied: 517 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 15 to 20 minutes Do not force dry.

Notes

















DP26 Power Fill 2K Primer Grey

as a Wet-On-Wet Sealer on Flexible Parts

<u>lotes</u>	

Safety

















Sealers

DP27 Power Fill 2K Primer Black

as a Wet-n-Wet-Sealer

Product Details



DP27 Power Fill 2K Primer Black is fast curing, easy sanding primers that provide ease of handling from mixing to spraying to sanding. When used as a wet-on-wet sealer, DP Power Fill can be applied over most cured and sanded finishes such as original paintwork, fiberglass, SMC, body filler or any metal that has been properly pretreated. DP Power Fill 2K Primers used as a wet-on-wet sealer provide a durable and chemically resistant coating with excellent holdout for all R-M topcoat systems.

Products:

Hardeners

DH55 Fast Hardener DH57 Normal Hardener DH59 Slow Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 3:1:1:1

3 parts DP27

1 part UNO HD Tinting Base/Color

1 part DH55, DH57 or DH59

1 part VR Reducer

Pot Life of Mixed Product:

45 mins w/ DH57 @ 20°C/68°F 3 hrs w/ DH59 @ 20°C/68°F

Product Tips:

Need to use a pretreatment primer when using as a sealer over bare metal substrates.

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 15-20 sec. #4 Ford cup

Thickness: 1.0-1.5 mils

Coverage: 518 sq ft/gal @ 1.0 mil VOC as Applied 515 gms/ltr (4.3 lbs/gal)









as a Wet-On-Wet-Sealer

Post Application



Drying:

20°C/68°F 20 minutes Do not force dry.

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Wet-On-Wet-Sealer - Untinted

Product Details



DP27 Power Fill 2K Primer Black mixed as an untinted Wet-on-Wet sealer may be applied over most cured and sanded finishes such as original paintwork, fiberglass, SMC, body filler and most metal that has been properly pretreated. This primer sealer provides a quick and simple solution for production shops while maintaining a durable and chemically resistant coating with excellent holdout for all R-M topcoat systems.

Mixing



Mixing Ratio: 4:1:1

- 4 parts DP27
- 1 part DH55, DH57 or DH59
- 1 part VR Reducer

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 15-20 sec. #4 Ford cup

Thickness: 1.0-1.5 mils

Coverage: 518 sq ft/gal @ 1.0 mil

VOC as Applied: 515 gms/ltr (4.3 lbs/gal)













Sealers

DP27 Power Fill 2K Primer Black

as a Wet-On-Wet Sealer on Flexible Parts

Mixing



Mixing Ratio - Step 1: 4:1

4 parts DP27 1 part DF21

Pot Life of Mixed Product:

3 hours with DH55@ 20°C/68°F 4 hours with DH57@ 20°C/68°F 5 hours with DH59@ 20°C/68°F

Step 2: 4:1:1

4 parts DP27/DF21 mixture 1 part DH55, DH57 or DH59 1 part VR Reducer

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.9 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 11-15 sec. #4 Ford cup

Thickness: 1 mil

Coverage: 518 sq ft/gal @ 1.0 mil VOC as Applied: 517 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 15 to 20 minutes Do not force dry.

<u>Notes</u>















DP27 Power Fill 2K Primer Black

as a Wet-On-Wet Sealer on Flexible Parts

<u>Notes</u>	<u>3</u>	

Safety















DP31 Power Fill 2K Sealer Gray

as a Wet-On-Wet Sealer

Product Details



DP31 is a wet-on-wet sealer that provides exceptional hold out, dries to a GLOSSY finish and provides a smooth surface for Diamont, UNO HD or ONYX HD topcoats. DP31 can be tinted with either Diamont, UNO HD or ONYX HD bases. DP31 may be applied over cured and sanded air dry finishes, properly sanded OEM finishes, properly prepared bare metal, fiberglass and body fillers. Aluminum substrates must be properly treated before DP31 is applied.

Do not use ready for use Diamont, UNO HD or ONYX HD colors due to VOC regulations.

Products:

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Untinted Mixing Ratio: 4:1:2

4 parts DP31 1 part DH42, DH44 or DH46 2 parts UR or VR Reducer

Tinted with Diamont: 4:1:1:1

4 parts DP31

1 part Diamont Tinting Base/Color

1 part DH42, DH44 or DH46

1 part UR Reducer

Tinted with ONYX HD: 6:1 / 4:1:2

Step 1 - 6:1

6 parts DP31

1 part ONYX HD Tinting Base/Color

Step 2 - 4:1:2

4 parts DP31/ONYX HD mixture

1 part DH42, DH44 or DH46

2 parts UR or VR Reducer











Sealers

DP31 Power Fill 2K Sealer Gray

as a Wet-On-Wet Sealer

Mixing (cont.)



Tinted with UNO HD: 3:1:1:2

3 parts DP31

1 part UNO HD Tinting Base/Color

1 part DH42, DH44 or DH46

2 parts UR or VR Reducer

Pot Life:

45 to 60 minutes @ 20°C/68°F

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.5-1.7 mm (HVLP Gravity) 1.3-1.5 mm

VOC as Applied:

Untinted 539 gms/liter (4.5 lbs/gal)
Tinted with Diamont 550 gms/liter (4.6 lbs/gal)

Tinted with UNO HD

UR Reducers: 550 gms/liter (4.6 lbs/gal) VR Reducers: 419 gms/liter (3.5 lbs/gal)

Tinted with ONYX HD

UR Reducers: 550 gms/liter (4.6 lbs/gal) VR Reducers: 420 gms/liter (3.5 lbs/gal)

Drying:

20°C/68°F 15 to 20 minutes - Do not force dry.

Tech Data:

Viscosity: 15-18 sec. #4 Ford cup

Thickness: 1.0-1.5 mils

Coverage:

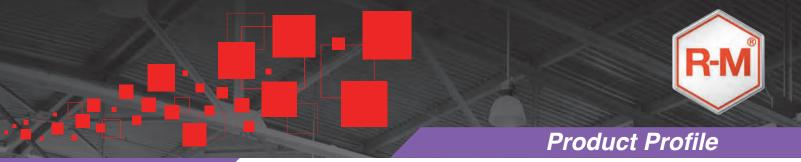
Untinted 589 sq ft/gal Tinted with Diamont 447 sq ft/gal Tinted with UNO HD 461 sq ft/gal Tinted with ONYX HD 561 sq ft/gal











Sealers

DP31 Power Fill 2K Sealer Gray

as a Wet-On-Wet Sealer on Flexible Parts

Flex Product Details



DP31 is a wet-on-wet sealer that provides exceptional hold out, dries to a GLOSSY finish and provides a smooth surface for Diamont, UNO HD or ONYX HD topcoats. DP31 can be tinted with either Diamont, UNO HD or ONYX HD bases. **Do not use ready for use Diamont, UNO HD or ONYX HD colors due to VOC regulations.** DF21 is designed to give flexibility to DP Power Fill Primers.

Products:

Hardeners

DH42 Rapid Hardener DH44 Mediuml Hardener DH46 Normal Hardener

Flex Additives

DF21 Flex Additive

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Flex Mixing



Untinted Flexed: 4:1:1:2

4 parts DP31 1 part DF21

1 part DH42, DH44 or DH46

2 parts UR or VR Reducer

UNO HD Tinted - Flexed: 3:1 / 4:1:1:2

Step 1 - 6:1

3 parts DP31

1 part UNO HD Tinting Base/Color

Step 2 - 4:1:2

4 parts DP31/UNO HD mixture

1 part DF21

1 part DH42, DH44 or DH46

2 parts UR or VR Reducer









Flex Mixing (cont.)



Diamont Tinted - Flexed: 4:1 / 4:1:1:1

Step 1 - 4:1

4 parts DP31

1 part Diamont Tinting Base/Color

Step 2 - 4:1:1:1

4 parts DP31/Diamont mixture

1 part DF21

1 part DH42, DH44 or DH46

1 part UR Reducer

ONYX Tinted - Flexed: 6:1 / 5:1 / 4:1:2

Step 1 - 6:1

6 parts DP31

1 part ONYX HD Tinting Base/Color

Step 2 - 5:1

5 parts DP31/ONYX HD mixture

1 part DF21

Step 3 - 4:1:2

4 parts DP31/ONYX HD/DF21 mixture

1 part DH42, DH44 or DH46

2 parts VR Reducer

Pot Life of Mixed Product:

45 to 60 minutes

Flex Application



Apply 1 medium wet coat

Spray Pressure:

6-10 psi at air cap

Fluid Tip:

(HVLP/HE) 1.5-1.7 mm

Tech Data:

Viscosity: 12 - 20 sec. #4 Ford cup Coat Thickness: 1.0-1.5 mils











DP31 Power Fill 2K Sealer Gray

as a Wet-On-Wet Sealer on Flexible Parts

Flex Application (cont.)



Coverage:

Untinted 663 sq ft/gal Tinted with Diamont 616 sq ft/gal Tinted with UNO HD 596 sq ft/gal Tinted with ONYX HD 587 sq ft/gal

VOC as Applied:

Untinted 503 gms/liter (4.2 lbs/gal)
Tinted with Diamont 527 gms/liter (4.4 lbs/gal)

Tinted with UNO HD

UR Reducers: 551 gms/liter (4.6 lbs/gal) VR Reducers: 419 gms/liter (3.5 lbs/gal)

Tinted with ONYX HD

VR Reducers - only: 503 gms/liter (4.2 lbs/gal)

Flex Post Application



Flex Drying:

20°C/68°F 15 to 20 minutes - Do not force dry.

Safety













Sealers

DS30 Clear 2K Sealer

as a Sealer

Product Details



DS30 Clear 2K Sealer is a two part urethane trans-parent sealer. DS30 can be applied over all R-M 2K Urethane Primers, EP Series Epoxy Primers (as a primer-surfacer), all OEM finishes (except acrylic lacquer) and all air dry finishes (except acrylic lacquer).

Products:

Hardeners

PH12 X-Fast Hardener PH36 Medium Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

<u>Mixing</u>



Mixing Ratio: 2:1:10%

2 parts DS30 1 part PH12 or PH36 10% UR Reducer

Pot Life of Mixed Product:

2 hours @ 20°C/68°F

Application



Apply 1 to 2 medium coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm





Sealers

DS30 Clear 2K Sealer

as a Sealer

Application (cont.)



Tech Data:

Viscosity: 18 sec. #4 Ford cup Thickness: 0.5-0.75 mils

Coverage: 1190 sq ft/gal @ 0.5 mil VOC as Applied: 551 gms/ltr (4.6 lbs/gal)

Post Application



Drying:

20°C/68°F

60 minutes (If topcoating with Diamont) No longer than 6 hours before topcoating

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

<u>Notes</u>



Safety







Sealers

EP569 Gray Chromate Free Epoxy Primer

as a Precoat

Product Details



EP569 Gray Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP569 1 part PA897 1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr (4.7-4.8 lbs/gal)









Sealers

EP569 Gray Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Wet-On-Wet Sealer

Product Details



EP569 Gray Chromate Free Epoxy Primer is a two part epoxy primer for use as wet-on-wet sealer under Diamont or ONYX HD. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1

4 parts EP569 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

May be topcoated for up to 24 hours before sanding is required.











Sealers

EP569 Gray Chromate Free Epoxy Primer

as a Wet-On-Wet Sealer

Application



Apply 1 medium wet coat or 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.3-1.5 mm **Tech Data:**

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 0.75-1.3 mils

Coverage: 673 sq ft/gal @ 1.0 mil

VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 45 minutes (Before topcoating with Diamont or ONYX HD)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

Notes



Safety













Sealers

EP669 White Chromate Free Epoxy Primer

as a Precoat

Product Details



EP669 White Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP669 1 part PA897

1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr (4.7-4.8 lbs/gal)







Filling





Sealers

EP669 White Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Wet-On-Wet Sealer

Product Details



EP669 White Chromate Free Epoxy Primer is a two part epoxy primer for use as wet-on-wet sealer under Diamont or ONYX HD. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1

4 parts EP669 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

May be topcoated for up to 24 hours before sanding is required.











Sealers

EP669 White Chromate Free Epoxy Primer

as a Wet-On-Wet Sealer

Application



Apply 1 medium wet coat or 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.3-1.5 mm **Tech Data:**

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 0.75-1.3 mils

Coverage: 673 sq ft/gal @ 1.0 mil

VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 45 minutes (Before topcoating with Diamont or ONYX HD)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

Notes



Safety













Sealers

EP769 Black Chromate Free Epoxy Primer

as a Precoat

Product Details



EP769 Black Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals.

EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activatedwith PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP769 1 part PA897

1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr (4.7-4.8 lbs/gal)









EP769



Sealers

EP769 Black Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Wet-On-Wet Sealer

Product Details



EP769 Black Chromate Free Epoxy Primer is a two part epoxy primer for use as wet-on-wet sealer under Diamont or ONYX HD. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1

4 parts EP769 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

May be topcoated for up to 24 hours before sanding is required.













Sealers

EP769 Black Chromate Free Epoxy Primer

as a Wet-On-Wet Sealer

Application



Apply 1 medium wet coat or 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.3-1.5 mm **Tech Data:**

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 0.75-1.3 mils

Coverage: 673 sq ft/gal @ 1.0 mil

VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 45 minutes (Before topcoating with Diamont or ONYX HD)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

Notes



Safety















Sealers

EP869 Red Chromate Free Epoxy Primer

as a Precoat

Product Details



EP869 Red Chromate Free Epoxy Primer is a two part epoxy primer for use as a precoat under DP20, DP21 and NP80 Primers or as a primersurfacer. EP primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals.

EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activatedwith PA897 Epoxy Activator.

Products:

Activators

PNT88 Lacquer Thinner - Medium PNT90 Lacquer Thinner - Slow

Mixing



Mixing Ratio: 4:1:1

4 parts EP869 1 part PA897 1 part PNT88 or PNT90

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

Must be followed by a compliant primer.

Check your local VOC regulations to determine which primers are compliant in you area.

Applied precoat not to exceed 25% of primer-surfacer.

Application



Apply 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.5-0.75 mil

Coverage: 1122 sq ft/gal @ 0.5 mil VOC as Applied: 563-575 gms/ltr (4.7-4.8 lbs/gal)







EP869



Sealers

EP869 Red Chromate Free Epoxy Primer

as a Precoat

Post Application



Drying:

20°C/68°F 15 to 30 minutes (Before applying body fillers or primer fillers/surfacers)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

as a Wet-On-Wet Sealer

Product Details



EP869 Red Chromate Free Epoxy Primer is a two part epoxy primer for use as wet-on-wet sealer under Diamont or ONYX HD. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

Products:

Activators

PA897 Epoxy Activator

Mixing



Mixing Ratio: 4:1

4 parts EP869 1 part PA897

Pot Life of Mixed Product:

24 hours @ 20°C/68°F

Product Tips:

May be topcoated for up to 24 hours before sanding is required.











Sealers

EP869 Red Chromate Free Epoxy Primer

as a Wet-On-Wet Sealer

Application



Apply 1 medium wet coat or 1 to 2 light coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.3-1.5 mm **Tech Data:**

Viscosity: 20-22 sec. #4 Ford cup

Thickness: 0.75-1.3 mils

Coverage: 673 sq ft/gal @ 1.0 mil

VOC as Applied: 516 gms/ltr (4.3 lbs/gal)

Post Application



Drying:

20°C/68°F 45 minutes (Before topcoating with Diamont or ONYX HD)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

Notes



Safety













Polyuroxy® Primer

as a Wet-On-Wet Sealer

Product Details



Polyuroxy Primer is a unique product, combining the properties of both epoxy and urethane into one easy to use package. Polyuroxy is a 3-component primer using epoxy for direct to metal performance and urethanes for their durability and speed. Polyuroxy can be applied over all bare metals including CRS, galvanized, zinc and aluminum. Polyuroxy can be sprayed as a high build primer-surfacer or as a wet-onwet sealer depending upon mix ratio. All R-M topcoats can by used over Polyuroxy Primer.

Products:

Hardeners

DH46 Normal Hardener (ONLY)

Activators

UA97 Polyuroxy Activator

Primers

EP569 Gray Chromate Free Epoxy Primer EP669 White Chromate Free Epoxy Primer EP769 Black Chromate Free Epoxy Primer EP869 Red Chromate Free Epoxy Primer

Product Profile

Mixing



Mixing Ratio: 3:2:1

3 parts EP569, EP669, EP769 or EP869 2 parts UA97 1 part DH46

Pot Life of Mixed Product:

2 hours @ 20°C/68°F

Product Tips:

Do not use DH42 Hardener in Polyuroxy Wet-On-Wet Sealer.

<u>Application</u>



Apply 1 to 2 medium coats allowing 10 minutes flash between coats 25 minutes flash prior to topcoating

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.6 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 14 sec. #4 Ford cup Thickness: 0.75-1.25 mils Coverage: 584 sg ft/gal @ 1.0 mil

VOC as Applied: 539 gms/ltr (4.5 lbs/gal)





Sealers

Polyuroxy® Primer

as a Primer-Filler

Post Application



Drying:

20°C/68°F 25 minutes (Before topcoating with Diamont, ONYX HD or UNO HD)

Sanding:

Remove sanding residue with 900, 901, 909 or AM900.

<u>Notes</u>	

Safety









Sealers

DP200 Exempt Low VOC 2K Primer

as a Wet-On-Wet Sealer

Product Details



DP200 Low VOC Primer can be used as a wet-on-wet sealer or as a primer surfacer. DP200 is a 2.1 lbs/gal solvent borne primer which exhibits extremely fast filling and sanding characteristics. DP200 is a high solids urethane primer that dries quickly to a hard chemically resistant finish. DP200 is recommended under UNO HD and Diamont topcoats.

Products:

Hardeners

PH10 Spot Repair Hardener PH20 Medium Hardener

Primers

DE17 Chromate Free Etch Primer

Mixing



Untinted Mixing Ratio: 4:1:2

4 parts DP200 1 part PH10 or PH20 2 parts VR Reducer

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Tinted Mixing Ratio:

Step 1 - 5:1

5 parts DP200

1 part UNO HD or Diamont Tinting Base/Color

Step 2 - 4:1:2

4 parts DP200/tint mixture

1 part PH10 or PH20

2 parts VR Reducer

Pot Life of Mixed Product:

Tinted with Diamont: 2 hours @ 20°C/68°F Tinted with UNO HD: 1.5 hours @ 20°C/68°F

Untinted: 2 hours @ 20°C/68°F

Product Tip:

Use the same topcoat product to tint DP200 as you will be using to paint the vehicle/part. If topcoating with Diamont, use Diamont to tint DP200. If topcoating with UNO HD, use UNO HD to tint DP200. When using inter-mixed color, Diamont ONLY, to tint DP200, the color should NOT be ready-for-use (no reducer). Check your local VOC regulations to determine which R-M cleaners are compliant in your area.







DP200 Exempt Low VOC 2K Primer

as a Wet-On-Wet Sealer

Application



Apply 1 to 2 medium wet coats allowing 5 minutes flash between coats; 30 minutes flash before topcoating

Spray Pressure:

8-10 psi at air cap

Fluid Tip:

(HE/HVLP Gravity) 1.3-1.5 mm

Tech Data:

Tinted Viscosity: 13-15 sec. #4 Ford cup Untinted Viscosity: 12-13 sec. #4 Ford cup

Coat Thickness: 0.75-1.25 mils

Coverage:

Tinted with Diamont: 506 sq ft/gal @ 1.0 mil Tinted with UNO HD: 546 sq ft/gal @ 1.0 mil Untinted: 628 sq ft/gal @ 1.0 mil

VOC as Applied: Tinted with Diamont: 336 gms/liter (2.8 lbs/gal) Tinted with UNO HD: 288 gms/liter (2.4 lbs/gal

Untinted: 252 gms/liter (2.1 lbs/gal)

Post Application



Drying:

20°C/68°F 30 minutes

Notes









Sealers

DP200 Exempt Low VOC 2K Primer

as a Wet-On-Wet Sealer

<u>Notes</u>	

Safety









EP369 Grey Epoxy Primer LVOC

as a Surfacer

Product Details



EP369 Grey Epoxy Primer LVOC is chromate-free and recommended for 340 gms/ltr (2.8 lbs/gal) or 420 gms/ltr (3.5 lbs/gal) VOC topcoats like ONYX HD and UNO HD.

Products:

Activators

PA38 Low VOC Activator

Reducers

VR29 Low VOC Reducer

Mixing



Mixing Ratio: 4:1:1

4 parts EP369 1 part PA38 1 part VR29

Pot Life of Mixed Product:

8 hours @ 20°C/68°F

Application



Apply 2 medium wet coats allowing 5 to 10 minutes flash time between coats

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

(HVLP/HE) 8-10 psi at air c

Fluid Tip: (HE Gravity) 1.6 mm (HVLP Gravity) 1.7 mm

Tech Data:

Viscosity: 18-24 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 400 sq ft/gal @ 2.0 mils VOC as Applied: 250 gms/ltr (2.0 lbs/gal)

Post Application



Drying:

20°C/68°F 8 to 12 hours to sand

Sanding:

320 to 600 grit depending on topcoat used. Remove sanding residue with 909 or AM900.









as a Wet-On-Wet Sealer

Product Details



EP369 Grey Epoxy Primer LVOC is chromate-free and recommended for 340 gms/ltr (2.8 lbs/ gal) or 420 gms/ltr (3.5 lbs/gal) VOC topcoats like ONYX HD and UNO HD.

Products:

Activators

PA33 Low VOC Activator

Reducers

VR29 Low VOC Reducer

Mixing



Mixing Ratio: 2:1:1

2 parts EP369 1 part PA33 1 part VR29

Pot Life of Mixed Products:

6 hours @ 20°C/68°F

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.4 mm (HVLP Gravity) 1.3-1.4 mm

Tech Data:

Viscosity: 17-21 sec. #4 Ford cup

Thickness: 0.75-1.0 mil

Coverage: 708 sq ft/gal @ 1.0 mil

VOC as Applied: 335 gms/ltr (2.8 lbs/gal)

Post Application



Drying:

20°C/68°F Topcoats should be applied after 30 minutes dry time

for UNO HD, and after two hours for ONYX HD, but no longer than 12 hours for any topcoat system.

Drying at room temperature: Tack Free - 30 minutes

Dry to touch/handle - 3 hours





EP369





Sealers

EP369 Grey Epoxy Primer LVOC

as a Surfacer / as a Wet-On-Wet Sealer

<u>Notes</u>	

Safety













Sealers

DP321 Low VOC Tintable Sealer

as a Wet-On-Wet Sealer

Product Details



DP321 is a low VOC wet-on-wet sealer that provides exceptional hold out, dries to a semi-gloss finish and provides a smooth surface for topcoats. DP321 can be tinted with ONYX HD bases. DP321 may be applied over cured and sanded air dry finishes, properly sanded OEM finishes, properly prepared bare metal, fiberglass and body fillers. Aluminum substrates must be properly treated before DP321 is applied. **Do not use ready for use ONYX HD colors.**

Products:

Hardeners

DH100 Low VOC Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Untinted Mixing Ratio: 4:1:2

4 parts DP321 1 part DH100 2 parts VR Reducer

Tinted Mixing Ratio:

Step 1 - 6:1

6 parts DP321 1 part ONYX HD Tinting Base/Color (without HB002, HB005, HB020 or HB040)

Step 2 - 4:1:2

4 parts DP321/ONYX HD mixture 1 part DH100 2 parts VR Reducer

Pot Life of Mixed Product:

1.5 hours @ 20°C/68°F

Product Tip:

Must use a pretreatment primer when using as a sealer over bare metal substrates. For application of DP321 to plastic parts, see Flexible Parts Section.

Application



Apply 1 medium wet coat









DP321 Low VOC Tintable Sealer

as a Wet-On-Wet Sealer

Application (cont.)



Spray Pressure:

HVLP/HE: 6-10 psi at air cap

Fluid Tip:

HVLP/HE: 1.3-1.5 mm

Tech Data:

Viscosity: 15-18 sec. #4 Ford cup Coat Thickness: 1.0-1.5 mils

Coverage:

Untinted 522 sq ft/gal

Tinted with ONYX HD 514 sq ft/gal

VOC as Applied:

Untinted 250 gms/ltr (2.1 lbs/gal)

Tinted with ONYX HD 180 gms/ltr (1.5 lbs/gal)

Post Application



Drying: 20°C/68°F 20 to 30 minutes Do not force dry.

Sanding:

Remove sanding residue with 909 or AM900.

Flex Procedures

Flex Mixing



Untinted - Flexed:

5:1:1:2

5 parts DP321

1 part DF21

then

1 part DH100

2 parts VR Reducer









DP321 Low VOC Tintable Sealer

as a Wet-On-Wet Sealer on Flexible Parts

Mixing (cont.)



ONYX HD Tinted - Flexed:

Step 1 - 6:1

6 parts DP321 1 part ONYX HD Toner

Pot Life of Mixed Product:

45 to 60 minutes @ 20°C/68°F

Step 2 - 5:1

5 parts DP321/ONYX HD mixture 1 part DF21

Step 3 - 4:2:1

4 parts DP321/ONYX HD/DF21 mixture

1 part DH100

2 parts VR Reducer

Flex Application



Apply 1 to 2 medium wet coat

Spray Pressure:

HVLP/HE: 6-10 psi at air cap

Fluid Tip:

HVLP/HE: 1.3-1.5 mm

Tech Data:

Viscosity: 15-19 sec. #4 Ford cup Coat Thickness: 1.0-2.0 mils

Coverage:

Untinted 663 sq ft/gal @ 1.0 mil Tinted with ONYX HD 587 sq ft/gal @ 1.0 mil

VOC as Applied:

Untinted 503 gms/ltr (4.2 lbs/gal)
Tinted with ONYX HD 503 gms/ltr (4.2 lbs/gal)

Flex Post Application



Drying:

15 to 20 minutes Do not force dry.









Sealers

DP321 Low VOC Tintable Sealer

as a Wet-On-Wet Sealer on Flexible Parts

<u>Notes</u>	

Safety











DP322 Low VOC White Sealer

as a Wet-On-Wet Sealer

Product Details



DP322 Low VOC White Sealer is to be used as a wet-on-wet sealer. DP322 is an easy to apply 2.1 lbs/gal solventborne sealer which exhibits extremely fast filling and smooth layout characteristics. DP322 is a high solids urethane sealer that dries quickly to a hard finish. DP322 is recommended under UNO HD, ONYX HD, ONYX HD Low VOC Productive System and Diamont topcoats.

Products:

Hardeners

RMH94 Low VOC Fast Hardener RMH96 Low VOC Medium Hardener RMH98 Low VOC Slow Hardener

Flex Agents

DF21 Flex Additive

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Primers

DE17 Chromate Free Etch Primer

Mixing



Mixing Ratio: 4:1:2

4 parts DP322

1 part RMH94, RMH96 or RMH98

2 parts VR Reducer

Pot Life of Mixed Product:

1.5 hours @ 20°C/68°F

Application



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HVLP/HE) 1.3-1.5 mm

Tech Data:

Viscosity: 13-14 sec. #4 Ford cup Coat Thickness: 1.0-1.5 mil

Coverage:

751 sq ft/gal @ 1.0 mil

VOC as Applied:

250 gms/ltr (2.1 lbs/gal)

Post Application



Drying:

20°C/68°F 20 to 30 minutes







Sealers

DP322 Low VOC White Sealer

as a Wet-On-Wet Sealer on Flexible Parts

Flex Mixing



Step 1 - 5:1

5 parts DP322 1 part DF21 Step 2 - 4:1:2

4 parts DP322/DF21 mixture 1 part RMH94, RMH96 or RMH98 2 parts VR Reducer

<u>Notes</u>			

Safety









DP323 Low VOC Dark Grey Sealer

as a Wet-On-Wet Sealer

Product Details



DP323 Low VOC Dark Grey Sealer is to be used as a wet-on-wet sealer. DP323 is an easy to apply 2.1 lbs/gal solventborne sealer which exhibits extremely fast filling and smooth layout characteristics. DP323 is a high solids urethane sealer that dries quickly to a hard finish. DP323 is recommended under UNO HD, ONYX HD, ONYX HD Low VOC Productive System, and Diamont topcoats.

Reducers

VR0 Exempt Slow

VR29 Exempt Fast

Products:

Hardeners

RMH94 Low VOC Fast Hardener RMH96 Low VOC Medium Hardener RMH98 Low VOC Slow Hardener

Flex Agents

DF21 Flex Additive

Mixing



Mixing Ratio: 4:1:2

4 parts DP323 1 part RMH94, RMH96 or RMH98 2 parts VR Reducer

Pot Life of Mixed Product:

1.5 hours @ 20°C/68°F

<u>Application</u>



Apply 1 medium wet coat

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HVLP/HE) 1.3-1.5 mm

Tech Data:

Viscosity: 13-14 sec. #4 Ford cup Coat Thickness: 1.0-1.5 mil Coverage: 619 sq ft/gal @ 1.0 mil

VOC as Applied: 250 gms/ltr (2.1 lbs/gal)







DP323 Low VOC Dark Grey Sealer

as a Wet-On-Wet Sealer

Post Application



Drying:

20°C/68°F 20 to 30 minutes

Flex Procedures

Flex Mixing



Step 1 - 5:1

5 parts DP323 1 part DF21

Step 2 - 4:1:2

4 parts DP323/DF21 mixture

1 part RMH94, RMH96 or RMH98

2 parts VR Reducer

Pot Life of Mixed Product:

1.5 hours @ 20°C/68°F

<u>Safety</u>









Sealers

DS40 LVOC Transparent Sealer

Product Details



DS40 LVOC Transparent Sealer is a two part urethane transparent sealer. DS40 can be applied over all R-M primer surfacers, all OEM finishes and all air dry finishes (except acrylic lacquer).

Products:

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio Untinted: 6:1:1

6 parts DS40

1 part DH99, DH100 or DH105

1 part VR Reducer

Mixing Ratio Tinted with ONYX HD

Step 1: 10:1

10 parts DS40

1 part ONYX HD Tinting Base/Color

Step 2: 6:1:1

6 parts DS40/ONYX HD mixture

1 part DH99, DH100 or DH105

1 part VR Reducer

Pot Life of Mixed Product:

1 hour @ 20°C/68°F

Application



Apply 1 to 2 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure: Fluid Tip:

10 psi at air cap (HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm







DS40





DS40



Product Profile

Sealers

DS40 LVOC Transparent Sealer

Application (cont.)



Tech Data:

Viscosity: 12-16 sec. #4 Ford cup

Thickness: 1.0-1.4 mils

Coverage: 1190 sq ft/gal @ 0.5 mil

VOC as Applied:

Tinted 241 gms/ltr (2.0 lbs/gal) Untinted 189 gms/ltr (1.6 lbs/gal)

Post Application



Drying:

20°C/68°F 20 to 30 minutes No longer than 6 hours before topcoating

Sanding:

Remove sanding residue with 909 or AM900.

Product Tips: Need to use a pretreatment primer when using as a sealer over bare metal substrates. DS40 may be applied to unsanded e-coat that has been properly cleaned.

<u>Safety</u>



















Topcouts

AM200 Aero-Max Hi Gloss Black

Product Details



AM200 Hi Gloss Black is a 1K, fast drying topcoat for use in spot and panel repairing of all factory OEM finishes. Available in an easy to use aerosol container, AM200 can be applied over AM700 Prime Etch, AM800 Spot Prime and other properly cured and sanded substrates.

Products:

AM900 Aero-Max Pre-Kleano

Mixing



Ready to spray

Application



Shake aerosol can for one minute after mixing ball rattles and spray to test. Spray distance 6"- 8".

Technical Data:

Number of Coats: 2 to 3 coats

Thickness: 1.5-2.0 mils

Coverage: 107.6 sq ft/gal @ 1 mil VOC as Applied: 641 gms/ltr (5.4 lbs/gal)

Post Application



Drying:

20°C/68°F 30 to 35 minutes

Sanding/ Polishing:

Clean areas to be painted with AM900 Pre-Kleano. Sand as required.







Topcoats

AM200 Aero-Max Hi Gloss Black

<u>Notes</u>		

Safety









AM210 Aero-Max Satin Black

for Spot Repairs

Product Details



AM210 Satin Black is a 1K, fast drying topcoat for use in spot and panel repairing of all factory OEM finishes. Available in an easy to use aerosol container, AM210 can be applied over AM700 Prime Etch, AM800 Spot Prime and other properly cured and sanded substrates.

Mixing



Ready to spray

Application



Shake aerosol can for one minute after mixing ball rattles and spray to test. Spray distance 6" to 8".

Technical Data:

Number of Coats: 2 to 3 coats

Thickness: 1.5-2.0 mils

Coverage: 109 sq ft/gal @ 1 mil

VOC as Applied: 639 gms/ltr (5.3 lbs/gal)

Post Application



Drying:

20°C/68°F 30 to 35 minutes

Safety









Topcoats

R-M Extreme Colors

Product Details



R-M Extreme Colors provide a stunning holographic effect. The color changes depending upon the angle from which it is viewed, creating the most dramatic color shifts possible. R-M Extreme Colors spray easily, hide quickly and require no special spraying techniques. Multiple color effects can now be taken to the Extreme.

Products:

Clearcoats

R-M 2K Clearcoats

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow

VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Basecoat, groundcoat or midcoat: 2:1

2 parts Color1 part UR ReducerOptional - 10% BCH2 added to unreduced color portion.

Pot Life of Mixed Product:

Without 10% BCH2 Indefinite using 10% BCH2 24 hours

Product Tips:

To blend in edges of the clearcoat, use a mixture of 1 part RFU clear to 5 parts UR60, UR70 or UR100.

For improved color control of the Extreme midcoat, add up to 30% BC100 prior to reduction. Spray to desired color. If using low VOC clearcoats, check local wallcharts to ensure correct amount of BCH2 hardener has been added to basecoat.

For additional information contact your local R-M Extreme Distributor.





Topcoats

R-M Extreme Colors

Application



R-M Extreme Colors are sprayed exactly like other Diamont Basecoat colors. For optimum color effects, ensure the Extreme Color has been thoroughly stirred prior to use. Stir every two hours for best results. Allow 5 to 10 minutes flash between coats.

Basecoat Colors Stock #
Carribean Night Mist D28069
Ocean D28070

Spray two coats to achieve hiding. Allow 10-15 minutes flash prior to clearcoat.

Tricoat Colors	Groundcoat Stock #	Extreme Midcoat Stock #
Rainbow	30067	D28067
Copper Head Bronze	30176	D28211
Cotton Candy	30210	D28211
Purple Haze	30335	D28211
Tahitian Sunset	30209	D28211

Apply groundcoat to hiding in two coats. Allow 10 to 15 minutes flash then apply 2 to 3 coats of EXTREME midcoat to achieve desired color. Allow 10 to 15 minutes flash prior to clearcoat.

Repair of Basecoat

(HVLP Gravity) 1.4 mm

- 1. Allow R-M Extreme Colors to dry for at least 30 minutes prior to sanding.
- 2. Wet sand using 1200 grit (or finer).
- 3. After sanding and repairing Extreme Colors, additional basecoat must be applied over the repair area. No special reducers or repair techniques are required.
- 4. If hardener has been added to the basecoat color, hardener must also be added to the repair basecoat.
- 5. Blending Extreme Colors is very easy due to the tremendous color gradient within the colors.

Spray Pressure: Tech Data:

(HVLP/HE) 6-10 psi at air cap Viscosity: 13-15 sec. #4 Ford cup

Thickness: 0.4-1.0 mil Number of Coats: 2

Fluid Tip:
(HE Gravity) 1.4 mm

Number of Coats: 2
VOC as Applied: 779 gms/ltr (6.5 lbs/gal)





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Topcoats

R-M Extreme Colors

Post Application



Drying:

20°C/68°F 10 to 15 minutes

<u>Notes</u>	

Safety







UNO HD National Rule

for Spot Repairs

Product Details



R-M UNO HD is a high solids single stage, two component, topcoat system. This globally available product was developed with international cooperation among our European and American facilities. This formulation is based on a unique acrylic/polyurethane technology that offers high solids and high performance. UNO HD comes in a wide range of solid colors that can assure success in completes, panel replacements and spot repairs. The ease of mix as well as application are just the beginning. Expect excellent flow and leveling, exceptional hiding and mirror like gloss. Superior hardness and chemical resistance completes the package.

Products:

Flex Agents

DF21 Flex Agent

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener

Special Products

SC01 Base Booster SC10 Mixing Clear SM09 Flattener - Special MAT09 UBR200 Blending Solvent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 3:1:1

3 parts UNO HD Color

1 part DH42, DH44, DH46 or DH47

1 part VR Reducer

Pot Life of Mixed Product:

2 to 4 hours

Product Tips:

Notes Apply UBR200 Blending Solvent or AM960 Spot Blender (see Clearcoat section) over blend areas. Intermix formula must contain SC01 and SC10.
Use 10% SC01 Base Booster and 15% SC10 Mixing Clear in the intermix formula.



UNO HD National Rule

for Spot Repairs

Application



Apply 1st coat over repair area only allowing 5 minutes flash between coats Apply 2nd coat 4 to 6 inches beyond where the 1st coat ended. Apply 3rd coat (if necessary) 4 to 6 inches beyond where the 2nd coat ended. Bake immediately after final coat for best results.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.5 to 1.6 mm (HVLP Gravity) 1.3 to 1.5 mm

Tech Data:

Viscosity: 18-20 sec. #4 Ford cup

Thickness: 2.0 to 2.4 mils

Coverage: 375 sq ft/gal @ 2.0 mils

VOC as Applied: 479 gms/ltr max. (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 2 hours tack free, 30 to 60 minutes to dust free 60°C/140°F 30 minutes

Sanding:

Wet Sand - 1200 grit or finer

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UNO HD National Rule

for Complete Repairs

Product Details



R-M UNO HD is a high solids single stage, two component, topcoat system. This globally available product was developed with international cooperation among our European and American facilities. This formulation is based on a unique acrylic/polyurethane technology that offers high solids and high performance. UNO HD comes in a wide range of solid colors that can assure success in completes, panel replacements and spot repairs. The ease of mix as well as application are just the beginning. Expect excellent flow and leveling, exceptional hiding and mirror like gloss. Superior hardness and chemical resistance completes the package.

Products:

Flex Agents

DF21 Flex Agent

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener

Special Products

SC01 Base Booster SC10 Mixing Clear SM09 Flattener - Special MAT09 UBR200 Blending Solvent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 4:1:1

4 parts UNO HD Color

1 part DH42, DH44, DH46 or DH47

1 part UR Reducer

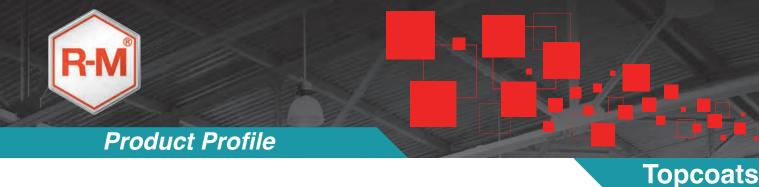
Pot Life of Mixed Product:

2 to 3 hours

Product Tips:

Intermix formula must contain SC01 and SC10. Use 10% SC01 Base Booster and 15% SC10 Mixing Clear in the intermix formula.





UNO HD National Rule

for Complete Repairs

Application



Apply 1 medium wet coat allowing 5 minutes flash between coats. Apply a 2nd full wet coat.

Bake immediately after final coat for best results.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.5-1.6 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 18 - 20 sec. #4 Ford cup

Thickness: 2.0-2.4 mils

Coverage: 375 sq ft/gal @ 2.0 mils

VOC as Applied 479 gms/ltr max. (4.0 lbs/gal)

Post Application



Drying:

20°C/68°F 2 hours 60°C/140°F 30 minutes

Sanding:

Wet Sand - 1200 grit or finer

Safety







UNO HD 340 gms/liter (2.8 lbs/gal) VOC

for Spot Repairs

Product Details



R-M UNO HD is a high solids single stage, two component, topcoat system. This formulation is basedon a unique acrylic/polyurethane technology that offers high solids and high performance. UNO HD comes in a wide range of solid colors that can assure success in completes, panel replacements and spot repairs. The ease of mix as well as application are just the beginning. Expect excellent flow and leveling, exceptional hiding and mirror like gloss. Superior hardness and chemical resistance completes the package.

Products:

Flex Agents

DF21 Flex Agent

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener DH105 High Temp Low VOC Hardener **Mixing Clear**

SCM103 Mixing Clear

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 3:1:1

3 parts UNO HD Color

1 part DH99, DH100 or DH105

1 part VR Reducer

Pot Life of Mixed Product:

2 hours

Product Tips:

Intermix formula must contain SCM103. Mix 3 parts UNO HD color to 1 part (by volume) SCM103.



UNO HD 340 gms/liter (2.8 lbs/gal) VOC

for Spot Repairs

Application



Apply 1st coat over repair area only allowing 5 minutes flash between coats Apply 2nd coat 4 to 6 inches beyond where the 1st coat ended. Apply 3rd coat (if necessary) 4 to 6 inches beyond where the 2nd coat ended. Bake immediately after final coat for best results.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.5 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 16-20 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 400 sq ft/gal @ 2.0 mils

VOC as Applied: 340 gms/ltr max. (2.8 lbs/gal)

Post Application



Drying:

20°C/68°F 2 hours tack free, 30 to 60 minutes to dust free 60°C/140°F 30 minutes

Sanding:

Wet Sand - 1200 grit or finer

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UNO HD 340 gms/liter (2.8 lbs/gal) VOC

for Complete Repairs

Product Details



R-M UNO HD is a high solids single stage, two component, topcoat system. This formulation is basedon a unique acrylic/polyurethane technology that offers high solids and high performance. UNO HD comes in a wide range of solid colors that can assure success in completes, panel replacements and spot repairs. The ease of mix as well as application are just the beginning. Expect excellent flow and leveling, exceptional hiding and mirror like gloss. Superior hardness and chemical resistance completes the package.

Products:

Flex Agents

DF21 Flex Agent

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener DH105 High Temp Low VOC Hardener **Mixing Clear**

SCM103 Mixing Clear

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 3:1:1

3 parts UNO HD Color

1 part DH99, DH100 or DH105

1 part VR Reducer

Pot Life of Mixed Product:

2 hours

Product Tips:

Intermix formula must contain SCM103. Mix 3 parts UNO HD color to 1 part (by volume) SCM103.





UNO HD 340 gms/liter (2.8 lbs/gal) VOC

for Complete Repairs

Application



Apply 1 medium wet coat allowing 5 minutes flash between coats.

Apply a 2nd full wet coat.

Bake immediately after final coat for best results.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.5 mm (HVLP Gravity) 1.5-1.8 mm

Tech Data:

Viscosity: 16-20 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 400 sq ft/gal @ 2.0 mils

VOC as Applied: 340 gms/ltr max. (2.8 lbs/gal)

Post Application



Drying:

20°C/68°F 2 hours tack free, 30 to 60 minutes to dust free

60°C/140°F 30 minutes

Sanding:

Wet Sand - 1200 grit or finer

Safety







UNO HD 420 gms/liter (3.5 lbs/gal) VOC

for Spot Repairs

Product Details



R-M UNO HD is a high solids single stage, two component, topcoat system. This formulation is basedon a unique acrylic/polyurethane technology that offers high solids and high performance. UNO HD comes in a wide range of solid colors that can assure success in completes, panel replacements and spot repairs. The ease of mix as well as application are just the beginning. Expect excellent flow and leveling, exceptional hiding and mirror like gloss. Superior hardness and chemical resistance completes the package.

Products:

Flex Agents

DF21 Flex Agent

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener Mixing Clear

SCM103 Mixing Clear

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 3:1:1

3 parts UNO HD Color

1 part DH42, DH44, DH46 or DH47

1 part VR Reducer

Pot Life of Mixed Product:

5 hours

Product Tips:

Intermix formula must contain SCM103.
Mix 3 parts UNO HD color to 1 part (by volume) SCM103.



UNO HD 420 gms/liter (3.5 lbs/gal) VOC

for Spot Repairs

Application



Apply 1st coat over repair area only allowing 5 minutes flash between coats Apply 2nd coat 4 to 6 inches beyond where the 1st coat ended. Apply 3rd coat (if necessary) 4 to 6 inches beyond where the 2nd coat ended. Bake immediately after final coat for best results.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3 to 1.5 mm (HVLP Gravity) 1.3 to 1.5 mm

Tech Data:

Viscosity: 15-17 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 370 sq ft/gal @ 2.0 mils

VOC as Applied: 420 gms/ltr max. (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 2 hours tack free, 30 to 60 minutes to dust free

60°C/140°F 30 minutes

Sanding:

Wet Sand - 1200 grit or finer

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UNO HD 420 gms/liter (3.5 lbs/gal) VOC

for Complete Repairs

Product Details



R-M UNO HD is a high solids single stage, two component, topcoat system. This formulation is basedon a unique acrylic/polyurethane technology that offers high solids and high performance. UNO HD comes in a wide range of solid colors that can assure success in completes, panel replacements and spot repairs. The ease of mix as well as application are just the beginning. Expect excellent flow and leveling, exceptional hiding and mirror like gloss. Superior hardness and chemical resistance completes the package.

Products:

Flex Agents

DF21 Flex Agent

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener Mixing Clear

SCM103 Mixing Clear

Reducers

Mixing Ratio:

VR0 Exempt Slow VR29 Exempt Fast

Mixing



3:1:1

3 parts UNO HD Color

1 part DH42, DH44, DH46 or DH47

1 part VR Reducer

Pot Life of Mixed Product:

5 hours

Product Tips:

Intermix formula must contain SCM103. Mix 3 parts UNO HD color to 1 part (by volume) SCM103.





UNO HD 420 gms/liter (3.5 lbs/gal) VOC

for Complete Repairs

Application



Apply 1 medium wet coat allowing 5 minutes flash between coats.

Apply a 2nd full wet coat.

Bake immediately after final coat for best results.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3 to 1.5 mm (HVLP Gravity) 1.3 to 1.5 mm

Tech Data:

Viscosity: 15-17 sec. #4 Ford cup

Thickness: 2.0-3.0 mils

Coverage: 370 sq ft/gal @ 2.0 mils

VOC as Applied: 420 gms/ltr max. (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 2 hours tack free, 30 to 60 minutes to dust free

60°C/140°F 30 minutes

Sanding:

Wet Sand - 1200 grit or finer

Safety











Basecoats

Diamont Basecoat D121

Ultra Flash Flake Basecoat with Chrome Satin Effect

Product Details



Ultra Flash Flake is a special Diamont basecoat showing a chrome satin effect. A homogeneous, black substrate is necessary for creating a chrome satin effect.

Products:

Hardeners

BCH2 Basecoat Hardener

Clearcoats

DC98 2.0 VOC Clearcoat DC5335 Glamour Clear DC5800 2.0 CTR Clear

Reducers

UR30 Polar
UR40 Fast 50UR50 Normal 70-3
UR60 Mid to Hot 80+
UR70 High Temp Ove
UR100 Retarder
VR0 Exempt Slow

VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Groundcoat: 2:1:10%

2 parts BC201 Black 1 part UR Reducer 10% BCH2 Basecoat Hardener

Ultra Flash Flake Midcoat: 1:10%

1 part D121 Ultra Flash Flake 10% BCH2 Basecoat Hardener (Do not reduce)

Pot Life of Mixed Product:

Indefinite Using 10% BCH2 24 hours

Product Tips:

BC201 Black Catalyzed with 10% BCH2, must be applied before application of D121, unless otherwise stated in the intermix formulations.

D121 Ultra Flash Flake is only compliant in National Rule areas.

To meet USEPA National Rule VOC regulations, a 3.5 VOC or lower clearcoat must be used. Check your local regulations for detailed VOC requirements.

Diamont Basecoat D121

Ultra Flash Flake Basecoat with Chrome Satin Effect Application



Groundcoat

Apply BC201 in 2 to 3 wet coats or to hiding.

Ultra Flash Flake Midcoat

Apply 2 medium wet coats plus 1 to 2 mist coats allowing 5 to 10 minutes flash between coats Allow final coat to flash at least 15 minutes before applying the clearcoat. If needed, when dry, tack entire vehicle with a clean tack rag.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Post Application



Drying:

20°C/68°F 15 to 20 minutes 60°C/140°F 10 to 15 minutes 70°C/160°F 7 to 10 minutes

Tech Data:

Viscosity: 10-13 sec. #4 Ford cup Number of Coats: 2 medium wet coats plus 1 to 2 mist coats

Thickness: 0.75-1.0 mil

Coverage: 278 sq ft/gal @ 0.75 mil

VOC as Applied: BC201 743 gms/ltr (6.2 lbs/gal) D121 851 gms/ltr (7.2 lbs/gal)

<u>Safety</u>





Basecoats

Diamont Basecoat

for Spot Repairs

Product Details



Diamont Basecoat Color is the basecoat color used to repair and duplicate the OEM look of original basecoat/clearcoat finishes. Diamont Basecoat Colors require no special spraying techniques and achieve complete hiding in two or three light coats. All Diamont Basecoat Colors must be clearcoated with an approved Diamont Clearcoat.

Products:

Hardeners

BCH2 Basecoat Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 2:1

2 parts Diamont Basecoat Color 1 part UR Reducer optional - 10% BCH2 added to unreduced color portion

Pot Life of Mixed Product:

Pot Life using 10% BCH2 24 hours

Product Tips:

Tack entire panel with clean tack rag to remove dry overspray.

Repair of Diamont Basecoat:

- 1. Allow Diamont Basecoat Color to dry for 30 minutes or longer at 20°C/68°F before sanding.
- 2. Wet sand using 1200 grit or finer sandpaper to remove small imperfections.
- 3. After sanding and repairing Diamont Basecoat Color, additional Diamont Basecoat Color must be applied over the repaired area. No special reducers or spray techniques are required.
- 4. If hardener has been added to a basecoat color, hardener must be added to the repair basecoat also.



Diamont Basecoat

for Spot Repairs

Application



Apply 1st coat over repair area only, allowing 5 to 10 minutes flash between coats Apply 2nd coat 4 to 6 inches beyond where the 1st coat ended.

Apply 3rd coat (if necessary) 4 to 6 inches beyond where the 2nd coat ended.

- * With certain high metallic colors the final blend coat is best applied at low pressures of 15 to 20 psi.
- * Do not melt in the dry edge of the color after finishing the blend the clearcoat will take care of this.
- * Allow final coat to flash 15 minutes before applying the clear.

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Thickness: 0.75-1.0 mil

Coverage: 278 sq ft/gal @ 0.75 mil VOC as Applied: 791 gms/ltr (6.6 lbs/gal)

Post Application



Drying:

20°C/68°F 20 minutes 60°C/140°F 5 minutes 70°C/160°F 10 minutes



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Basecoats

Diamont Basecoat

for Complete Repairs

Product Details



Diamont Basecoat Color is the basecoat color used to repair and duplicate the OEM look of original basecoat/clearcoat finishes. Diamont Basecoat Colors require no special spraying techniques and achieve complete hiding in two or three light coats. All Diamont Basecoat Colors must be clearcoated with an approved Diamont Clearcoat.

Products:

Hardeners

BCH2 Basecoat Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 2:1

2 parts Diamont Basecoat Color 1 part UR Reducer optional - 10% BCH2 added to unreduced color portion

Pot Life of Mixed Product:

Pot Life is Indefinite if not using BCH2 Pot Life is 24 hours if using 10% BCH2

Repair of Diamont Basecoat:

- 1. Allow Diamont Basecoat Color to dry for 30 minutes or longer at 20°C/68°F before sanding.
- 2. Wet sand using 1200 grit or finer sandpaper to remove small imperfections.
- After sanding and repairing Diamont Basecoat Color, additional Diamont Basecoat Color must be applied over the repaired area. No special reducers or spray techniques are required.
- 4. If hardener has been added to a basecoat color, hardener must be added to the repair basecoat also.



Diamont Basecoat

for Complete Repairs

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats Allow final coat to flash at least 15 minutes before applying the clearcoat. If needed, when dry, tack entire vehicle with a clean tack rag.

Post Application



Notes

Drying:

20°C/68°F 15 to 20 minutes 60°C/140°F 10 to 15 minutes 70°C/160°F 7 to 10 minutes

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Basecoats

Diamont Basecoat

for Interior Parts

Application



Diamont is ideally suited for repairs of interior substrates due to the fast dry, minimal overspray and wide range of color capability for Diamont Basecoat. Adding an approved hardener to Diamont Basecoat crosslinks the basecoat to a durable interior finish that will withstand fading, chalking and abrasions. Diamont Basecoat does not require a clearcoat when used on interior parts. Diamont Basecoat does not require addition of flex agents when used on flexible plastic parts. However, all clearcoats need to be flexed if used.

Products:

Hardeners

DH14 Fast Hardener
DH16 Normal Hardener
DH18 Slow Hardener
DH42 Rapid Hardener
DH44 Medium Hardener
DH46 Normal Hardener
DH99 Low VOC Fast Hardener
DH100 Low VOC Normal Hardener

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 1:10%:70-100%

1 part Diamont Basecoat Color 10% Hardener (see product list) * 75%-100% UR Reducer

Pot Life of Mixed Product:

24 hours @ 68°F

Product Tips:

* The 10% of hardener is by weight, as per color formula.



Diamont Basecoat

for Interior Parts

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 6-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 14-16 sec. #4 Ford cup

Thickness: 0.75-1.0 mil

VOC as Applied: 539 gms/ltr (4.5 lbs/gal)

Post Application



Drying:

20°C/68°F 20 minutes

Notes

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Safety



Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous and should be used according to label directions and technical data information. Appropriate respiratory protection should be worn at all times while products are in use - read product label and Material Safety Data Sheet (MSDS) for specific details. Statements and methods described are based upon the latest standard of technology known to the manufacturer Application procedures cited are suggestions only and are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.



Diamon



Basecoats

ONYX HD

for Exterior

Product Details



The R-M ONYX HD Waterborne is an advanced water-based topcoat that provides all the drying advantages of a solvent based product while having the environmentally safe properties of a water-base topcoat. ONYX HD uses 80% less solvent when compared to conventional basecoats and has a ready for use VOC of 3.5 lbs/gal or less. Has OEM approval and is good for multi-colors and solid colors.

Products:

Undercoats

All R-M Undercoats

Clears

All R-M Clears

Other Products

HB002 Hydrobase

HB004 Hydrobase Slow (Not for California)

HB005 Hydrobase Slow (For California only)

HB020 Hydromix

HB040 Hydromix Slow

HB055 Onyx Blender Pro

HB100 Mixing Clear

Mixing



Mixing Ratio

100% ONYX HD Color 60-80% Hydromix

It is important to follow these steps during the preparation of ONYX HD:

- Prepare the ONYX HD Color
- Stir well until uniform
- Add Hydromix
- · Stir well until uniform

Strain before application.

Pot Life of Mixed Product:

6 months (in plastic or lined containers)







Basecoats

ONYX HD

for Exterior

Mixing (cont.)



Product Tips:

Intermix formula must contain Hydrobase.

Please observe the following shelf life recommendations:

HB002 - 12 months HB040 - 12 months

HB004 - 12 months HB055 - 12 months

HB005 - 12 months HB100 - 12 months

HB020 - 12 months

ONYX HD colors mixed to formula: 6 months in a sealed plastic container.

ONYX HD ready for use: 1 week in a sealed plastic container.

For underhood solution, please see SmartTRAK/SmartCOLOR.

Application



Apply 2 medium wet coats (to hiding) + 1 mist coat for metallic / effect colors allowing 5 minutes flash between coats and before clearcoat until matte. The use of air jets will reduce flash-off time of the ONYX HD paint.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 21-26 sec. #4 Ford cup Thickness: 0.5-1.0 mil Coverage 230 sq ft/gal @ 1.0 mil VOC as Applied 420 gms/ltr (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 15 minutes under ventilation







Basecoats

ONYX HD

for Exterior OEM Warranty

Product Details



The R-M ONYX HD Waterborne is an advanced water-based topcoat that provides all the drying advantages of a solvent based product while having the environmentally safe properties of a water-base topcoat. ONYX HD uses 80% less solvent when compared to conventional basecoats and has a ready for use VOC of 3.5 lbs/gal or less. Has OEM approval and is good for multi-colors and solid colors.

Products:

Undercoats

All R-M Undercoats

Clears

All R-M Clears

Hardeners

BCH10 Basecoat Hardener

Other Products

HB002 Hydrobase

HB004 Hydrobase Slow (Not for California)

HB005 Hydrobase Slow (For California only)

HB020 Hydromix

HB040 Hydromix Slow

HB055 Onyx Blender Pro

HB100 Mixing Clear

Mixing



Mixing Ratio:

100% ONYX HD Color 80% Hydromix * 5% BCH10

It is important to follow these steps during the preparation of ONYX HD:

- Prepare the ONYX HD Color
- · Stir well until uniform
- Add Hydromix
- Stir well until uniform
- Add BCH10 Basecoat Hardener
- Stir well until uniform

Strain before application.

Pot Life of Mixed Product:

6 months (in plastic or lined containers)





Basecoats

ONYX HD

for Exterior OEM Warranty

Mixing



Product Tips:

Intermix formula must contain Hydrobase. Please observe the following shelf life recommendations:

HB002 - 12 months HB004 - 12 months HB005 - 12 months HB005 - 12 months HB100 - 12 months HB020 - 12 months

ONYX HD colors mixed to formula: 6 months in a sealed plastic container.

ONYX HD ready for use: 1 week in a sealed plastic container.

For underhood solution, please see SmartTRAK/SmartCOLOR.

Pot Life of Mixed Product:

6 months (in plastic or lined containers)
Pot Life using 5% BCH10 90 minutes

Application



Apply 2 medium wet coats (to hiding) + 1 mist coat for metallic / effect colors allowing 5 minutes flash between coats and before clearcoat until matte. The use of air jets will reduce flash-off time of the ONYX HD paint.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 21-26 sec. #4 Ford cup

Thickness: 0.5-1.0 mil

Coverage: 230 sq ft/gal @ 1.0 mil

VOC as Applied: 420 gms/ltr (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 15 minutes under ventilation





Basecoats

ONYX HD

for Low VOC Productive System Using RMR09 ONYX HD Low VOC Slow Reducer

Product Details



The R-M ONYX HD Low VOC Productive System is an advanced topcoat that provides similar drying properties of solventborne basecoats. Because of its solventborne nature, ONYX HD Low VOC Productive System is easy to use and its drying properties are less negatively affected by increase in humidity commonly found in collision repair centers. ONYX HD Low VOC Productive System meets all current low VOC regulations in North America with 420 gms/ltr (3.5 lbs/gal) or less VOC content (ready for use).

Products:

Hardeners

DH100 Low VOC Hardener

Clears

SB01 Low VOC Mixing Clear All VOC Compliant R-M Clears and Undercoats

- without flexed or matte additives

Other Products

SB02 Quick-Dry Basecoat Adjuster SB03 Quick-Dry Color Adjuster SB04 Quick-Dry Color Booster SB05 Quick-Dry Mixing Clear For Solids

Reducers

RMR09 Onyx HD Low VOC Slow Reducer

Mixing



Mix Toners with appropriate SB Quick-Dry as per formula provided in SmartTRAK. Color bases must be mixed well before the addition of mixing clear and reducer.

Metallic Colors

See SmartTRAK for further details or reduce color by 70% with RMR09 and 10% of DH100 by weight Do not use volume to add reducer and hardener.

Solid Colors

See SmartTRAK for further details or add 7% of DH100 by weight. Do not use volume to add hardener.

Pot Life of Mixed Product:

Usable same day with hardener

Product Tips:

RMR09 ONYX HD Low VOC Slow Reducer should replace VR0 100% when slow drying properties are required.

Please, use the same reducer amount showed in the SmartTRAK color formulas when replacing VR0 with RMR09.





Basecoats

ONYX HD

for Low VOC Productive System Using RMR09 ONYX HD Low VOC Slow Reducer

Application



Apply 2 to 3 medium wet coats (to hiding); optional 1 mist coat for metallic / effect colors if needed. Allow 5 to 10 minutes flash between coats. Metallic colors will dry to a matte finish. Solid colors will dry to a semi-gloss finish. Allow final coat to flash at least 15 minutes before applying clearcoat. If needed when dry, tack off the entire vehicle or repair area with a clean rag.

Blending:

Follow below two blending procedures for ONYX HD Low VOC Productive System colors. When making repairs the size of a soccer ball or smaller in temperatures of 30°C/85°F it is beneficial to use a pressure of 16-20psi and a gun tip and needle of 1.5 mm.

Blend Bed

- Mix 2 parts SB01 to 1 part RMR09 to 10% DH100.
- Apply one coat of catalyzed SB01 to the entire blend area.
- · Allow 5 to 10 minutes Flash.
- Proceed with the application of the color.
- · Apply to uniform finish

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap;19-26 psi at gun (HVLP/HE) for hot weather: 16-20 psi at gun

Fluid Tip:

(HE Gravity) 1.3-1.4 mm (HVLP Gravity) 1.3-1.4 mm (For best results a 1.4 mm tip is recommended) (HVLP Gravity) for hot weather: 1.5 mm

Wet Bed

- Mix 2 parts SB01 to 1 part RMR09 to 10% DH100.
- Apply one coat of catalyzed SB01 to the entire blend area.
- Proceed with the application of color before a complete flash of the SB01, apply color and work color blend accordingly.
- · Apply to uniform finish

Tech Data:

Viscosity: 11-14 sec. #4 Ford cup

Thickness: 0.5-1.5 mils

Coverage: Will vary depending on the color VOC as Applied: 420 gms/ltr (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 15 to 30 minutes





Basecoats

ONYX HD

for Low VOC Productive System Using VR0 Low VOC Reducer

Product Details



The R-M ONYX HD Low VOC Productive System is an advanced topcoat that provides similar drying properties of solventborne basecoats. Because of its solventborne nature, ONYX HD Low VOC Productive System is easy to use and its drying properties are less negatively affected by increase in humidity commonly found in collision repair centers. ONYX HD Low VOC Productive System meets all current low VOC regulations in North America with 420 gms/ltr (3.5 lbs/gal) or less VOC content (ready for use).

Products:

Hardeners

DH100 Low VOC Hardener

Clears

SB01 Low VOC Mixing Clear All VOC Compliant R-M Clears and Undercoats

- without flexed or matte additives

Other Products

SB01 Low VOC Mixing Clear SB02 Quick-Dry Basecoat Adjuster SB03 Quick-Dry Color Adjuster SB04 Quick-Dry Color Booster SB05 Quick-Dry Mixing Clear For Solids

Reducers

VR0 Low VOC Reducer

Mixing



Metallic Colors

See SmartTRAK for further details or reduce color by 70% with VR0 and 10% of DH100 by weight. Do not use volume to add reducer and hardener.

Solid Colors

See SmartTRAK for further details or add 7% of DH100 by weight. Do not use volume to add hardener.

Blending:

Follow below two blending procedures for ONYX HD Low VOC Productive System colors.

When making repairs the size of a soccer ball or smaller in temperatures of 30°C/85°F it is beneficial to use a pressure of 16-20psi and a gun tip and needle of 1.5 mm.





Basecoats

ONYX HD

for Low VOC Productive System Using VR0 Low VOC Reducer

Mixing (Cont.)



Blend Bed

- Mix 2 parts SB01 to 1 part RMR09 to 10% DH100.
- Apply one coat of catalyzed SB01 to the entire blend area.
- Allow 5 to 10 minutes Flash.
- Proceed with the application of the color.
- · Apply to uniform finish

Pot Life of Mixed Product:

Usable same day with hardener

Product Tips:

For Toners Intermix formula see SmartTRAK.

Must use the recommended hardener.

Mixed colors (without VR0 and DH100) have a 30 day shelf-life.

For underhood solution, please see SmartTRAK/SmartCOLOR.

Application



Apply 2 to 3 medium wet coats (to hiding); optional 1 mist coat for metallic / effect colors if needed. Allow 5 to 10 minutes flash between coats. Metallic colors will dry to a matte finish. Solid colors will dry to a semi-gloss finish. Allow final coat to flash at least 15 minutes before applying clearcoat. If needed when dry, tack off the entire vehicle or repair area with a clean rag.

Wet Bed

to 10% DH100.

· Apply to uniform finish

Mix 2 parts SB01 to 1 part RMR09

Apply one coat of catalyzed SB01

 Proceed with the application of color before a complete flash of the SB01, apply color

and work color blend accordingly.

to the entire blend area.

Spray Pressure:

(HE Gravity) 8-10 psi at air cap; 19-26 psi at gun

for hot weather: 16-20 psi at gun

Fluid Tip:

(HE Gravity) 1.3-1.4 mm

(HVLP Gravity) 1.3-1.4 mm

(For best results a 1.4 mm tip is recommended)

(HVLP Gravity) for hot weather: 1.5 mm







Basecoats

ONYX HD

for Low VOC Productive System Using VR0 Low VOC Reducer

Application



Tech Data:

Viscosity: 11-14 sec. #4 Ford cup Thickness: Thickness 0.5-1.5 mils

Coverage: Coverage Will vary depending on the color

VOC as Applied 420 gms/ltr (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 15 to 30 minutes

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Safety





Clearcoats R-M R-M R-M CR DC21NB CR DC01NB **DC92** AM960 AM2100 111111 - 815 BASF -BASF -BASF DIRECT PROPERTY. 7.8 TA NA DC5335 **DC98** DC5100 CTR Clear Venis ATC Barrie ATC DC5300 CTR Baking Glear Versis RTC poor cuitson Barnis RTC de Cocer -BASF -BASF -BASF DOMEST.











AM100 Aero-Max Cut-In Clear

Product Details



AM100 Cut-In Clear is a 1K, fast drying clearcoat for use in door jambs, under hood and cut-ins. Available in an easy to use aerosol container. AM100 can be applied over R-M Basecoats.

Mixing



Ready to spray

Application



Shake aerosol can for one minute after mixing ball rattles and spray to test. Spray distance 6"- 8".

Apply 3 to 4 medium wet coats allowing 5 minutes flash between coats

Tech Data:

Total Mill Thickness: 1.5-2.0 Coverage: 76.6 sq ft/gal @ 1 mil

VOC as Applied: 708 gms/ltr (5.9 lbs/gal)

Post Application



Drying:

20°C/68°F: 45 to 60 mins

60°C/140°F: 30 minutes (Flash 15 minutes before baking) 70°C/160°F: 30 minutes (Flash 15 minutes before baking)

Sanding/Polishing:

Wet Sand 1200 grit or finer

Notes





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AM100 Aero-Max Cut-In Clear

<u>Notes</u>		
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Safety







AM2100 Aero-Max 2K Urethane Clear

Product Details



AM2100 is a 2K urethane clear in a convenient aerosol container that can be used over R-M Basecoats.

Mixing



Activation:

Take red button from cap and attach it to the pin on the aerosol bottom.

Put aerosol with cap upside down on a stable ground. Press red button with ball of your hand until stop is reached. Shake aerosol vigorously before and after activating for 2 minutes minimum. Contents after activation is good for only 1 day.

Application



Shake aerosol can for one minute after mixing ball rattles and spray to test.

Spray distance 6"- 8".

Apply 2 to 3 coats allowing 5 minutes flash between coats

Tech Data:

Thickness: 1.5-2.0 mils

Coverage: 76.6 sq ft/gal @ 1 mil

VOC as Applied: 659 gms/ltr (5.5 lbs/gal)

Post Application



Drying:

20°C/68°F 60 to 90 mins 50°C/120°F 10 to 15 minutes

Sanding/Polishing:

Wet Sand - 1200 grit or finer

Product Tip:

Turn container over and spray to clear nozzle when spraying is complete.

Notes



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AM2100 Aero-Max 2K Urethane Clear

<u>Notes</u>		
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Safety







AM960 Aero-Max Spot Blender

Product Details



AM960 Spot Blender is a 1K, spot blender that provides a smooth blend edge of the clearcoat repair area.

Mixing



Ready to spray

Application



Shake aerosol can for one minute after mixing ball rattles and spray to test. Spray distance 6"- 8".

Apply 2 to 3 light coats until blend is achieved 1 to 2 minutes flash between coats

Tech Data:

VOC as Applied: 729 gms/ltr (6.1 lbs/gal)

Post Application



Drying:

20°C/68°F

Refer to clearcoat technical data sheet

Sanding/ Polishing:

Wet Sand - 3000 to 4000 grit Light polish as needed

Product Tips:

Do not let last coat of clear dry.

For best results apply AM960 30 seconds after last coat of clear is applied.

Notes



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AM960 Aero-Max Spot Blender

<u>Notes</u>		
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Safety







DC01NB Energy Saving Speed Clear

Product Details



DC01NB Energy Saving Speed Clear is a Super Fast, no-bake, two component acrylic urethane clear. DC01NB flash time between coats is 3-5 minutes and it can be buffed after 15-30 minutes under air-dry conditions. DC01NB Clear produces a high gloss, durable automotive finish that is recommended for spot repair and up to 3 panel repairs for topcoating Diamont and ONYX HD basecoat colors.

Products:

Hardeners

DH16 Normal Hardener DH18 Slow Hardener

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

<u>Mixing</u>



Mixing Ratio: 3:1:15%

3 parts DC01NB 1 part DH16 or DH18 15% UR Reducer

DH18 hardener can be used under high temperature conditions in combination with high temperature reducers.

Lower amounts of reducer can be used depending on the technician's choice. 15% of UR Reducer is the maximum amount recommended.

Product Tip:

Reducers can be intermixed to achieve custom blends best suited to your environment

Pot Life of Mixed Product:

1 hour @ 20°C/68°F











DC01NB Energy Saving Speed Clear

Application



Apply 2 medium wet coats allowing 3 to 5 minutes flash between coats

Spray Pressure:

(HVLP/HE) 9 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.5 mm (HVLP Gravity) 1.4-1.5 mm

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Thickness: 1.7-2.0 mils

Coverage: 269 sq ft/gal @ 2.0 mils

VOC as Applied: 503 gms/ltr (4.2 lbs/gal)

Post Application



Drying:

20°C/68°F

Dust Free Dry Time to Handle 4 to 7 minutes 15 to 30 minutes

Please note that the dry time will be slightly longer when the material is flexed.

Buff and Polish Time:

15 to 30 minutes

Sanding/ Polishing:

Wet Sand - 1200 grit or finer

Product Tip: May be baked for 15 minutes at 50°C/120°F if desired.

Flex Procedures

Flex Mixing



Mixing Ratio:

Step 1 - 5:1

5 parts DC01NB 1 part DF21 Step 2 - 3:1:15%

3 parts DC01NB/DF21 mixture 1 part DH16 or DH18 15% UR Reducer

DH18 hardener can be used under high temperature conditions in combination with high temperature reducers. Lower amounts of reducer can be used depending on the technician's choice. 15% of UR Reducer is the maximum amount recommended.









DC01NB Energy Saving Speed Clear

Flex Procedures (cont.)

Flex Application



Apply 2 medium wet coats allowing 3 to 5 minutes flash between coats

Tech Data:

Viscosity: 14-16 sec. #4 Ford cup Coverage: 327 sq ft/gal @ 2.0 mils

VOC as Applied: 410 gms/ltr (4.2 lbs/gal)

Post Application



Please note that the dry time will be slightly longer when the material is flexed.

Product Tips:

May be baked for 15 minutes at 50°C/120°F if desired.

Do not use DH14.

DH18 hardener can be used under high temperature conditions in combination with high temperature reducers.

Lower amounts of reducer can be used depending on the technician's choice. 15% of UR Reducer is the maximum amount recommended.

Suede Texturing Procedures

Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

25%: Fine Texture 50% Medium Texture









DC01NB Energy Saving Speed Clear

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color) allowing 10 minutes flash between coats.

Spraying distance: 12 in / 30 cm

Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

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Safety











Clearcoats

DC100 Jammin' Clear

Product Details



DC100 Jammin' Clear is a 1K, fast drying ready-to-spray clearcoat for use in door jambs, under hood and cut-ins. DC100 is designed to be used over R-M basecoats. DC100 is a specialty coating as defined under the U.S. VOC standard for automobile refinish coatings, 63 FR 48806.

Mixing



Ready for use

Pot Life:

Indefinite

Application



Apply 3 to 4 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 9-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.1-1.3 mm

Tech Data:

Viscosity: 13-14 sec. #4 Ford cup

Thickness: 1.5-2.0 mils

Coverage: 130 sq ft/gal @ 1.5 mil

VOC as Applied: 745 gms/liter (6.22 lbs/gal)

Post Application



Drying:

20°C/68°F 30 to 60 minutes **60°C/140°F** 35 minutes **70°C/160°F** 30 minutes

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance: 25%: Fine Texture

50% Medium Texture



DC100 Jammin' Clear

Suede Texturing Procedures (cont.) Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.)
Allowing 10 minutes flash between coats.
Spraying distance: 12 in / 30 cm
Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

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Safety







Clearcoats

DC5100 CTR Clear

Product Details



DC5100 CTR Clear is a two component, high build, acrylic urethane clear for topcoating Diamont or ONYX HD Basecoat colors. Applied at 4.2 VOC, DC5100 meets 5.0 VOC requirements while producing a very glossy, durable and chemically resistant automotive finish. DC5100 has excellent flow and leveling, good sag resistance, is user friendly and has fast drying properties. Activate DC5100 with DH14 for small panel application, DH16 for large panel application or DH18 for larger panel and warm weather application. No reduction is necessary.

Products:

Hardeners

DH14 Fast Hardener DH16 Normal Hardener DH18 Slow Hardener

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

<u>Mixing</u>



Mixing Ratio: 3:1

3 parts DC5100 1 part DH14, DH16 or DH18

Pot Life:

1 to 1.5 hours @ 20°C/68°F

Application



Apply 2 medium wet coats allowing 5 minutes flash between coats If it is not practical to clearcoat the entire panel and blending of the clear is necessary (e.g., roof pillar), remelt the clearcoat edge with UBR200 Blending Solvent (1 part clear/ hardener/reducer + 5 parts UBR200) using reduced air pressure to the spray gun. The blending of clear into a panel is not covered under the R-M warranty.

Spray Pressure:

(HVLP/HE) 9-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 14-16 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 283 sq ft/gal @ 2.0 mils VOC as Applied: 503 gms/ltr (4.2 lbs/gal)





DC5100 CTR Clear

Post Application



Drying

Dust Free Dry Time

20°C/68°F 10 to 12 minutes 90 minutes

50°C/120°F N/A 10 to 15 minutes (see note)

Infra red short wave 5 to 7 minutes

Sanding/ Polishing: Wet Sand - 1200 grit or finer

Product Tips:

Dry time to handle at 20°C/68°F - 30 minutes Cure schedule is based on metal temperature and does not take into consideration any purge or ramp-up time. After cool down the job is ready to buff.

Flex Procedures

Flex Mixing



Mixing Ratio: 4:1:2:4

- 4 parts DC5300
- 1 part DF21
- 2 parts DH42, DH44, DH46 or DH47
- 4 parts UR Reducer

Tech Data:

Coverage: 296 sq ft/gal @ 2.0 mils VOC as Applied: 515 gms/ltr (4.3 lbs/gal)

Flex Application



Apply 2 medium wet coats allowing 5 to 15 minutes flash between coats

- Do use 809 Fisheye Eliminator in DC5300 if necessary.
- Do bake immediately for best results.
- Do use the DC5300 mixture within 2.5 hours for best results.
- Do use DH47 for hot weather conditions.
- Do use DH42 in cool weather to decrease dry time.
- Do add up to a maximum of 1 ounce of Jet95 to improve cure time at 140°F. (1 ounce equates to 25 grams Jet95 per gallon of unhardened DC5300 Clear.)
- Do add up to a maximum of 3 ounces of Jet95 to improve cure time at 120°F. (3 ounces equates to 75 grams Jet95 per gallon





DC5100 CTR Clear

Low Gloss Procedures

To matte, add SM09 by volume as follows:

Low Gloss Mixing



Satin Gloss Step 1

> 70 parts DC5100 30 parts SM09

Step 2

4 parts matte mixture
1 part DH42/44/46
1 part appropriate reducer

Matte Gloss Step 1

> 50 parts DC5100 50 parts SM09

Step 2

4 parts matte mixture1 part DH42/44/461 part appropriate reducer

Low Gloss Application



Apply 2 to 3 coats (usually requires 1 more coat than the full gloss clear) allowing 5 to 10 minutes flash between coats. Bake after last coat is fully matte if force drying.

Additional Procedures:

- Gloss level is dependent on spray technique. Spray lighter/drier coats to maintain low gloss levels.
- The addition of SM09 slightly reduces the pot life of the topcoat.
- Do not attempt to recoat until the final coat has dried a minimum of 24 hours.
- This Product is for U.S. National Rule VOC ONLY. Stir product well before using.
- Do use 809 Fisheye Eliminator if necessary, add up to 1/2 ounce per quart of RFU clear.

Do not sand or polish.

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

25%: Fine Texture 50% Medium Texture





DC5100 CTR Clear

Suede Texturing Procedures (cont.) Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.)
Allowing 10 minutes flash between coats.
Spraying distance: 12 in / 30 cm

Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Cut In Procedures Cut In Mixing



Mixing Ratio:

Step 1 - 1:1

1 part DC5100

1 part Diamont Basecoat unreduced

Step 2 - 3:1

3 parts DC5100/Diamont Basecoat mixture 1 part DH14

Product Tips:

Use Diamont Basecoat unreduced. Use DH14 only.

Pot Life of Mixed Product:

2 hours







DC5100 CTR Clear

Cut In Procedures (cont.) Cut In Application



Apply 2 medium wet coats allowing 5 minutes flash between coats. By using DC5100 and unreduced Diamont Basecoat intermixed, a durable finish can be obtained for cut ins such as door jambs.

Cut In Post Application



Drying:

20°C/68°F 1 hour 50°C/120°F 15 minutes

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Safety







DC5300 CTR Baking Clear

Product Details



DC5300 CTR Baking Clear is a very high solids, two component, high build, acrylic urethane baking clearcoat used to topcoat Diamont or ONYX HD Basecoat colors. Applied at 4.1 VOC, DC5300 meets 5.0 VOC requirements while producing a very glossy, durable and chemically resistant automotive finish. DC5300 is recommended for baking conditions ranging in temperature from 100°F to 180°F. DC5300 must be activated with DH42 for spot and small panel repairs, DH46 for large panel applications and completes at temperatures less than 85°F or DH47 for large panel and complete applications at temperatures greater than 85°F.

Products:

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 3:1:1

3 parts DC5300

1 part DH42, DH44, DH46 or DH47

1 part UR Reducer appropriate to spray temperature

UR30	Polar Spot Repair	
UR40	Fast Spot Repair	
UR50	Normal	55°F-70°F
UR60	Warm	70°F-95°F
UR70	Hot	85°F-100°F
UR100	Slow 100+	

Product Tip:

Reducers can be intermixed to achieve custom blends best suited to your environment

Pot Life of Mixed Product:

30-45 mins w/ DH42 @ 24°C/75°F 2-2.5 hours w/ DH46 @ 24°C/75°F







DC5300 CTR Baking Clear

Application



Apply 2 medium wet coats allowing 5 to 10 minutes flash between coats. If it is not practical to clearcoat the entire panel and blending of the clear is necessary (e.g., roof pillar), remelt the clearcoat edge with UBR200 Blending Solvent (1 part clear/ hardener/reducer + 5 parts UBR200) using reduced air pressure to the spray gun. The blending of clear into a panel is not covered under the R-M warranty.

DH47

10 min

Spray Pressure:

(HVLP/HE) 9-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Thickness: 2.0-2.5 mils

Viscosity: 15-17 sec. #4 Ford cup Coverage: 362 sq ft/gal @ 2.0 mils VOC as Applied: 491 gms/ltr (4.1 lbs/gal)

Post Application



Drying:

20°C/68°F	1 hr	3 hrs	N/A
38°C/100°F	20 to 25 min	35 to 40 min	N/A
50°C/120°F	15 to 20 min	25 to 30 min	N/A
60°C/140°F	N/A	20 min	30 to 35 min*
71°C/160°F	N/A	N/A	15 min

DH46

N/A

N/A

DH42

Infra Red short wave 10 to 12 minutes

Product Tips:

82°C/180°F

Vehicle can be immediately recoated, sanded and compounded when cooled. Temperatures referenced above are booth temperatures, except where noted otherwise.

Sanding/ Polishing:

Wet Sand - 1200 grit or finer Dry Sand - 1200 grit or finer







^{* 10} minutes if metal temp = 140°F

Clearcoats

DC5300 CTR Baking Clear

Flex Procedures

Flex Mixing



Mixing Ratio: 4:1:2:4

- 4 parts DC5300
- 1 part DF21
- 2 parts DH42, DH44, DH46 or DH47
- 4 parts UR Reducer

Pot Life of Mixed Product:

2 to 2.5 hours @ 20°C/68°F

Application



Tech Data:

Coverage: 362 sq ft/gal @ 2.0 mils VOC as Applied: 491 gms/ltr (4.1 lbs/gal)

Flex Application



Apply 2 medium wet coats over Diamont or ONYX HD basecoats allowing 5 to 15 minutes flash between coats relating to surface tension. Additional flash will be required for flexed products.

Additional Procedures:

- Bake immediately for best results.
- Add up to a maximum of 1 ounce of Jet95 to improve cure time at 140°F.
- 1 ounce equates to 25 grams Jet95 per gallon of unhardened DC5330 Clear.
- Add up to a maximum of 3 ounces of Jet95 to improve cure time at 120°F.
- 3 ounces equates to 75 grams Jet95 per gallon of unhardened DC5330 Clear.
- R-M 809 Fisheye Eliminator is specially developed for use in R-M Clearcoats. Only use if fisheyes are encountered.
- Add up to 2 ounces of R-M 809 Fisheye Eliminator per ready for use gallon of R-M Clears. Do not use in Diamont or ONYX HD Basecoat Colors or any R-M Undercoat.

P-M DC5300 CTR Baling Clear Were a real of the Core Sensitive of C

Notes







DC5300 CTR Baking Clear

Low Gloss Procedures

To matte, add SM09 by volume as follows:

Low Gloss Mixing



Satin Gloss Step 1

> 70 parts DC5330 30 parts SM09

Step 2

4 parts matte mixture 1 part DH42/44/46

1 part appropriate reducer

Matte Gloss

Step 1

50 parts DC5330 50 parts SM09

Step 2

4 parts matte mixture 1 part DH42/44/46

1 part appropriate reducer

Low Gloss Application



Apply 2 to 3 coats (usually requires 1 more coat than the full gloss clear) allowing 5 to 10 minutes flash between coats. Bake after last coat is fully matte if force drying.

Additional Procedures:

- Gloss level is dependent on spray technique. Spray lighter/drier coats to maintain low gloss levels.
- The addition of SM09 slightly reduces the pot life of the topcoat.
- Do not attempt to recoat until the final coat has dried a minimum of 24 hours.
- This Product is for U.S. National Rule VOC ONLY. Stir product well before using.
- Do use 809 Fisheye Eliminator if necessary, add up to 1/2 ounce per quart of RFU clear.

Do not sand or polish.

Suede Texturing Procedures **Suede Texturing Mixing**



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

> 25%: Fine Texture 50%: Medium Texture









Clearcoats

DC5300 CTR Baking Clear

Low Gloss Procedures (cont.)

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats.

Spraying distance: 12 in / 30 cm

Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

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Safety











Clearcoats

DC5335 Glamour Clear

Product Details



- · One Panel to complete refinishing
- · High Gloss, High Glamour Clear
- Same day buffability
- OEM approved
- Performance, productivity and affordability with a premium finish

Products:

Hardeners

DH42 Low Temp Fast DH44 Medium DH46 Normal

DH47 High Temp Slow

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder VR0 Exempt Slow VR29 Exempt Fast

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

<u>Mixing</u>



Mixing Ratio: 4:1:1

- 4 Parts DC5335
- 1 Part DH42/44/46/47
- 1 Part Reducer appropriate to spray temperature

UR30	Polar Spot Repair	
UR40	Fast Spot Repair	
UR50	Normal	55°F-70°F
UR60	Warm	70°F-95°F
UR70	Hot	85°F-100°F
UR100	Slow 100+	
VR0	Exempt Slow	
VR29	Exempt Fast	

Product Tip: Reducers can be intermixed to achieve custom blends best suited to your environment

Pot Life of Mixed Product:

1.5 to 2 Hours @ 20°C / 68°F









BASE

DC5335

DC5335 Glamour Clear

Application



Apply 2 medium wet coats allowing 5 to 15 minutes flash between coats relating to surface tension.

Spray Pressure:

(HVLP/HE) 9-10 psi at air cap

Fluid Tip:

(HVLP Gravity) 1.3-1.5 mm

Tech Data:

Thickness 2.0-2.5 mils
Viscosity 14-16 sec. #4 Ford cup
Coverage 325 sq. ft/gal @ 2.0 mils
VOC as Applied UR Series Reducers
503 gms/ltr (4.2 lbs/gal)
VR Series Reducers
407 gms/ltr (3.4 lbs/gal)

Post Application



Drying:

20°C/68°F 3 hours 50°C/120°F 45 minutes 60°C/140°F 30 minutes Infra-Red short wave 10 to 12 minutes

De Nib and Polish:

Allow to fully cool after bake cycle
De Nib for dirt with 1200-1500
Polish with a premium finishing system

Flex Procedures

Flex Mixing



Mixing Ratio:

Step 1 - 4:1

4 parts DC5335 1 part DF21

Step 2 - 3:1:1

3 parts DC5335/DF21 mixture 1 part DH42, DH46 or DH47 1 part UR or VR Reducer

Pot Life of Mixed Product:

6 hours @ 20°C/68°F



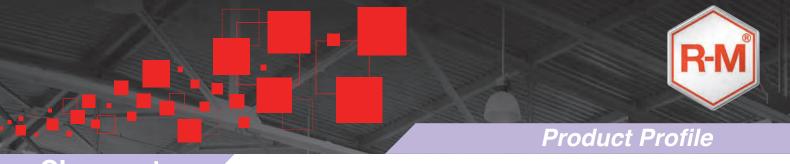






BASE

DC5335



DC5335 Glamour Clear

Flex Procedures (cont.)

Flex Application



Apply 2 medium wet coats over Diamont or ONYX HD basecoats allowing 5 to 15 minutes flash between coats relating to surface tension. Additional flash will be required for flexed products.

Additional Procedures:

- · Bake immediately for best results.
- Add up to a maximum of 1 ounce of Jet95 to improve cure time at 140°F.
- 1 ounce equates to 25 grams Jet95 per gallon of unhardened DC5335 Clear.
- Add up to a maximum of 3 ounces of Jet95 to improve cure time at 120°F.
- 3 ounces equates to 75 grams Jet95 per gallon of unhardened DC5335 Clear.
- R-M 809 Fisheye Eliminator is specially developed for use in R-M Clearcoats. Only use if fisheyes are encountered.
- Add up to 2 ounces of R-M 809 Fisheye Eliminator per ready for use gallon of R-M Clears. Do not use in Diamont or ONYX HD Basecoat Colors or any R-M Undercoat.

Tech Data:

VOC as Applied

UR Series Reducers 491 gms/ltr (4.2 lbs/gal)

VR Series Reducers 370 gms/ltr (3.4 lbs/gal)

Low Gloss Procedures

To matte, add SM09 by volume as follows:

Low Gloss Mixing



Satin Gloss Step 1

> 70 parts DC5335 30 parts SM09

Step 2

4 parts matte mixture

1 part DH42/44/46

1 part appropriate reducer

Matte Gloss

Step 1

50 parts DC5335 50 parts SM09

Step 2

4 parts matte mixture 1 part DH42/44/46

1 part appropriate reducer











DC5335 Glamour Clear

Low Gloss Procedures (cont.)

Low Gloss Application



Apply 2 to 3 coats (usually requires 1 more coat than the full gloss clear) allowing 5 to 10 minutes flash between coats. Bake after last coat is fully matte if force drying.

Additional Procedures:

- Gloss level is dependent on spray technique. Spray lighter/drier coats to maintain low gloss levels.
- The addition of SM09 slightly reduces the pot life of the topcoat.
- Do not attempt to recoat until the final coat has dried a minimum of 24 hours.
- This Product is for U.S. National Rule VOC ONLY. Stir product well before using.
- Do use 809 Fisheye Eliminator if necessary, add up to 1/2 ounce per quart of RFU clear.

Do not sand or polish.

Suede Texturing Procedures

Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance: 25%: Fine Texture 50% Medium Texture

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm

Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes













Clearcoats

DC5335 Glamour Clear

Safety















Clearcoats

DC5600 CTR Production Clear

Product Details



DC5600 CTR Production Clear is a fast drying, two-component acrylic urethane clear for topcoating Diamont or ONYX HD Basecoat colors. DC5600 Clear produces a very glossy, durable and chemically resistant automotive finish. DC5600 Clear is recommended for spot repair and up to 2 panel repairs.

Products:

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 4:1:1

4 parts DC5600

1 part DH42, DH44, DH46 or DH47

1 part UR Reducer

Pot Life (Sprayable):

2 hours w/ DH42 @ 20°C/68°F

Application



Apply 2 medium wet coats allowing 2 to 5 minutes flash between coats. If it is not practical to clearcoat the entire panel and blending of the clear is necessary (e.g., roof pillar), remelt the clearcoat edge with UBR200 Blending Solvent (1 part clear/ hardener/reducer + 5 parts UBR200) using reduced air pressure to the spray gun. The blending of clear into a panel is not covered under the R-M warranty.

Spray Pressure:

(HVLP/HE) 9-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 14-16 sec. #4 Ford cup Thickness: 2.0-2.5 mils

2.5 hours w/ DH46 @ 20°C/68°F

Coverage: 282 sq ft/gal @ 2.0 mils

VOC as Applied: 492 gms/ltr (4.1 lbs/gal)







-BASE

DC5600 CTR Production Clear

Post Application



Dust Free Dry Time to Handle 20°C/68°F 10 minutes 1.5 to 2 hours

50°C/120°F N/A 15 to 20 minutes with DH42

60°C/140°F N/A 10 to 15 minutes with DH46, DH47

Infra Red short wave 6 to 8 minutes

After baking vehicle can be immediately recoated, sanded and compounded when cooled. Temperatures referenced above are booth temperatures.

Sanding/ Polishing:

Wet Sand - 1500 grit or finer Dry Sand - 1500 grit or finer

Product Tips:

24" masking is all that is required, however, when using DH42 with DC5600, 18" masking paper can be used without the overspray adhering to the adjacent finish.

Flex Procedures

Flex Mixing



Mixing Ratio: 4:2:2:3

4 parts DC5600

2 part DF21

2 parts DH42, DH44, DH46 or DH47

3 part UR Reducer

Flex Application



Apply 2 medium wet coats allowing 2 to 5 minutes flash between coats

- Do use 809 Fisheye Eliminator in DC5600 if necessary.
- Do use DH42 in cool weather to decrease dry time.
- · Do bake immediately for best results.
- Do use the DC5600 mixture within 2.5 hours for best results.
- Do allow DC5600 to dry 8 hours before recoating or attempting to remove dirt

Tech Data:

VOC as Applied: 515 gms/ltr (4.3 lbs/gal)









DC5600 CTR Production Clear

Low Gloss Procedures

To matte, add SM09 by volume as follows:

Low Gloss Mixing



Satin Gloss Step 1

> 70 parts DC5600 30 parts SM09

Step 2

4 parts matte mixture
1 part DH42/44/46
1 part appropriate reducer

Matte Gloss

Step 1

50 parts DC5600 50 parts SM09

Step 2

4 parts matte mixture 1 part DH42/44/46 1 part appropriate reducer

Low Gloss Application



Apply 2 to 3 coats (usually requires 1 more coat than the full gloss clear) allowing 5 to 10 minutes flash between coats.

Bake after last coat is fully matte if force drying.

Do not sand or polish.

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal
Add MT900 as follows to achieve the desired appearance:
25%: Fine Texture
50% Medium Texture

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.)
Allowing 10 minutes flash between coats.

Spraying distance: 12 in / 30 cm

Bake immediately after last coat if force drying.









DC5600 CTR Production Clear

Suede Texturing Procedures (cont.) Suede Texturing Application (cont.)



Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Cut In Procedures Cut In Mixing



Mixing Ratio:

Step 1 - 1:1

1 part DC5100

1 part Diamont Basecoat unreduced

Step 2 - 3:1

3 parts DC5100/Diamont Basecoat mixture 1 part DH14

Cut In Application



Apply 2 medium wet coats allowing 5 minutes flash between coats. By using DC5100 and unreduced Diamont Basecoat intermixed, a durable finish can be obtained for cut ins such as door jambs.

Cut In Post Application



Drying:

20°C/68°F 1 hour 50°C/120°F 15 minutes











Clearcoats

DC5600 CTR Production Clear

<u>Notes</u>		
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Safety













Clearcoats

DC5775 Ultra Flat Clear

National Rule

Product Details



DC5775 Ultra Flat Clear is a two-component acrylic urethane clear for topcoating Diamont and ONYX HD Basecoat colors. DC5775 Clear produces an ultra flat, durable, and chemically resistant automotive finish. For proper gloss appearance, follow the application steps carefully.

Pre-flexed for use over flexible parts

Products:

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio National Rule: 4:1:1

4 parts DC5775

1 part DH42, DH44 or **DH46***

1 part VR Reducer

Pot Life of Mixed Product:

2 hours@ 20°C/68°F

Application



National Rule Steps

- 1) Over reduce clear by mixing DC5335 4:1:2 with proper DH hardener (DH42, DH44 or DH46) and VR reducer.
- After basecoat has been applied and flashed off completely, apply 2 medium wet coats of DC5335 clearcoat allowing 5 - 10 minutes flash time between coats.
- If possible, use formula found at SmartTrak, SmartColor or www.basfrefinish.com.
- 3) Very Important! Use calibrated scale to mix exact amounts by weight at a ratio of 4:1:1 of DC5775 with proper DH hardener (DH42, DH44 or DH46) and VR reducer.









DC5775 Ultra Flat Clear

National Rule

Application (cont.)



National Rule Steps (cont.)

4) After 2nd coat of DC5335 is flashed, apply first coat of DC5775 medium wet making sure to apply evenly. Very Important! Allow first coat of DC5775 to flash approximately 15 minutes. (This will be affected by air temperature and air movement). If you apply the second coat before the first coat has become uniformly dull, the second coat will trap too much solvent making it dry mottled and inconsistent in the "puddle areas" or wetter areas.
5) Apply 2nd coat of DC5775 medium wet evenly over area.

Spray Pressure:

(HVLP/HE: 9-10 psi cap (see MFG gun recommendations)

Fluid Tip:

(HE Gravity) : 1.3 mm (HVLP Gravity) : 1.3 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 2.5-3.0 mils

Coverage: 542 sq ft/gal @ 2.0 mils VOC as Applied: 419 gms/ltr (3.5 lbs/gal)

Post Application



Drying:

20°C/68°F 2 to 4 hours 60°C/140°F 30 to 45 minutes

* The slower the drying (DH46) the higher the gloss will be.

Product Tips:

Must follow application steps closely and observe proper flash times For proper matte appearance.

Does not require flex agent on flexible parts.

20° gloss < 10

It's a good idea to make notes of hardeners, reducers, flash times, tip size and booth temp. The more you adhere to the original "set-up" the more consistency in matching sheen you will have down the road when you find yourself in a touch up or redo situation.

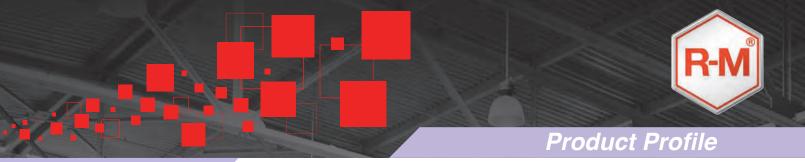
Always weigh your Clear, Hardener and Reducer to exact measure to ensure consistency and rematch for future problems.











DC5775 Ultra Flat Clear

National Rule

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance: 25%: Fine Texture 50% Medium Texture

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Safety











DC92 High Solids Clear

Product Details



DC92 High Solids Clear is a two component, high build, acrylic urethane clear for topcoating Diamont or ONYX

Products:

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener DH47 Slow Hardener

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar UR40 Fast UR50 Normal UR60 Mid to Hot UR70 High Temp UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

<u>Mixing</u>



Mixing Ratio: 3:1:20%

3 parts DC92 1 part DH42, DH44, DH46 or DH47 20% UR Reducer

Pot Life of Mixed Product:

3 hours @ 20°C/68°F

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats. If it is not practical to clearcoat the entire panel and blending of the clear is necessary (e.g., roof pillar), remelt the clearcoat edge with UBR200 Blending Solvent (1 part clear/ hardener/reducer + 5 parts UBR200) using reduced air pressure to the spray gun. The blending of clear into a panel is not covered under the R-M warranty.

Spray Pressure:

(HVLP/HE) 9-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm

Tech Data:

Viscosity: 18-20 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 323 sq ft/gal @ 2.0 mils VOC as Applied: 503 gms/ltr (4.2 lbs/gal)



DC92 High Solids Clear

Post Application



Drying:

20°C/68°F 4 to 5 hours 60°C/140°F 30 to 45 minutes

Recoat 24 hours Compound 24 hours

Sanding/Polishing:

Wet Sand - 1200 grit or finer

Flex Procedures

Flex Mixing



Mixing Ratio: 5:1:2:4

- 4 parts DC92
- 1 part DF21
- 2 parts DH42, DH44, DH46 or DH47
- 4 parts UR Reducer

Flex Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats

Tech Data:

Viscosity: 16-19 sec. #4 Ford cup

Thickness: 1.8 to 2.2 mils

Coverage: 264 sq ft/gal @ 2.0 mils

VOC as Applied: 587 gms/ltr (4.9 lbs/gal)

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DC92 High Solids Clear

Low Gloss Procedures

To matte, add SM09 by volume as follows:

Low Gloss Mixing



Satin Gloss Step 1

> 70 parts R-M clear 30 parts SM09

Step 2

4 parts matte mixture
1 part DH42/44/46
1 part appropriate reducer

Matte Gloss Step 1

> 50 parts R-M clear 50 parts SM09

Step 2

4 parts matte mixture 1 part DH42/44/46 1 part appropriate reducer

Low Gloss Application



Apply 2 to 3 coats (usually requires 1 more coat than the full gloss clear) allowing 5 to 10 minutes flash between coats. Bake after last coat is fully matte if force drying.

Additional Procedures:

- Gloss level is dependent on spray technique. Spray lighter/drier coats to maintain low gloss levels.
- The addition of SM09 slightly reduces the pot life of the topcoat.
- Do not attempt to recoat until the final coat has dried a minimum of 24 hours.
- This Product is for U.S. National Rule VOC ONLY. Stir product well before using.
- Do use 809 Fisheye Eliminator if necessary, add up to 1/2 ounce per quart of RFU clear.

Do not sand or polish.

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

25%: Fine Texture 50% Medium Texture



DC92 High Solids Clear

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.)

Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

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Safety







DC21NB Low VOC Energy Saving Speed Clear

Product Details



DC21NB Low VOC Energy Saving Speed Clear is a Super Fast, no-bake, two component acrylic urethane clear. DC21NB flash time between coats is 3-4 minutes and it can be buffed after 15-30 minutes under air-dry conditions. DC21NB Low VOC Clear produces a high gloss, durable automotive finish that is recommended for spot repair and up to 3 panel repairs for topcoating ONYX HD basecoat colors.

Products:

Hardeners Reducers

DH100 Low VOC Hardener VR0 Exempt Slow DH105 Low VOC Hardener - High Temp VR29 Exempt Fast

Flex Agents

DF21 Flex Agent

Mixing



Mixing Ratio: 4:1:1

4 parts DC21NB 1 part DH100

1 part VR Reducer

Product Tip:

DH105 hardener can be used under high temperature conditions in combination with high temperature reducers.

Pot Life of Mixed Product:

45 minutes - 1 hour @ 20°C/68°F

Application



Apply 2 Medium wet coats allowing 3 to 4 minutes flash between coats

Spray Pressure: Tech Data:

(HVLP/HE) 9 psi at air cap Viscosity: 13-15 sec. #4 Ford cup Thickness: 1.7-2.0 mils

Fluid Tip:

(HE Gravity) 1.4-1.5 mm (HVLP Gravity) 1.4-1.5 mm Coverage: 262 sq ft/gal @ 2.0 mils VOC as Applied: 240 gms/ltr (2.0 lbs/gal)











DC21NB Low VOC Energy Saving Speed Clear

Post Application



Drying:

Dust Free

Dry Time to Handle

22°C/72°F

5 to 15 minutes

15 to 30 minutes

Buff and Polish Time:

15 to 30 minutes

Sanding:

Wet Sand - 1200 grit or finer

Product Tip:

May be baked for 15 minutes at 50°C/120°F if desired. Do not use DH99.

Flex Procedures

Application



Apply 2 Medium wet coats allowing 3 to 4 minutes flash between coats

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup Coverage: 298 sq ft/gal @ 2.0 mils

VOC as Applied: 180 gms/ltr (2.0 lbs/gal)

Flex Mixing



Mixing Ratio:

Step 1 - 5:1

5 parts DC21NB 1 part DF21 Step 2 - 4:1:1

4 parts DC21NB/DF21 mixture

1 part DH100

1 part VR Reducer

Pot Life of Mixed Product:

45 minutes - 1 hour @ 20°C/68°F

Post Application



Buff and Polish Time:

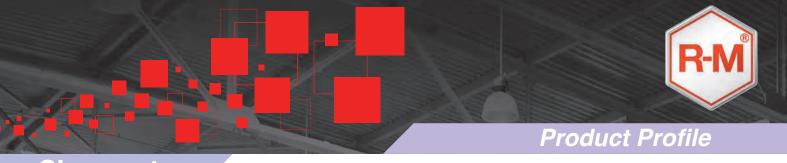
45 to 60 minutes







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DC21NB Low VOC Energy Saving Speed Clear

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

25%: Fine Texture 50% Medium Texture

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Safety

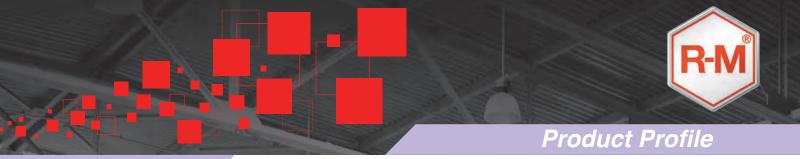












DC98 2.0 VOC Clearcoat

Product Details



DC98 2.0 VOC Clearcoat is a two component acrylic urethane clear for topcoating ONYX HD Basecoat Colors. Applied at 2.0 mils, DC98 will meet a combined basecoat/clearcoat VOC average of 3.5 lbs/gal when using ONYX HD Basecoats. DC98 produces a very glossy, durable and chemically resistant automotive finish.

Products:

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener DH105 Low VOC Hardener - High Temp

Flex Agents

DF21 Flex Agent

Reducers

UR30 Polar
UR40 Fast
UR50 Normal
UR60 Mid to Hot
UR70 High Temp
UR100 Retarder

50-70 Single Panel 70-85 Multi Panel 80+ Multi Panel Overall Slow

Mixing



Mixing Ratio: 3:1:10%

3 parts DC98 1 part DH99, DH100 or DH105 10% UR Reducer

Pot Life of Mixed Product:

1 hour @ 20°C/68°F

Application



Apply 2 to 3 wet coats allowing 10 minutes flash between coats. If it is not practical to clearcoat the entire panel and blending of the clear is necessary (e.g., roof pillar), remelt the clearcoat edge with UBR200 Blending Solvent (3 part clear/ hardener/reducer + 1 part UBR200 + 1 part VR0 or VR29) using reduced air pressure to the spray gun. The blending of clear into a panel is not covered under the R-M warranty.



DC98 2.0 VOC Clearcoat

Application (cont.)



Spray Pressure:

HVLP/HE 8-10 psi at air cap

Fluid Tip:

HE Gravity 1.5 mm HVLP Gravity 1.5 mm

Post Application



Drying:

20°C/68°F 2 to 3 hours 60°C/140°F 30 minutes Infra Red short wave 8 to 9 minutes

Polishing:

After 24 hours

Flex Procedures

Flex Mixing



Mixing Ratio:

Step 1 - 4:1

4 parts DC98 1 part DF21 Step 2 - 3:1:10%

3 parts DC98/DF21 mixture 1 part DH100 or DH105 10% UR Reducer

Tech Data:

Viscosity: 15-16 sec. #4 Ford cup

Coverage: 320 sq ft/qal (2.0 mils)

VOC as Applied: 240 gms/ltr (2.0 lbs/gal)

Thickness: 2.0-2.5 mils

Pot Life of Mixed Product:

1 hour @ 20°C/68°F

Flex Application



Apply 2 to 3 wet coats allowing 10 minutes flash between coats

Product Tip:

DC98 must be activated with DH100 or DH105.

Tech Data:

Coverage: 320 sq ft/gal (2.0 mils)

VOC as Applied: 240 gms/ltr (4.2 lbs/gal)



DC98 2.0 VOC Clearcoat

Low Gloss Procedures

To matte, add SM09 by volume as follows:

Low Gloss Mixing



Satin Gloss Step 1

> 70 parts DC98 30 parts SM09

Step 2

4 parts matte mixture

1 part DH42/44/46

1 part appropriate reducer

Low Gloss Application



Apply 2 to 3 coats (usually requires 1 more coat than the full gloss clear) allowing 5 to 10 minutes flash between coats. Bake after last coat is fully matter if force drying.

Additional Procedures:

- Gloss level is dependent on spray technique. Spray lighter/drier coats to maintain low gloss levels.
- The addition of SM09 slightly reduces the pot life of the topcoat.
- Do not attempt to recoat until the final coat has dried a minimum of 24 hours.
- This Product is for U.S. National Rule VOC ONLY. Stir product well before using.
- Do use 809 Fisheye Eliminator if necessary, add up to 1/2 ounce per quart of RFU clear.

Do not sand or polish.

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

25%: Fine Texture 50% Medium Texture



DC98 2.0 VOC Clearcoat

Suede Texturing Procedures (cont.) Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

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Safety







Clearcoats

DC5775 Ultra Flat Clear

Low VOC

Product Details



DC5775 Ultra Flat Clear is a two-component acrylic urethane clear for topcoating ONYX HD Basecoat colors. DC5775 Clear produces an ultra flat, durable, and chemically resistant automotive finish. For proper gloss appearance, follow the application steps carefully.

Pre-flexed for use over flexible parts

Products:

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio LOW VOC 2.0: 4:1:1

- 4 parts DC5775
- 1 part DH99 or DH100*
- 1 part VR Reducer

Pot Life of Mixed Product:

3 hours @ 20°C/68°F

Application



Low VOC 2.0 Steps

- 1) Over reduce clear by mixing DC5800 4:1:2 with proper DH hardener (DH99 or DH100) and VR reducer.
- 2) After basecoat has been applied and flashed off completely, apply 2 medium wet coats of DC5800 clearcoat allowing proper flash time between coats.
- If possible, use formula found at SmartTrak, SmartColor or www.basfrefinish.com.
- 3) **Very Important!** Use calibrated scale to mix exact amounts by weight at a ratio of 4:1:1 of DC5775 with proper DH hardener (DH99 or DH100) and VR reducer.









^{*} The slower the drying (DH100) the higher the gloss will be.

DC5775 Ultra Flat Clear

Low VOC

Application (cont.)



Low VOC 2.0 Steps (cont.)

4) After 2nd coat of DC5800 is flashed, apply first coat of DC5775 medium wet making sure to apply evenly.

Very Important! Allow first coat of DC5775 to flash approximately 15 minutes. (This will be affected by air temperature and air movement). If you apply the second coat before the first coat has become uniformly dull, the second coat will trap too much solvent making it dry mottled and inconsistent in the "puddle areas" or wetter areas.

5) Apply 2nd coat of DC5775 medium wet evenly over area.

Spray Pressure:

(HVLP/HE) 9-10 psi cap (see MFG gun recommendations)

Fluid Tip:

(HE Gravity) : 1.3 mm (HVLP Gravity) : 1.3 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 2.5-3.0 mils

Coverage: 542 sq ft/gal @ 2.0 mils

VOC as Applied: 240 gms/ltr (2.0 lbs/gal)

Post Application



Drying:

20°C/68°F 2 to 4 hours 60°C/140°F 30 to 45 minutes

* The slower the drying (DH100) the higher the gloss will be.

Product Tips: Must follow application steps closely and observe proper flash times for proper matte appearance.

Does not require flex agent on flexible parts.

20° gloss < 10

It's a good idea to make notes of hardeners, reducers, flash times, tip size and booth temp. The more you adhere to the original "set-up" the more consistency in matching sheen you will have down the road when you find yourself in a touch up or redo situation.

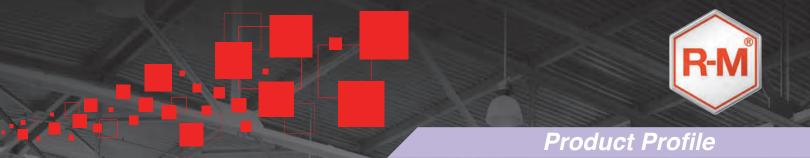
Always weigh your Clear, Hardener and Reducer to exact measure to ensure consistency and rematch for future problems.











DC5775 Ultra Flat Clear

Low VOC

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance: 25%: Fine Texture

50% Medium Texture

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Safety













Clearcoats

DC5800 2.0 CTR Clear

Product Details



DC5800 2.0 CTR Clearcoat is a two component acrylic urethane clear for topcoating ONYX HD Basecoat Colors. Applied at 2.0 mils, DC5800 will meet a combined basecoat/clearcoat VOC average of 3.5 lbs/gal when using ONYX HD Basecoat. DC5800 produces a very glossy, durable and chemically resistant automotive finish. DC5800 is recommended for spot and panel repair.

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Products:

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener

Flex Agents

DF21 Flex Agent

DF2

<u>Mixing</u>



Mixing Ratio: 4:1:1

4 parts DC5800

1 part DH99 or DH100

1 part VR Reducer

Pot Life of Mixed Product:

1 to 2 hours @ 20°C/68°F

Application



Apply 2 to 3 wet coats allowing 3 to 5 minutes flash between coats. If it is not practical to clearcoat the entire panel and blending of the clear is necessary (e.g., roof pillar) remelt the clearcoat edge with UBR200 Blending Solvent (3 part clear/hardener/reducer + 1 part UBR200 + 1 part VR Reducer) using reduced air pressure to the spray gun. The blending of clear into a panel is not covered under the R-M warranty.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.5 mm (HVLP Gravity) 1.5 mm

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 282 sq ft/gal @ 2.0 mils

VOC as Applied: 239.5 gms/ltr (2.0 lbs/gal)



DC5800 2.0 CTR Clear

Post Application



Drying:

Dust Free 20°C/68°F 15 minutes

60°C/140°F N/A

Dry Time to Handle 1.5 to 2 hours 20 to 30 minutes

Sanding:

Wet Sand - 1500 grit or finer Dry Sand - 1500 grit or finer

Polishing:

After 2 hours (air dry) After cool down (bake)

Flex Procedures

Flex Mixing



Mixing Ratio: 4:2:2:1

4 parts DC5800

2 part DH99 or DH100

2 parts VR Reducer

1 part DF21

Flex Application



Apply 2 to 3 wet coats allowing 5 minutes flash between coats

Tech Data:

VOC as Applied: 239.5 gms/ltr (2.0 lbs/gal)

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

25%: Fine Texture 50% Medium Texture







Clearcoats

DC5800 2.0 CTR Clear

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

<u>Notes</u>	
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Safety









Clearcoats

DC5900 Low VOC Pre-Flexed Clear

Product Details



DC5900 Low VOC Pre-Flexed Clear is a two component acrylic urethane clear for topcoating Diamont or ONYX HD Basecoat Colors. DC5900 produces a very glossy, durable and chemically resistant automotive finish. DC5900 may be used for spot and panel repairs and overall applications.

Products:

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener DH105 Low VOC Hardener - High Temp

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio

1-4 Panels: 4:1:1

4 parts DC5900

1 part DH99, DH100 or DH105

1 part VR Reducer

Overalls: 4:1

4 parts DC5900

1 part DH99, DH100 or DH105

Pot Life of Mixed Product:

3 to 4 hours @ 20°C/68°F

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.5 mm (HVLP Gravity) 1.5 mm

Tech Data:

Viscosity: 13-16 sec. #4 Ford cup

Thickness: 2.0-2.5 mils Coverage: 4:1:1

534 sq ft/gal @ 1.0 mil

4:1

641 sq ft/gal @ 1.0 mil

VOC as Applied: 239.5 gms/ltr (2.0 lbs/gal)





Clearcoats

DC5900 Low VOC Pre-Flexed Clear

Post Application



Drying:

20°C/68°F 2 hours 60°C/140°F 30 minutes

Sanding:

Wet Sand - 1500 grit or finer Dry Sand - 1500 grit or finer

Polishing:

After 2 hours (air dry) After cool down (bake)

Suede Texturing Procedures Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal
Add MT900 as follows to achieve the desired appearance:
25%: Fine Texture
50% Medium Texture

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.)
Allowing 10 minutes flash between coats.
Spraying distance: 12 in / 30 cm

Bake immediately after last coat if force drying.

Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes







Clearcoats

DC5900 Low VOC Pre-Flexed Clear

<u>Notes</u>	

Safety









Clearcoats

DC5995 Low VOC Glamour Clear

Product Details



DC5995 Low VOC Glamour Clear is a two component, high solids, acrylic urethane clear that can be applied over Diamont or ONYX HD basecoat colors. DC5995 Low VOC Glamour Clear produces a high gloss, durable and chemical resistant finish.

Products:

Hardeners

DH99 Low VOC Fast Hardener DH100 Low VOC Hardener DH105 Low VOC Hardener - High Temp

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Mixing



Mixing Ratio: 4:1:1

4 parts DC5995

1 part DH99, DH100 or DH105

1 part VR Reducer

DH105 hardener can be used under high temperature conditions.

Pot Life:

3-4 hours @ 20°C/68°F

Application



Apply 2 medium wet coats allowing 3 to 4 minutes flash between coats

Spray Pressure:

(HVLP/HE) 9 psi at air cap

Fluid Tip:

(HE Gravity) 1.4-1.5 mm (HVLP Gravity) 1.4-1.5 mm

Tech Data:

Viscosity: 14-16 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Coverage: 334 sq ft/gal @ 2.0 mils VOC as Applied: 240 gms/ltr (2.0 lbs/gal)

Post Application



Drying:

Dust Free Dry Time to Handle

22°C/72°F 30 minutes 2 hours



Clearcoats

DC5995 Low VOC Glamour Clear

Post Application (cont.)



Buff and Polish Time:

30 minutes after bake

Sanding:

Wet Sand - 1500 grit or finer

Product Tip:

May be baked for 30 minutes at 60°C/140°F if desired.

Flex Procedures

Flex Mixing



Mixing Ratio:

Step 1 -8:1

8 parts DC5995 1 part DF21 Step 2 - 4:1:1

4 parts DC5995/DF21 mixture 1 part DH99, DH100 or DH105

1 part VR Reducer

Flex Application



Apply 2 medium wet coats allowing 3 to 4 minutes flash between coats

Suede Texturing Procedures

Suede Texturing Mixing



Mixing Ratio: MT900 usage levels

Activate desired clearcoat formula as normal Add MT900 as follows to achieve the desired appearance:

25%: Fine Texture 50% Medium Texture

Suede Texturing Application



Apply 2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Allowing 10 minutes flash between coats. Spraying distance: 12 in / 30 cm Bake immediately after last coat if force drying.





Clearcoats

DC5995 Low VOC Glamour Clear

Suede Texturing Application (cont.)



Product Tips:

The addition of MT900 slightly reduces the pot life of the topcoat. Stir product well before using.

Drying Time:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

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Safety





Special/AUX







Special/AUX

812 Fisheye Eliminator

Product Details



R-M 812 Fisheye Eliminator is specially designated to reduce the effects of silicone contamination. Use with UNO HD and only use when absolutely necessary and NEVER exceed the recommended quantities. In the event of the appearance of craters or fisheyes, add 1/4 to 1/2 cap of R-M 812 to one quart ready for use UNO HD color (1/2 cap max.). Apply one to two very fine coats in the areas where fisheyes have formed. Allow the solvents to flash off between coats. Continue the application of your UNO HD color according to recommended procedures.

Notes		

Safety







Special/AUX

822 Adhesion Promoter

Product Details



822 Adhesion Promoter is a 1K, non-sanding, clear adhesion promoter. It is formulated to promote the adhesion of Diamont basecoat/clearcoat to factory applied cured finishes.

Preparation



Cleaning:

Wash with soap and water and rinse thoroughly. Scuff and clean with R-M 900, 901 or 909.

Mixing



Ready to spray

Application



Apply 1 light coat

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

Fluid Tip (HE Gravity): 1.3-1.5 mm Fluid Tip (HVLP Gravity): 1.3-1.5 mm

Tech Data:

Viscosity: 16-18 sec. #4 Ford cup

Thickness: 0.2-0.5 mils

Pot Life: N/A

Coverage: 106 sq. ft./gal. @ 0.5 mil VOC as Applied: 803 gms/ltr (6.7 lbs/gal)

Post Application



Drying:

25°C/75°F 15 minutes

Product Tips: Use for spot repairs and small sand throughs. Do not apply 2K polyester putties, 2K epoxy coatings or waterborne basecoats over.







Special/AUX

822 Adhesion Promoter

<u>Notes</u>	

Safety









Special/AUX

BC00 Base Clear

Using BC00 as a Uniform Finish Blender

In addition to its usual function as a mixing clear for Carizzma Dyes, you may use BC00 as a uniform finish blender for Diamont Basecoat. And with its excellent clarity, BC00 will give cleaner blends when compared to using BC100.

The use of a uniform finish blender, or orientation coat, serves two purposes. First, it provides a wet bed that allows metallic flakes to lie down properly. Next, it melts in the dry overspray on the blend panel. Use the following procedures to achieve a homogenous, undetectable basecoat blend with BC00. Option 1 is recommended for colors that are particularly difficult to blend.

Using BC00 as a Uniform Finish Blender: Option 1

- 1. Perform the repair by following recommended procedures.
- 2. Sand the entire panel with P1200-1500 grit paper.
- 3. Apply 1-2 coats of Diamont Basecoat beyond the repair area. Flash-off for 5-7 minutes between coats.
- 4. Apply one coat of BC00 (mixed 2:1 with UR series reducer) over the entire panel. Flash-off for 5-7 minutes.
- 5. Blend out the final coat of Diamont; flash off for 15 minutes or until matte.
- 6. Apply approved R-M clearcoat to entire panel.

Using BC00 as a Uniform Finish Blender: Option 2

- 1. Perform the repair by following recommended procedures.
- 2. Sand the entire panel with P1200-1500 grit paper.
- 3. Apply one coat of BC00 (mixed 2:1 with UR series reducer) over the entire panel. Flash-off for 5-7 minutes.
- 4. Apply 1-2 coats of Diamont Basecoat beyond the repair area. Flash-off for 5-7 minutes between coats.
- 5. Blend out the final coat of Diamont: flash off for 15 minutes or until matte.
- 6. Apply approved R-M clearcoat to entire panel.

Note that while BC00 has a very clear profile when dried, it should not be used as a clear coat especially over dark colors. It will leave a slight milky appearance if not covered with basecoat. This will be readily noticeable over black and other very dark colors.





Special/AUX

BC00 Base Clear

<u>Notes</u>	
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Safety







Special/AUX

MT900 Suede Texture

Texturing Agent

Product Details



MT900 Suede Texture is a texturing agent that enables users to add texture to UNO HD and R-M clears to match the original appearance of painted plastic parts. Various textures can be achieved, according to requirements; from fine to medium. MT900 is easy to use, compatible with UNO HD and R-M clears and can be combined with SM09 Flattener-Special MAT09.

Products:

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener R-M Clears UR Series Reducers UNO HD Color

Mixing



Mixing Ratio

Option 1 See UNO HD formulas with MT900.

Option 2 To texture all other UNO HD colors and R-M clears, activate desired color formula as normal, then add 25% - 50% MT900 to achieve the desired appearance.

Note: The addition of MT900 slightly reduces the pot life of the topcoat.

Application



2 to 3 coats (usually requires 1 more coat than standard non-textured color.) Spraying distance: 12 in/30 cm

10 minutes flash between coats

Bake immediately after last coat if force drying.

Spray Pressure:

(HVLP/HE) 6 psi at air cap

Fluid Tip:

(HE Gravity) 1.3-1.5 mm (HVLP Gravity) 1.3-1.5 mm







Special/AUX

MT900 Suede Texture

Texturing Agent

Application (cont.)



Tech Data:

Viscosity: 18-20 sec. #4 Ford cup

Thickness: 2.0-2.5 mils

Pot Life: 2-3 hours @ 20°C/68°F Coverage: 350 sq ft/gal (2.0 mils)

VOC as Applied: 503-539 gms/ltr (4.2-4.5 lbs/gal)

Post Application



Drying:

20°C/68°F 90 minutes 60°C/140°F 30 minutes

Sanding/Polishing: NA

MT900 usage levels:

25%: Fine Texture 50%: Medium Texture

Stir product well before using.

Safety









Special/AUX

SM09 Flattener - Special MAT09

Universal Matting Agent

Product Details



SM09 Flattener - Special MAT09 is a matting agent which allows one to reduce the gloss level of National Rule VOC compliant R-M clears and UNO HD colors. SM09 is easy to use, allows different degrees of gloss (from total matte to semi-gloss), is pourable and can be combined with MT900 Texturing agent to create low gloss textured coatings.

Products:

Clearcoats

DC92 High Solids Clear DC5100 CTR Clear DC5120 CTR Fast Clear DC5300 CTR Baking Clear DC5335 Glamour Clear DC5600 CTR Production Clear

Mixing



Mixing Ratio

Mixing Ratio To matte, add SM09 by volume as follows:

Low Gloss UNO HD

Satin Gloss

70 parts UNO HD color 30 parts SM09 25 parts DH42, DH44,DH46 25 parts UR Reducer

Matte Gloss

50 parts UNO HD color 50 parts SM09 25 parts DH42, DH44,DH46 25 parts UR Reducer











Special/AUX

SM09 Flattener - Special MAT09

Universal Matting Agent

Mixing (cont.)



Mixing Ratio

Mixing Ratio To matte, add SM09 by volume as follows:

Low Gloss R-M Clearcoat

Satin Gloss

Step 1: 70 parts R-M clear

30 parts SM09

Step 2: Mix the SM09/clear mixture

as indicated on the clearcoat's

technical data sheet

Matte Gloss

Step 1: 70 parts R-M clear

30 parts SM09

Step 2: Mix the SM09/clear mixture

as indicated on the clearcoat's

technical data sheet

Application



Apply 2 to 3 coats (usually requires 1 more coat than the full gloss color) allowing 5 to 10 minutes flash between coats. Bake immediately after last coat if force drying.

Product Tips:

This Product is for U.S. National Rule VOC ONLY.

Stir product well before using.

When using SM09 in R-M clearcoats, use the appropriate hardener as indicated on the product's technical data sheet.

Gloss level is dependent on spray technique.

Spray lighter/drier coats to maintain low gloss levels.

The addition of SM09 slightly reduces the pot life of the topcoat.











Special/AUX

SM09 Flattener - Special MAT09

Universal Matting Agent

<u>Notes</u>		
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Safety













Special/AUX

UBR200 Blending Solvent

as a Uniform Finish Coating

Product Details



The reduced mil thickness of a clearcoat blend edge may cause the edge to become visible with time. Aggressive polishing and harsh weather conditions will accelerate this process.

Consequently, BASF will not normally guarantee the blend edges of clearcoats. To be eligible for the R-M warranty, clearcoat must be applied to the entire panel or repaired according to the R-M CTR Repair System by a CTR certified painter.

R-M developed UBR200 Blending Solvent specifically for situations when clearcoating an entire panel is not possible. UBR200 is a unique blend of solvents designed to melt in dry overspray and blend edges of R-M Clearcoats and UNO-HD. Using UBR200 to melt in clear edges is not covered under the R-M warranty.

Application



- 1. Let final blended coat of clear flash off for 5 minutes.
- 2. For optimal performance
 - a. 840 g/l (7.0 lb/gal) VOC Regulated Areas: mix 5 parts of UBR200 to 1 part R-M Clearcoat (RFU).
 - b. 540 g/l (4.5 lb/gal) VOC Regulated Areas:mix 1 part of UBR200 :3 parts DC98 or DC5800 (RFU) : 1 part VR0 or VR29.
- 3. With reduced air pressure, apply 1-2 coats of above mixture over blend edges.
- 4. Allow 5-7 minutes flash between coats of UBR200 mixture.
- 5. Allow clearcoat to cure according to the recommendations in the R-M technical manual.

Product Tips:

UBR200 can also be used to blend the final coat of UNO-HD. To achieve an undetectable blended finish with UNO-HD, please follow the procedure mentioned above replacing the ready-for-use clearcoat with ready-for-use UNO-HD.











Special/AUX

UBR200 Blending Solvent

as a Uniform Finish Coating

<u>lotes</u>	

Safety













Special/AUX

BC100 Base Clear

Product Details



BC100 Base Clear can be used with Carizzma and R-M Extreme Colors

<u>Notes</u>	

Safety





Special/AUX

BCH2 Basecoat Hardener

Product Details



BCH2 Basecoat Hardener can be used with R-M Carizzma, Diamont Basecoats, Diamont Basecoat D121, R-M Extreme Colors.

<u>Notes</u>	

Safety







Special/AUX

HB10S Ultra Flash Flake

Application



Repair process with water-thinnable products for a fast, economical quality finish in compliance with ninternational VOC legislation.

1. Edge to edge repair

1-1. Substrates

R-M undercoats or full cured, solvent resistant old paint work.

1-2. Pretreatment

- 1) Apply guide coat.
- 2) Sand substrates with a dual action sander and P500 grit sand paper.
- 3) Reapply guide coat.
- 4) Sand with a dual action sander and P1000 grit sand paper, to cover the sanding marks from the P500.
- 5) Degrease with 909.

Product Tips: If the rough surface of primer filler remains, it will result in a scaly appearance. If the sand-scratch marks from the P500 remains, it will affect the surface quality by mottling or telegraphing the sand-scratches. Use guide coat to control the sanding process. Use soft interface pad for orbital sander.

1-3. Application of HB055 Onyx Blender Pro II

Volume

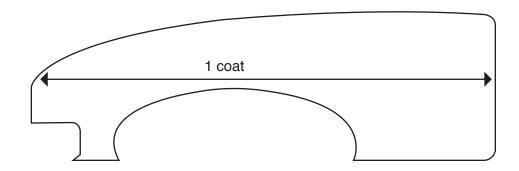
Mixing ratio: HB055 100 parts

HB020 or HB040 60 parts

Spray coats: 1 wet

Flash off time: 15 minutes 68°F / 20°C Spray gun setting: HVLP 1.3 - 1.4 mm

Product Tips: For ground coat, apply wet coat to avoid generating peel on the surface. Allow the total dry time to expire in order to avoid creating a scaly surface.





Special/AUX

HB10S Ultra Flash Flake

Application (cont.)



1. Edge to edge repair (continued)

1-4. Application of ONYX HD containing HB10S Ultra Flash Flake

ONYX HD HB10S shade as supplied by distributor.

Volume

Mixing ratio: ONYX HD HB10S shade 100

HB040 Hydromix Slow 60 - 80

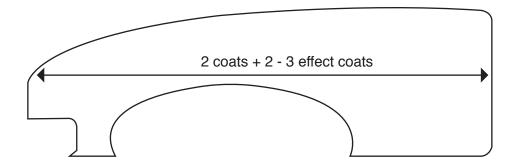
(Stir immediately after having added adjusting base)

Spray coats: 2 medium wet plus 2 - 3 effect coats

Flash off time: Flash off until matte after each single coat.

Spray gun setting: HVLP 1.3 - 1.4 mm

Product Tips: Use of tack rag is not recommended in between coats once effect coats have been applied. Inspect for unevenness and mottling using artificial light in booth with lights turned off.



1-5. Application of DC- clear

Apply DC- clear according to technical information.



Special/AUX

HB10S Ultra Flash Flake

Application



Repair process with water-thinnable products for a fast, economical quality finish in compliance with international VOC legislation.

2. Blend-in technique

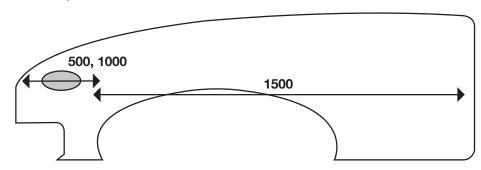
2-1. Substrates

R-M undercoats or full cured, solvent resistant old paint work.

2-2. Pretreatment

- 1) Sand filler surfacer area with a dual action sander and P500 grit sand paper.
- 2) Sand with a dual action sander and P1000 grit sand paper, to cover the sanding marks from the P500.
- 3) Sand with a dual action sander and P1500 grit sand paper on the fade out zone.
- 4) Degrease with 909.

Product Tips: If the rough surface of primer filler remains, it will result in a scaly appearance. If the sand-scratch marks from the P500 remains, it will affect the surface quality by mottling or telegraphing the sand-scratches. Use sanding guide to control the sanding process. Use soft interface pad for orbital sander.



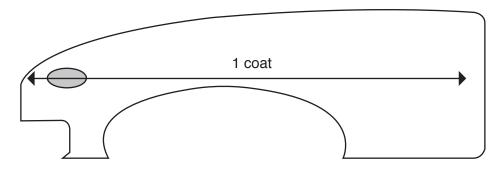
2-3. Application of HB055 Onyx Blender Pro II (1)

Volume
Mixing ratio: HB055 100 parts

HB020 or HB040 60 parts

Spray coats: 1

Flash off time: flash off until matte Spray gun setting: HVLP 1.3 - 1.4 mm





Special/AUX

HB10S Ultra Flash Flake

Application (cont.)



2. Blend-in technique (continued)

2-4. Application of ONYX HD HB10S Ultra Flash Flake

ONYX HD HB10S shade as supplied by distributor.

Volume

100

Mixing ratio: ONYX HD HB10S

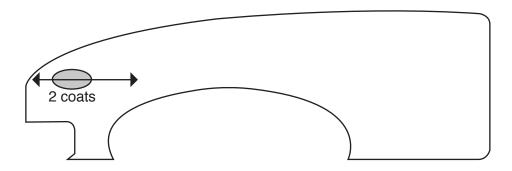
HB040 Hydromix Slow 60 - 80

(Stir immediately after having added adjusting base)

Spray coats: 2 medium wet

Flash off time: Flash off until matte after each single coat.

Spray gun setting: HVLP 1.3 - 1.4 mm



2-5. Application of HB055 Onyx Blender Pro II (1)

Volume

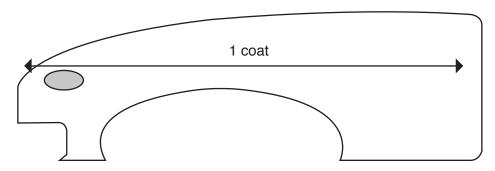
Mixing ratio: HB055 100 parts

HB020 or HB040 60 parts

Spray coats: 1

Flash off time: flash off until matte Spray gun setting: HVLP 1.3 - 1.4 mm

Product Tips: Before the effect coats of ONYX HD, apply a wet coat of HB055 on the blending area to avoid overspray mist.





Special/AUX

HB10S Ultra Flash Flake

Application (cont.)



Repair process with water-thinnable products for a fast, economical quality finish in compliance with international VOC legislation.

2. Blend-in technique (continued)

2-6. Application of ONYX HD HB10S Ultra Flash Flake

ONYX HD HB10S shade as supplied by distributor.

Volume

Mixing ratio: ONYX HD color 100

HB040 Hydromix Slow 60 - 80

(Stir immediately after having added adjusting base)

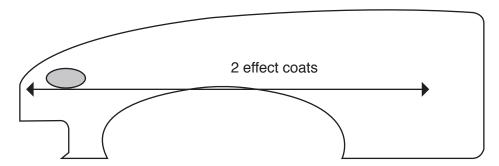
Spray coats: 2 - 3 effect coats

Flash off time: Flash off until matte after each single coat

Spray gun setting: HVLP 1.3 - 1.4 mm

Product Tips:

Use of tack rag is not recommended in between coats once effect coats have been applied. Inspect for unevenness and mottling using artificial light in booth with lights turned off.



2-7. Application of DC- clear

Apply DC- clear according to technical information.



Special/AUX

HB10S Ultra Flash Flake

<u>lotes</u>	

Safety





Special/AUX

HR50 Blending Solvent

Product Details



HR50 Blending Solvent is a specially developed product for blending. It can be used with UNO HD, is easy to use, quick drying and ensures successful blends.

Products:

Color

UNO HD Color

Hardeners

DH46 Normal Hardener

Mixing



Mixing Ratio:

Untinted 1+2%

1 part HR50 2% DH46 Tinted 1:5

1 part Activated UNO HD 5 parts HR50

Pot Life of Mixed Product:

1 hour

Product Tips:

For dark shades (blacks, dark blues, etc.) is it recommended that the tinted option be used.

Application



Apply 1 to 2 coats allowing 2 to 5 minutes flash between coats

Spray Pressure:

(HVLP/HE) 10 psi at air cap

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup

Thickness: 0.2 mil

Coverage: 175 sq ft/gal @ (1.0 mil)

VOC as Applied: 786 gms/liter (6.6 lbs/gal)

Fluid Tip:

(HE Gravity) 1.3 mm (HVLP Gravity) 1.3 mm





Special/AUX

HR50 Blending Solvent

Post Application



Drying:

60°C/140°F 30 minutes

Sanding:

Sand the repair area with the recommended grit paper (P400-P600). Compound or ultra fine sand the undamaged area with P1500 (or finer).

Polishing:

If polishing is necessary use only a fine or non abrasive polish.

<u>Notes</u>	

Safety









Special/AUX

PA897 Epoxy Primer Activator

Product Details



PA890 Epoxy Prlmer Activator is used with the EP Series Chromate Free Epoxy Primers.

<u>Notes</u>	

Safety













Special/AUX

UA97 Polyuroxy Activator

Product Details



UA97 Polyuroxy Activator is used with Polyuroxy

<u>Notes</u>	
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Safety













Special/AUX

801 Metal Conditioner

Product Details



R-M 801 Metal Conditioner is a metal etching, acid type of cleaner which leaves an adherent phosphate coating. For use on bare steel and aluminum to clean and mildly etch the metal prior to priming. Improves adhesion and minimizes rust creepage resulting in a more durable finish. It is used to neutralize soldering flux; remove light rust; promote adhesion of subsequent coatings. R-M 801 is also non-flammable.

Mixing



Mixing Ratio: 1:2

1 part 801 2 parts Water

Product Tips:

Proper results will be obtained only when Metal Conditioner is reduced with water as directed. Do not let 801 Metal Conditioner dry on substrate before wiping off.

Application



Wipe On

Apply one thin coat of R-M 801 Metal Conditioner with a clean cloth or brush. Heavily rusted areas should be scrubbed with steel wool made wet with R-M 801 mixture. Allow R-M 801 to remain on the metal for a minute or longer. Do not let dry. While still wet, wipe the Metal Conditioner off with a clean, dry cloth.

Tech Data:

VOC as Applied (weight of VOC pervolume of material) 25 gms/ltr (0.12 lbs/gal)

VOC as Applied (minus water and exempt solvents) 191 gms/ltr (1. 6 lbs/gal)







Special/AUX

801 Metal Conditioner

Safety









Special/AUX

R-M 825 Hydropure

Product Details



R-M 825 Hydropure is a powder that is added to leftover ONYX HD waterborne basecoat waste water The 825 reacts with the solids in the paint and coagulates. The solid material can be disposed of according to local regulations, and the leftover clear liquid can be used to clean spray guns.

Mixing



Mixing Ratio:

Mixing Ratio 30 - 35 grams per gallon of waste water.

Application



Add 825 Hydropure by scattering the powder evenly and stir briefly. You may add more 825 Hydropure when the waste water does not become clear after 15 minutes.

Product Tips:

Once the coagulated substance has been separated, the clear, aqueous part may be used again for pre-cleaning spray guns, which are finally rinsed with fresh water.

Notes



<u>Safety</u>











Special/AUX

809 Fisheye Eliminator

Product Details



R-M 809 Fisheye Eliminator is specially developed for use in R-M Clearcoats. Only use if fisheyes are encountered. Add up to 2 ounces of R-M 809 Fisheye Eliminator per ready for use gallon of R-M Clears. Do not use in Diamont or ONYX HD Basecoat Colors or any R-M Undercoat.

<u>Notes</u>		

Safety









Special/AUX

915 Waterborne Gun Cleaner

Product Details



R-M 915 is a Waterborne Gun Cleaner designed to clean spray equipment after using the ONYX HD system.

Mixing



Ready for Use

Application



915 Waterborne Gun Cleaner should be used to clean spray equipment after use of ONYX HD.

Tech Data:

VOC as Applied 918 gms/ltr (7.7 lbs/gal)

Product Tip:

Keep from freezing.

Notes



Safety









Special/AUX

BCH10 Basecoat Hardener

Product Details



BCH10 Basecoat Hardener can be used with Carizzma, ONYX HD, DC5800, DC98 and DC5100.

<u>Notes</u>	

Safety







Special/AUX

DF21 Flex Agent

Product Details



R-M DF21 Flex Agent is a flexible agent used in both Low VOC and National Rule areas.

<u>Notes</u>		
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Safety







Special/AUX

HB055 Onyx Blender Pro II

Product Details



ONYX Blender Pro II is used either as a uniform finish blender or as a additive in ONYX HD. It will help cover sanding marks in fade out areas and will also absorb overspray during the blending process. ONYX Blender Pro II eliminates a dark, blotchy side tone caused by poorly orientated effect pigments.

Products:

Hardeners

BCH10 Basecoat Hardener

Other Products

HB020 Hydromix HB040 Hydromix Slow ONYX HD Waterborne Basecoat

Mixing



Orientation Coat

HB055 100 parts HB020 or HB040 60 parts

Additive in ONYX HD

HB055 - RFU 100 parts ONYX HD - RFU 100 parts

With hardener

Orientation Coat

HB055 100 parts HB020 or HB040 60 parts BCH10 5%

Additive in ONYX HD

Step 1: ONYX HD mixing formula 100 parts

HB020 or HB040 80 parts

BCH10 5%

Step 2: Above mixture 100 parts

HB055 (orientation mix) 100 parts

Pot Life of Mixed product:

When mixed with BCH10 15 to 30 minutes

Application



Apply 1 wet coat alllowing 2 to 5 minutes flash until slightly matte, for best results blend color into HB055 while still wet.

Spray Pressure:

(HVLP/HE) 8-10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3 mm-1.5 mm (HVLP Gravity) 1.3 mm

Tech Data:

Viscosity: 21-24 sec. #4 Ford cup Coverage: 158 sq ft/gal @ 0.5 mil

VOC as Applied: VOC as Applied 420 gms/

Itr (3.5 lbs/gal)



Special/AUX

HB055 Onyx Blender Pro II

Application (cont.)



Product Tips:

Over reduction with HB020 or HB040, while possible, may result in crawling when using a large spray gun tip or during high humidity.

Shelf life: 12 months from manufactured date.

Keep HB055 from freezing.

Agitate well between each product added for optimum results. If BCH10 is used in color step, it should be used in HB055 Onyx Blender Pro II at 5%.

Post Application



Drying:

20°C/68°F 15 minutes under ventilation

Notes



<u>Safety</u>





Special/AUX

HR5 Jet Accelerator

Product Details



R-M HR5 Jet5 is a high strength accelerator that significantly speeds drying and curing when added to R-M Clears. (Not for use in DC100, DC5120, DC5335, DC5600, DC5775 and DC5800.) Add up to 2 ounces of HR5 Jet5 to a ready for use gallon of DC92 Low VOC Clearcoat. Mixtures must be used within 1 hour. Do not use in Diamont or ONYX HD Basecoat Color or any R-M Undercoat.

<u>notes</u>		
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Safety







Special/AUX

Jet95 Accelerator

Product Details



R-M Jet95 is a specially developed accelerator – effective curing rates with less impact on pot life. Add up to 2 ounces of Jet95 in a ready for use gallon of R-M Clears. (Not for use in DC100, DC5120, DC5600, DC5775 and DC5800.) Do not use in Diamont or ONYX HD Basecoat Color or R-M Undercoats.

<u>Notes</u>	<u> </u>	

Safety













Special/AUX

PA20NB Low VOC Productive Primer Activator

Product Details



PA20NB Low VOC Productive Primer Activator was designed to speed the drying time of most of R-M's primers without the need for baking or IR light. The end result is a primer that can be sanded after 15 minutes with no energy cost.

PA20NB Low VOC Productive Primer Activator can be used with DP25, DP26, DP200 and DP226 primers making it perfect for a small damage repair to a 2-panel application for all areas in North America.

For small quantities (1 oz to 8 oz) it is always recommended to mix PA20NB with one of the primers mentioned above by weight on a scale.

<u>Notes</u>	
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Safety













Special/AUX

SB01 Low VOC Mixing Clear

Low VOC Underhood Solution Using ONYX HD Basecoat National Rule

Product Details



SB01 Onyx Underhood Converter is designed to give a durable finish to underhood applications while utilizing the the Onyx bases and color mixes. SB01 makes your underhood applications durable and fast drying with good coverage and better hiding.

Reducers

UR30 Universal Spot and Panel Reducer

UR40 Universal Low Temp Reducer

UR50 Universal Mid Temp Reducer

Products:

Hardeners

DH42 Rapid Hardener DH44 Medium Hardener DH46 Normal Hardener

ONYX HD Waterborne Basecoat

Basecoats

Mixing



RFU Mixture

Above Mixture 3 parts DH42, DH44 or DH46 10% **UR** Reducer 1 part

Be advised the hardener is the 10% portion of this formula.

The 10% is calculated on the paint portion.

Pot Life of Mixed Product:

3 hours

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3 mm (HVLP Gravity) 1.3 mm

Tech Data:

Viscosity: 13-15 sec. #4 Ford cup Coverage: 244 sq ft/qal @ 1.0 mil

VOC as Applied: 600 gms/ltr (5.0 lbs/gal)



Special/AUX

SB01 Low VOC Mixing Clear

Low VOC Underhood Solution Using ONYX HD Basecoat National Rule

Post Application



Drying:

20°C/68°F 20 minutes to 1 hour, depending on the number of coats

60°C/140°F 15 minutes

Product Tips:

Agitate well by machine. Hand shaking is not enough.

<u>Notes</u>		



Special/AUX

SB01 Low VOC Mixing Clear

Low VOC Underhood Solution Using ONYX HD Basecoat Low VOC Areas

Product Details



SB01 Onyx Underhood Converter is designed to give a durable finish to underhood applications while utilizing the the Onyx bases and color mixes. SB01 makes your underhood applications durable and fast drying with good coverage and better hiding.

Products:

Hardeners

DH99 Low VOC Fast Hardener
DH100 Low VOC Normal Hardener

Reducers

VR0 Exempt Slow VR29 Exempt Fast

Basecoats

ONYX HD Waterborne Basecoat

Mixing



Pre-mix

For direction on mixing the color, please see Smart Trak.

RFU Mixture

Above Mixture 3 parts DH99 or DH100 10% VR Reducer 1 part

Be advised the hardener is the 10% portion of this formula. The 10% is calculated on the paint portion.

Pot Life of Mixed Product:

Pot Life 3 hours

Product Tips:

Agitate well by machine. Hand shaking is not enough.

Notes

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Special/AUX

SB01 Low VOC Mixing Clear

Low VOC Underhood Solution Using ONYX HD Basecoat Low VOC Areas

Application



Apply 2 to 3 medium wet coats allowing 5 to 10 minutes flash between coats

Spray Pressure:

(HVLP/HE) 10 psi at air cap

Fluid Tip:

(HE Gravity) 1.3 mm (HVLP Gravity) 1.3 mm **Tech Data:**

Viscosity: 13-15 sec. #4 Ford cup Coverage: 242 sq ft/gal @ 1.0 mil

VOC as Applied: 340 gms/ltr (2.8 lbs/gal)

Post Application



Drying:

20°C/68°F 20 minutes to 1 hour, depending on the number of coats

60°C/140°F 15 minutes

Notes



Safety





Special/AUX

SM10 Low VOC Matte Additive

Universal Matting Agent

Product Details



SM10 Low VOC Matte Additive is a matting agent which allows one to reduce the gloss level of R-M clears. SM10 is easy to use, allows different degrees of gloss (from total matte to semi-gloss) and is pourable. This is a Low VOC additive and will not increase the VOC of 250 gms/ltr RFU material.

Products:

Clearcoats

DC21NB Low VOC Energy Saving Speed Clear DC98 2.0 VOC Clearcoat DC5800 2.0 CTR Clear DC5900 Low VOC Pre-Flexed Clear

Mixing



Mixing Ratio To matte, add SM10 by volume as follows:

Low Gloss R-M Clearcoat Satin Gloss

Step 1:

70 parts R-M clear 30 parts SM10

Step 2:

Mix the SM10/clear mixture as indicated on the clearcoat's technical data sheet

Matte Gloss

Step 1:

50 parts R-M clear 50 parts SM10

Step 2:

Mix the SM10/clear mixture as indicated on the clearcoat's technical data sheet

Application



SM10 may be added up to a 100% to RFU Material. Additional reduction is optional. Apply 2 to 3 coats (usually requires 1 more coat than the full gloss material) allowing 5 to 10 minutes flash between coats. Bake immediately after last coat if force drying.

Product Tips:

Stir product well before using.

When using SM10 in R-M clearcoats, use the appropriate hardener as indicated on the product's technical data sheet. Gloss level is dependent on spray technique. Spray lighter/drier coats to maintain low gloss levels. The addition of SM10 slightly reduces the pot life of the clearcoat.









Special/AUX

SM10 Low VOC Matte Additive

rsai Matting Agent		

Safety











Safety and Health Precautions

Protecting Yourself

Safety



Paint products are generally mixtures of a number of components that can be hazardous to health and safety. Paint products are typically composed of resins, pigments, solvents, additives and in some case isocyanates. In order to use these materials safely, a number of precautions should be followed.

- Flammable paint products should always be kept away from heat, sparks and other ignition sources due to the flammability of the solvents that are used as carriers.
- · Labels should be on all containers during use and storage.
- Paint products should be used by trained professionals only.
- First aid equipment and fire extinguishers should be available and in proper working order.
- Proper ventilation is required when working with any solvent based products including paints, reducers, hardeners, body putties, etc.
- Proper respiratory and other PPE (Personal Protective Equipment) should be used when mixing, spraying, applying or sanding.
- Review all labels, technical sheets and MSDS's for recommendations on product use.
- · Keep containers closed when not in use.
- Store properly.

Solvents, some pigments and other additives have health effects associated with them. OSHA has established PELs (Permissible Exposure Limits) for many of these and there may be TWAs (time weighted averages), STELs (short term exposure limits), TWA-C (TWA-Ceiling) or a skin designation. These levels are enforceable by OSHA inspectors. Some solvents or other components in a paint product can cause acute (immediate) or chronic (long term) effects. See the MSDS for specific information on these effects. Selected components may have been shown to cause such effects as damage to the liver or kidneys after overexposure. Acute effects may include dizziness, blurred vision, disorientation and in some severe cases unconsciousness. It is, therefore, very important to use the materials with the proper PPE including respiratory protection. Isocyanates have special hazards. See MSDS and labels for further information.

Protecting Yourself - PPE

Always wear gloves when skin exposure is possible. Organic solvents can be absorbed through the skin as well as inhaled. Never wash hands in solvent, use soap and water or a hand cleaner designed to remove paint. Solvents can also cause drying of the skin, dermatitis or other irritations to the skin.

Wear safety glasses or goggles to protect your eyes from splashes and vapors. Getting solvent in the eyes is very painful and may cause damage. If a solvent does get in the eyes, flush with large quantities of water and seek medical attention.

Safety

Safety and Health Precautions

Protecting Yourself (cont.)

Safety



Protecting Yourself - Respiratory Protection

When using a material containing solvent, it is necessary to use the proper respiratory protection. The respirator must be properly fitted if it has a face to seal contact. A vapor particulate respirator will protect you from vapors, mist and dust. An organic vapor cartridge (TC-23C) should be used. All respirators should be NIOSH (National Institute for Occupational Safety and Health) and MSHA (Mine Safety and Health Administration) approved. If you have facial hair or other conditions that prevent a proper seal of the mask, you should use a fresh air system such as a hood that has a positive pressure (TC19C NIOSH/MSHA).

For cartridge respirators using negative pressure, the cartridges should be replaced frequently. Cartridges should be replaced immediately if you can smell solvent or it becomes difficult to breathe when wearing. When not in use, respirators should be cleaned and stored in sealed plastic bags away from sunlight, heat or moisture. See the manufacturer's recommendations for proper cleaning and storage.

Fresh air systems are the only ones approved by NIOSH/MSHA for use with products containing or mixed with products containing isocyanates. A dust respirator should be used when sanding before or after applications of primers or body fillers. A vapor cartridge filter should also be used when applying body fillers which contain styrene or organic peroxides. Note that while it is important to use the proper respiratory protection and other PPE when applying the products, it is also important to use it while mixing or otherwise handling the products. See the MSDS and labels for more information.

Safety



trainingmanual

Perfection made simple



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