

R-M Carizzma® Waterborne

Carizzmatics



Products	Carizzma	
	851 Prep and Wash	HB020 Hydromix
	900 Pre-Kleano	HB040 Hydromix Slow
	909 Final Wipe	ONYX HD Toners
	AM900 Aero-Max Pre-Kleano	BCH10 Basecoat Hardener
	All R-M Clears	
Description	ONYX HD is known for perfect matches to OEM colors, but not everyone realizes that many dazzling and exciting non-OEM colors can be created directly from ONYX HD tinting base system. The high quality pigments and other materials used in ONYX HD create some of the cleanest and brightest colors imaginable.	
Cleaning	See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.	
Pretreatments	See Undercoat Section	
Mixing Ratio Multi-color finishes / masking tape	<p>If you have to apply multi-color finishes or a lot of masking tape to carry out different design paint jobs, it is recommended to add <i>BCH10 Basecoat Hardener</i> to the undercoat or basecoat in order to optimise its surface hardness and tape resistance.</p> <p>100 parts by volume ONYX HD solid color 5 parts by volume BCH10 60 - 80 parts by volume HB020 or HB040</p> <ul style="list-style-type: none"> • Add BCH10 and stir again carefully. • Add HB020 or HB040 and stir carefully. • Strain before application. <p>Potlife 1 hour (maximum) at 20°C/68°F</p> <p>Flash off Flash off until matte after each spraycoat.</p> <p>Drying 20 minutes at 60°C/140°F (before masking)</p>	
Mixing Ratio Precoat and Basecoat	<p>Precoat</p> <p>100 parts by volume ONYX HD Carizzma Precoat</p> <p>60 parts by volume HB020 or HB040</p> <ul style="list-style-type: none"> • Mix the ONYX HD Precoat to the formula • Mix intensively immediately after weighing • Add HB020 or HB040 • Mix intensively immediately after weighing • Strain before application. 	<p>Basecoat</p> <p>100 parts by volume ONYX HD Carizzma metallic or pearl effect color</p> <p>60 parts by volume HB020 or HB040</p> <ul style="list-style-type: none"> • Mix the ONYX HD Basecoat to the formula • Mix intensively immediately after weighing • Add HB020 or HB040 • Mix intensively immediately after weighing • Strain before application. (Do not insert a filter less than 200 microns in the spraygun when applying a metallic or pearl effect basecoat.)
Application	<p>Precoat: 2 to 3 coats</p> <p>Basecoat: 1 to 2 coats plus effect coat</p> <p>Flash off until matte after each spraycoat</p>	
Drying	20°C/68°F 15 minutes under ventilation	



Technical Data

Viscosity	40-65 seconds Ford 4 at 22°C/70°F
Fluid Tip (HVLP Gravity)	1.4-1.5 mm
Air Pressure (HVLP)	10 psi at air cap (maximum)
Number of Coats	Precoat: 2 to 3 coats Basecoat: 1 to 2 coats plus effect coat
Thickness	Precoat: 0.8-1.0 mil Basecoat: 0.4-0.5 mil
Pot Life	1 week in a sealed plastic vessel
VOC as Applied	420 gms/ltr (3.5 lbs/gal)

Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Do allow 30 minutes at 20°C/68°F before using masking tape.

Things NOT to DO:

- Do not use fisheye eliminator in Carizzma Carizzmatics.
- Do not apply directly over any acrylic lacquer or lacquer finishes.
- Do not use flex agents in Carizzma Carizzmatics.
- Do not use if the shop temperature is below 10°C/60°F.
- Do not sand Carizzma Carizzmatics.