

# R-M Carizzma® Waterborne Crystal



<b>Products</b>	<p>Carizzma</p> <p>851 Prep and Wash</p> <p>900 Pre-Kleano</p> <p>909 Final Wipe</p> <p>AM900 Aero-Max Pre-Kleano</p> <p>All R-M Clears</p>	<p>HB020 Hydromix</p> <p>HB040 Hydromix Slow</p> <p>ONYX HD Toners</p> <p>BCH10 Basecoat Hardener</p>
<b>Description</b>	<p>A few Crystal Bases and Onyx HD bases contain a unique pigment that, although small in size, exhibits a brilliant sparkle. Carizzma Crystal incorporates these pigments to create a dazzling palette of colors that look their best in direct sunlight. To identify those special pigment bases, the color description starts with "CRYSTAL".</p> <p>There are several Carizzma Crystal color formulas available but the number of possible colors by combining the different Onyx HD and Crystal bases is limited only to somebody's imagination.</p>	
<b>Cleaning</b>	See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.	
<b>Pretreatments</b>	See Undercoat Section	
<b>Mixing Ratio</b> 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 optimize its surface hardness and tape resistance.</p> <p>100 parts by volume ONYX HD solid color</p> <p>5 parts by volume BCH10</p> <p>60 - 80 parts by volume HB020 or HB040</p> <ul style="list-style-type: none"> <li>• Add BCH10 and stir again carefully.</li> <li>• Add HB020 or HB040 and stir carefully.</li> <li>• Strain before application.</li> </ul> <p><b>Potlife</b> 1 hour (maximum) at 20°C/68°F</p> <p><b>Flash off</b> Flash off until matte after each spraycoat.</p> <p><b>Drying</b> 20 minutes at 60°C/140°F (before masking)</p>	
<b>Mixing Ratio</b> Precoat and Basecoat	<p><b>Precoat</b></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"> <li>• Mix the ONYX HD Precoat to the formula</li> <li>• Mix intensively immediately after weighing</li> <li>• Add HB020 or HB040</li> <li>• Mix intensively immediately after weighing</li> <li>• Strain before application.</li> </ul>	<p><b>Basecoat</b></p> <p>100 parts by volume ONYX HD Carizzma Crystal color</p> <p>60 parts by volume HB020 or HB040</p> <ul style="list-style-type: none"> <li>• Mix the ONYX HD Basecoat to the formula</li> <li>• Mix intensively immediately after weighing</li> <li>• Add HB020 or HB040</li> <li>• Mix intensively immediately after weighing</li> <li>• Strain before application. (Do not insert a filter less than 200 microns in the spraygun when applying a metallic or pearl effect basecoat.)</li> </ul>
<b>Application</b>	<p><b>Precoat:</b> 2 to 3 coats</p> <p><b>Basecoat:</b> 1 to 2 coats plus effect coat</p> <p>Flash off until matte after each spraycoat</p>	
<b>Drying</b>	<b>20°C/68°F</b> 15 minutes under ventilation	



# R-M Carizzma<sup>®</sup> Waterborne Crystal



<b>Mixing Ratio</b> Basecoat only	100 parts by volume ONYX HD Carizzma Crystal color 60 parts by volume HB020 or HB040 <ul style="list-style-type: none"><li>• Mix the ONYX HD Precoat to the formula</li><li>• Mix intensively immediately after weighing</li><li>• Add HB020 or HB040</li><li>• Mix intensively immediately after weighing</li><li>• Strain before application. (Do not insert a filter less than 200 microns in the spraygun when applying a metallic or pearl effect basecoat.)</li></ul>
<b>Application</b>	1 to 2 coats plus effect coat Flash off until matte after each spraycoat
<b>Drying</b>	<b>20°C/68°F</b> 15 minutes under ventilation

## Technical Data - Precoat and Basecoat

<b>Viscosity</b>	40-65 seconds Ford 4 at 22°C/70°F
<b>Fluid Tip (HVLP Gravity)</b>	1.4-1.5 mm
<b>Air Pressure (HVLP)</b>	10 psi at air cap (maximum)
<b>Number of Coats</b>	<b>Precoat:</b> 2 to 3 coats <b>Basecoat:</b> 1 to 2 coats plus effect coat
<b>Thickness</b>	<b>Precoat:</b> 0.8-1.0 mil <b>Basecoat:</b> 0.5-0.6 mil
<b>Pot Life</b>	1 week in a sealed plastic vessel
<b>VOC as Applied</b>	420 gms/ltr (3.5 lbs/gal)

## Technical Data - Basecoat only

<b>Viscosity</b>	40-65 seconds Ford 4 at 22°C/70°F
<b>Fluid Tip (HVLP Gravity)</b>	1.4-1.5 mm
<b>Air Pressure (HVLP)</b>	10 psi at air cap (maximum)
<b>Number of Coats</b>	1 to 2 coats plus effect coat
<b>Thickness</b>	0.5-0.6 mil
<b>Pot Life</b>	1 week in a sealed plastic vessel
<b>VOC as Applied</b>	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 Crystal.
- Do not apply directly over any acrylic lacquer or lacquer finishes.
- Do not use flex agents in Carizzma Crystal.
- Do not use if the shop temperature is below 10°C/60°F.
- Do not sand Carizzma Crystal.