

R-M Carizzma® Waterborne Special Effect Powder



Products

Carizzma
 851 Prep and Wash
 900 Pre-Kleano
 909 Final Wipe
 AM900 Aero-Max Pre-Kleano
 All R-M Clears
 PF Special Effect Powder

HB020 Hydromix
 HB040 Hydromix Slow
 HB100 Mixing Clear
 ONYX HD Toners
 BCH10 Basecoat Hardener

Description

Carizzma PF Special Effect Powder used with ONYX HD waterborne basecoat creates special effect finishes that change their color depending on lighting and angle of view. The Carizzma Special Effect Powder can be used in ONYX HD colors and also with HB100 then sprayed over ONYX HD colors. By applying Carizzma Special Effect Powder in HB100 over ONYX HD colors, the color will be completely different. The color change can be intensified by increasing the amount of Carizzma Special Effect Powder used and the film thickness applied.

The color of the basecoat strongly influences the final color and its special effect.

The Carizzma Special Effect Powders are available in the following colors: PF18 Arctic Ice, PF38 Extreme Violet, PF54 Opal Marine, PF68 Sunfire Gold, PF65 Golden Emerald, PF85 Extreme Bronze.

Cleaning

See Topcoat Section - "Cleaning & Preparing Vehicle for Topcoating" for vehicle prep.

Pretreatments

See Undercoat Section

Mixing Ratio

Multi-color finishes / masking tape

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 *BCH10 Basecoat Hardener* to the undercoat or basecoat in order to optimize its surface hardness and tape resistance.

100 parts by volume ONYX HD solid color
 5 parts by volume BCH10
 60 - 80 parts by volume HB020 or HB040

- Add BCH10 and stir again carefully.
- Add HB020 or HB040 and stir carefully.
- Strain before application.

Potlife 1 hour (maximum) at 20°C/68°F
Flash off Flash off until matte after each spraycoat.

Drying 20 minutes at 60°C/140°F (before masking)

Mixing Ratio

Precoat and Basecoat with Special Effect Powder

Precoat

100 parts by volume ONYX HD Carizzma Precoat
 60 parts by volume HB020 or HB040

- 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.

Basecoat with Special Effect Powder

ONYX HD
 Special Effect Powder

- Mix to the formulas, then mix intensively

Then mix:

100 parts by volume ONYX HD / Special Effect Powder
 60 parts by volume HB040

- Mix intensively immediately after weighing
- Filter it after mixing. (Do not insert a filter less than 200 microns in the spraygun when applying Carizzma Special Effect Powder.)

Application

Precoat: 2 to 3 coats

Basecoat with Special Effect Powder: 1 to 2 wet coats (Don't spray an effect coat after flash off)

Flash off until matte after each spraycoat

Drying

20°C/68°F 15 minutes under ventilation



R-M Carizzma[®] Waterborne Special Effect Powder



Mixing Ratio Precoat and Basecoat with Special Effect Powder / HB100

Precoat

100 parts by volume ONYX HD solid or
metallic color
60 parts by volume HB020 or HB040

- 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.

Basecoat with Special Effect Powder

100 grams ONYX HD
1 to 5 grams Special Effect Powder
3 to 15 grams HB100
(add HB100 3:1 with the Special Effect Powder)

- Mix to the formulas, then mix intensively

Then mix:

100 parts by volume ONYX HD/Effect Powder/
HB100
60 parts by volume HB040

- Mix intensively immediately after weighing
- Filter it after mixing. (Do not insert a filter less than 200 microns in the spraygun when applying Carizzma Special Effect Powder.)

Application

Precoat: 2 to 3 coats (Solid color); 1 to 2 coats plus effect coat (Metallic color)

Basecoat with Special Effect Powder: 1 to 2 wet coats (Don't spray an effect coat after flash off)

Flash off until matte after each spraycoat

Drying

20°C/68°F 15 minutes under ventilation

Mixing Ratio Precoat and Special Effect Powder with HB100

Precoat

100 parts by volume ONYX HD solid or
metallic color
60 parts by volume HB020 or HB040

- 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.

Basecoat with Special Effect Powder

100 grams HB100
0.3 to 5 grams Special Effect Powder

- Mix intensively

Then mix:

100 parts by volume Special Effect Powder/
HB100
60 parts by volume HB040

- Mix intensively immediately after weighing
- Filter it after mixing. (Do not insert a filter less than 200 microns in the spraygun when applying Carizzma Special Effect Powder.)

Application

Precoat: 2 to 3 coats (Solid color); 1 to 2 coats plus effect coat (Metallic color)

Basecoat with Special Effect Powder: 1 to 2 wet coats (Don't spray a effect coat after flash off)

Flash off until matte after each spraycoat

Drying

20°C/68°F 15 minutes under ventilation

R-M Carizzma[®] Waterborne Special Effect Powder Technical Data



Technical Data - Precoat and Basecoat with Special Effect Powder

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: 0.5-0.6 mil
Pot Life	1 week in a sealed plastic vessel
VOC as Applied	420 gms/ltr (3.5 lbs/gal)

Technical Data - Precoat and Basecoat with Special Effect Powder / HB100

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: Solid - 2 to 3 coats Metallic - 1 to 2 coats + effect coat Basecoat: 1 to 2 wet coats
Thickness	Precoat: Solid - 0.8-1.0 mil Metallic - 0.5-0.6 mil Basecoat: 0.6-1.0 mil
Pot Life	1 week in a sealed plastic vessel
VOC as Applied	420 gms/ltr (3.5 lbs/gal)

Technical Data - Precoat and Special Effect Powder with HB100

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: Solid - 2 to 3 coats Metallic - 1 to 2 coats + effect coat Basecoat: 1 to 2 wet coats
Thickness	Precoat: Solid - 0.8-1.0 mil Metallic - 0.5-0.6 mil Basecoat: 0.6-1.0 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 Special Effect Powder.
- Do not apply directly over any acrylic lacquer or lacquer finishes.
- Do not use flex agents in Carizzma Special Effect Powder.
- Do not use if the shop temperature is below 10°C/60°F.
- Do not sand Carizzma Special Effect Powder.



