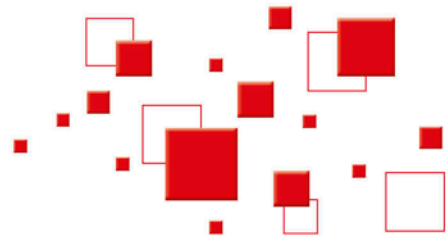


Process Information

Paint system Oldtimer



Process description

High-quality refinishing process suitable for long-lasting restorations of classic cars in professional body shops, using the R-M base- clear coat systems.

Substrates

- Steel
- Galvanised steel
- Aluminium
- Tin-plated areas
- Automotive OEM finishes

Products required

- PK 700 or PK 1000, PK 900 and PK 2000
- STARFILL
- AKROFILL
- STOP UNI
- STOP FILLER II
- PERFECTFILLER GREY
- UNO HD CP
- STARLUX CP


Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

Pre-treatment

	Soak a cloth with SC 850 and wipe over a sand-through.
	Finish swells, becomes sticky, softens? yes = solvent sensitive no = solvent resistant

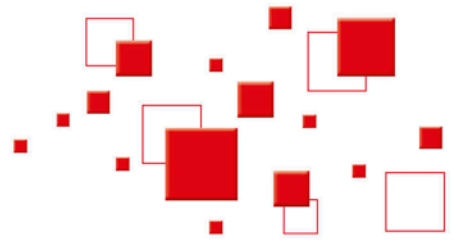
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R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 02/2013






Process Information




Paint system Oldtimer






Solvent-sensitive old paintwork

	If PK 700 causes swelling, use only P2000
	<ul style="list-style-type: none"> • Use fine grit sizes. • General rule: use sanding paper which is 1 or 2 grit sizes finer than the paper recommended in the standard process. • Sand transition areas adjacent to old paintwork with particular care and intensity
	Apply putty only to bare metal areas, avoiding overlaps with the old paintwork.
	<ul style="list-style-type: none"> • Please avoid the usage of aggressive primers. • Apply thin spray coats with long intermediate flash-off intervals. Respect the recommended total film thickness of 50 – 70 µm). • Filler must always be applied to the entire panel. Do not apply it to small spots. • Force-dry the filler coat in order to remove solvents rapidly. In this case IR drying is the most convenient drying method because the finish is warmed starting from the substrate up to its surface. This is the quickest method to get the solvents away from the delicate surface. • Exception: TPA finishes. These finishes must not be IR dried because they are thermoplastic and therefore deform when exposed to warmth.

Solvent-resistant old paintwork

	Degreasing PK 700 or PK 1000	
	Sanding	Remove all rust from damaged areas. P 80 – P 150 or blasting
	Degreasing PK 700 or PK 1000	

Tin-plated areas

	Degreasing PK 900	Attention: Treat tin-plated surfaces with special care.
	Sanding	Remove all rust from damaged areas. P 80 – P 150 or blasting
	Degreasing PK 700 or PK 1000	



Process Information

Paint system Oldtimer

Primer

Must be applied to achieve long-lasting corrosion protection on bare metal areas and on vehicles that will stand in the shop for a longer time before being refinished.

	STARILL D 30 Activator FR 500	100% by vol. 100% by vol. 30% by vol.
	Spray coats: Film Thickness:	1 5 – 10 µm
	Flash-off time 20°C:	60 min.
	(short wave)	11 min. 100%

	AKROFILL D 501 FR 500	100% by vol. 25% by vol. 25% by vol.
	Spray coats: Film thickness:	1 20 – 25 µm
	Drying 60°C:	20 min.
	(short wave)	11 min. 100%





Putty

	STOP UNI STOP Hardener	100 g 3 g
	Coats:	2 – 3
	20°C 60°C	20 min. 10 min.
	(short wave) (medium wave)	4 min. at 50% 6 min.
	Dry: use P80, P150, P240, then clean with PK 1000	






Process Information

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Spray putty / for use as a fine putty instead of a knifing putty.

	STOP FILLER II STOP FILLER hardener	100% by vol. 5% by vol.
	Coats: Film Thickness:	3 – 5 150 – 300 µm
	20°C 60°C	3 – 4 hours 30 min.
	(short wave) (medium wave)	10 min. at 50% 15 – 20 min.






Filler

	PERFECTFILLER GREY D 70 / D 80 FR 500 You may use PROFILLER WHITE / GREY & BLACK or PERFECTFILLER WHITE / BLACK instead of PERFECTFILLER GREY	100% by vol. 25% by vol. 25% by vol.
	Spray coats: Film Thickness:	3 80 – 120 µm
	20°C: 60°C	3 hours 20 min.
	(short wave)	9 min.
	Dry: use P400 and P500, then clean with PK 2000	

Process Information

Paint system Oldtimer




Visual Check / to ensure good finish quality we recommend the application of a two-component topcoat.

	UNO HD CP colour with SC 07 and SC 17 H 420 SC 850	100% by vol. 25% by vol. 25% by vol.
	Spray coats: Film Thickness:	1 thin + 1 full 60 µm
	60°C	30 min.
	(short wave)	3 min. at 50% + 10 min. at 100%
	Check the surface quality, e.g. under neon light.	
	Dry: use P400, then clean with PK 2000	

Topcoat

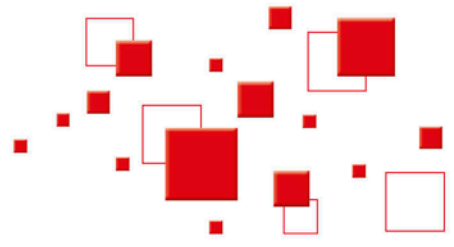
	ONYX HD, UNO HD CP Apply in accordance with the Technical Data Sheet
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Clear

	Stir well before use STARLUX CP H 420 SC 820	300% by vol. 100% by vol. 100% by vol.
	Spray coats: Film thickness:	1 thin + 1 wet 40 – 60 µm
	60°C	30 min.




Process Information

Paint system Oldtimer



High-end finishing: We recommend the application of an additional layer of clear on top of UNO HD CP topcoats and on top of our clear-over-base systems.

	Degreasing PK 2000
	P500 / P1000 / P2000
	Degreasing PK 2000

	Stir well before use	
	STARLUX CP	300% by vol.
	H 420	100% by vol.
	SC 820	100% by vol.
	Spray coats: Film thickness:	1 thin + 1 wet 40 – 60 µm
	60°C	30 min.