

PRODUCT DATA SHEET

GRAPHITE HD CHASSISMIX

PF

Application

construction machinery (steel), chassis painting (steel / aluminum), chassis (color change), container, steel and galvanized steel spare parts



Substrates:

- = very well suited
- = well suited
- = suited in some cases

Steel	●●
Galv. Steel	●●
Stainless steel	●
Aluminium	
Anodized Aluminium	
GRP / SMC	●
PP-EPDM	
RM CV-Primer	●
RM CV-Primer-Filler / Filler	
Powder	●
Coil-Coating	●
Plywood	
Wood	
OEM Paint work	●
Old paint work	●

Description:

- suitable for large areas / surfaces
- can be applied directly on steel or galvanized steel
- tintable
- good coverage of shot blasted profile
- brilliant top coat appearance
- improves the hiding power

Remarks:

Aluminum-Chassis have be primed with a suitable primer
The substrate should be clean, free of dust, rust, oil and grease

Special remarks

- The products are suitable for professional use only.
- It cannot be ruled out that this product contains particles < 0.1 µm
- **2004/42/IIB (c II)(540)530:** The EU limit value for this product (product category: IIB(d) in ready to use form is max.. 540 g/l. **The VOC content of this product is 530 g/l.**



Paint process

P 1.1

Spreading rate

≈ ~540 m² / l / 1µm

Solid content

≈ 80 %

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Perfection made simple



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Pre-mix

mix GHD CHASSISMIX (70 parts) with line GHD TOPCOAT (30 Parts)



Mixing ratio

100:15 :15-25 by volume



Hardener

H 770 / H 750 or H 700



Reducer

GV200 CV, normal 15 - 20°C
GV300, slow 20 - 25°C
 GV400, very slow 25 - 30°C



Spray viscosity DIN 4 / 20°C

25-35 s. DIN 4

Potlife 20 °C

2 h

Application



Compliant-gravity feed cup



HVLP-Spray gun



Suction cup



Airless/Airmix (ESTA)



Pressure pot/Dble membr. Pump

	bar	2,2 - 2,5	2	2,5	2	2,5
Atomization pressure	bar	--	-	-	120 - 150	0,8 - 1,5
Material pressure	mm	1,6 - 1,8	1,7 - 1,9	1,7 - 1,9	0,28 - 0,33	1,0 - 1,1
Nozzle size	kV	-	-	-	50 - 80	-
Voltage	Ω	-	-	-	700 - 1500	-
Elect. Resistance		2	2	2	1 - 2	2
Number of spraycoats	min.	10-15	10-15	10-15	10-15	10-15
Flash off	µm	40-60				
Filmbuild						



Drying



over-coatable



tack free



tapeable



ready to assemble



sandable

	20°C	Min.	Max.	16 h
Panel temperat.	60 min	72 h		
Panel temperat.	30 min			30 min

Remarks



Attention! The shelf life of the mixed product (Line GHD TOPCOAT and GHD CHASSISMIX) is only 2 weeks. The corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges)
 The adhesion on hot dipped galvanized steel has to be checked before.

