

PRODUCT DATA SHEET

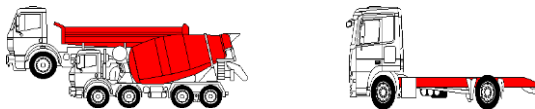
GRAPHITE HD CHASSIS SURFACER

beige-grey

PF

Application

chassis painting (steel / aluminum), container, construction machinery (steel), 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 on all RM CV primer
- suitable for large areas / surfaces
- chromate free with good corrosion protection
- good coverage of shot blasted profile
- brilliant top coat appearance
- outstanding application characteristics
- tintable

Remarks:

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

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 I)(540)520:** 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 520 g/l.**



Paint process

P 1, RAPID 1

Spreading rate

≈ 404 m² / l / 1µm

Solid content

≈ 68 %

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at www.rmpaint.com or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

R-M Automotive Refinish Paints, BASF Coatings S.A.S, F-60676 Clermont-de-l'Oise Cedex

Jan 2014

Perfection made simple












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	Mixing ratio	100:20:20 by volume		
	Hardener	H360 or H310		
	Reducer	GV300, slow GV400, very slow	15 - 20°C 20 - 25°C 25 - 30°C	
	Spray viscosity DIN 4 / 20°C	25 s. DIN 4	Potlife 20 °C	4 h

Application		 Compliant-garvity feed cup	 HVLP-Spray gun	 Suction cup	 Airless/Airmix (ESTA)	 Pressure pot/ Dble membr. Pump
Atomization pressure	bar	2,2 - 2,5	2,0	2,5	2	2,5
Material pressure	bar	--	-	-	120 - 150	0,8 - 1,5
Nozzle size	mm	1,3 - 1,8	1,5 - 1,7	1,5 - 1,7	0,28 - 0,33	1,0 - 1,1
Voltage	kV				50 - 80	
Elect. Resistance	Ω				300 - 500	
Number of spraycoats		2	2	2	1 - 2	2
Flash off	min.	without	without	without	without	without
Filmbuild	µm	60 - 70				

Drying		 over-coatable		 tack free	 tapeable	 ready to assamble	 sandable
		Min.	Max.				
Panel temperat.	20°C	60 min	72* h	2 h	16 h	16 h	16 h
Panel temperat.	60°C	30 min		30 min	30 min	30 min	45 min

Remarks



Can be tinted with up to 10% of GHD TOPCOAT Line Topcoat for the 2nd spraycoat.
To plasticize the product, mix it 100:25 by volume (using the mixing stick) with ADDITIVE SF before adding hardener.
Can be overcoated with CV topcoats of Lines GHD TOPCOAT, ONYX.
For tinting see CV Primer Tinting Paste GHD PRIMER TINTING PASTE !
The adhesion on hot dipped galvanized steel has to be checked before.
* Line DIAMOND/ONYX has to be applied within 1 working day

