

PRODUCT DATA SHEET

GRAPHITE HD EPOXY

grey-green

PF

Application

busses, fire-fighting vehicle, boxes, bulk loading vehicles, boxes (aluminum)



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 substrates
- good leveling
- good filling properties
- all-purpose
- outstanding corrosion protection

Remarks:

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 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, 1.1, 1.2, 3.1, 4, RAPID 1

Spreading rate

≈ 424 m² / l / 1µm

Solid content

≈ 73 %

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.mpaint.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












PRODUCT DATA SHEET

GRAPHITE HD EPOXY

grey-green

PF

	Mixing ratio	100:25:25 by volume		
	Hardener	GHD EPOXY HARDENER		
	Reducer	GV300, slow GV300, slow GV300, slow	15 - 20°C 20 - 25°C 25 - 30°C	
	Spray viscosity DIN 4 / 20°C	18 - 20 s. DIN 4	Potlife 20 °C	8 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	2,5	2	2,5
Material pressure	bar	-			120 - 150	0,8 - 1,5
Nozzle size	mm	1,6 - 1,8	1,5	1,7	0,28 - 0,33	1,0 - 1,1
Voltage	kV				50 - 80	
Elect. Resistance	Ω				600 - 900	
Number of spraycoats		2	2	2	1,5 - 2	1,5 - 2
Flash off	min.	10-15	10-15	10-15	10-15	10-15
Filmbuild	µm	40 - 60				

Drying		 over-coatable	 tack free	 tapeable	 ready to assamble	 sandable
		Min.	Max.			
Panel temperat.	20°C	60 min	72 h	3 h	16 h	16 h
Panel temperat.	60°C	30 min		30 min	30 min	30 min

Remarks



Minimum ambient temperature during application and drying: +12°C
 For tinting see CV Primer Tinting Paste GHD PRIMER TINTING PASTE !
 Before applying polyester products GHD EPOXI has to be dried for at least 45 min 60°C.
 The adhesion on hot dipped galvanized steel has to be checked before.
 If GHD EPOXY is used as a primer (3-layer system) a filmbuild of 25-30µm is required.
 Do not use reducer GV 200

