

TECHNICAL INFORMATION

GRAPHITE HD CHASSIS SURFACER

beige-grey

Range of application :

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



Performance:

- 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

Substrates:

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

Steel	●●
Galvanized steel	●
Stainless steel	
Aluminium	
Anodized Aluminium	
GRP / SMC	●●
PP-EPDM	
RM CV-Primer	●●
RM CV-Primer-Filler / Filler	
Powder coating	●
Coil-Coating	○
Plywood	●●
Wood	●●
OEM-PAint work	●
old paint work	●●

Remarks:

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

Special remarks

- It cannot be ruled out that this product contains particles < 0.1 µm
- The e products are suitable for professional use only.
- **2004/42/IIB (c I)(540)520**: The EU limit value for this product (product category: IIB.c I) in ready to use form is max.540 g/l. The VOC content of this product is **520 g/l**.



Painting process

P 1, RAPID 1

Spreading rate

≈ 404 m² / l / 1µm

Solid content

≈ 68 %

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PF



Pre mix

100:25 (100 parts paint and 25part ADDITIVE SF) use mixing stick.
For other mixtures see corresponding TDS.



Mixing ratio

100:25:25 by volume



Hardeners

H360 / H310



Reducer

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



Viscosity DIN 4 / 20° C

25 s. DIN 4

Potlife 20 °C

2 h

Application parameter



**Compliant -
gravity feed
cup**



**HVLP - Spray
gun**



Suction cup



**Airless/
Airmix
(ESTA)**



**Pressure pot
Dble.-Memb.
Pump**

Application parameter	bar	2,2 - 2,5	2,0	2,5	2	2,5
Atomization pressure	bar	2,2 - 2,5	2,0	2,5	2	2,5
Paint 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	
Spray coats		2	2	2	1 - 2	2
Flash - off	min.	without	without	without	without	without
Filmbuild	µm	60 - 70				



Drying



**Over-
coatable**



Tack-free



**Ready for
masking**



**Ready to
assemble**



Sandable

Min. Max.

Object temp.	20°C	60 min	72* h	2 h	16 h	16 h	16 h
Object temp.	60°C	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, DIAMOND/ONYX HD.
For tinting see CV Primer Tinting Paste GHD PRIMER TINTING PASTE !
Mixing Ratio 100:20:20 by volume = Higher viscosity e.g. for blasted steel substrats
The adhesion on hot dipped galvanized steel has to be checked before.
* Line DIAMOND/ONYX has to be applied within 1 working day

