

# PRODUCT DATA SHEET

## GRAPHITE HD PRIMER CF

beige

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### Application

busses, dumptruck (aluminum), flatbeds (aluminum), boxes, bulk loading vehicles (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 for large areas / surfaces
- chromate free with good corrosion protection
- fast drying

### 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/IIIB (c III)(780)760:** The EU limit value for this product (product category: IIB(d) in ready to use form is max.. 780 g/l. **The VOC content of this product is 760 g/l.**



### Paint process

P 1, 1.1, 1.2, 2, 4, 5, 6, RAPID 1, 4

### Spreading rate

≈ 101 m<sup>2</sup> / l / 1µm

### Solid content

≈ 43 %

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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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	<b>Mixing ratio</b>	100:50:10 by volume		
	<b>Hardener</b>	<b>GHD ACTIVATOR, slow</b>		
	<b>Reducer</b>	GV300, slow GV300, slow GV400, very slow	15 - 20°C 20 - 25°C 25 - 30°C	
	<b>Spray viscosity DIN 4 / 20°C</b>	16 - 18 s. DIN 4	<b>Potlife 20 °C</b>	8 h

Application		 Compliant-garvity feed cup	 HVLP-Spray gun	 Suction cup	 Airless/Airmix (ESTA)	 Pressure pot/ Dble membr. Pump
<b>Atomization pressure</b>	bar	2,2 - 2,5	2,0	2,5	2	2,5
<b>Material pressure</b>	bar	--	-	-	120 - 150	0,8 - 1,5
<b>Nozzle size</b>	mm	1,6 - 1,8	1,7	1,7	0,28	1,0 - 1,1
<b>Voltage</b>	kV	-	-	-	-	-
<b>Elect. Resistance</b>	Ω	-	-	-	-	-
<b>Number of spraycoats</b>		2	2	2	1 - 2	1,5 - 2
<b>Flash off</b>	min.	10-15	10-15	10-15	10-15	10-15
<b>Filmbuild</b>	µm	15 - 20				

	<b>Drying</b>	 over-coatable	 tack free	 tapeable	 ready to assemble	 sandable
		Min.	Max.			
<b>Panel temperat.</b>	20°C	30 min	8 h			
<b>Panel temperat.</b>	60°C	10 min				

### Remarks



Do not overcoat with polyester products.  
To be used only in 3-stage systems with all CV PUR Primer Filler / Filler.  
Spray filler within 8 hours.  
Do not use GHD PRIMER CF on sandblasted areas  
The adhesion on hot dipped galvanized steel has to be checked before.

