

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

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Perfection made simple



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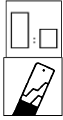
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Pre-mix

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



Mixing ratio

100:15 :15-25 by volume



Hardener

H350 or H300



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



Drying



over-coatable



tack free



tapeable



ready to assemble



sandable

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

