

PRODUCT DATA SHEET

GRAPHITE HD CHASSISMIX

DTM

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Application

chassis painting (steel / aluminum), chassis (color change), container



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:

- tintable
- suitable for large areas / surfaces
- good leveling
- can be applied directly on steel or galvanized steel
- high efficiency
- good corrosion protection

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/IIIB (d)(420)419:** The EU limit value for this product (product category: IIB(d) in ready to use form is max.. 420 g/l. **The VOC content of this product is 419 g/l.**



Paint process

P 1.2

Spreading rate

≈ 503 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

Jan 2014

Perfection made simple



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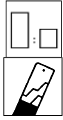
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Pre-mix

mix GHD CHASSISMIX with line GHD TOPCOAT in the ratio 1:1



Mixing ratio

100:15:10-15 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

30-40 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	2	2,5
Atomization pressure	bar	--	-	-	120 - 150	0,8 - 1,5
Material pressure	mm	1,6 - 1,8	1,7 - 1,9	1,7 - 1,9	0,28 - 0,33	1,0 - 1,3
Nozzle size	kV	-	-	-	50 - 80	-
Voltage	Ω	-	-	-	700 - 1500	-
Elect. Resistance		2	2	2	1 - 2	2
Number of spraycoats	min.	10-15	10-15	10-15	10-15	10-15
Flash off	µm	60-150				
Filmbuild						



Drying



over-coatable



tack free



tapeable



ready to assemble



sandable

Min. Max.

Panel temperat.	20°C	16 h	2 h	16 h	16 h	16 h
Panel temperat.	60°C	30 min	30 min	30 min	30 min	30 min

Remarks



Attention! The shelf life of the mixed product (Line GHD TOPCOAT and GHD CHASSISMIX) is only 2 weeks. The DTM version is not suitable for areas that are directly exposed to sunlight. The corrosion protection can only be achieved, if the required film thickness is applied (covering of sand blasting roughness, edges). Mixing of GHD CHASSISMIX and Line GHD TOPCOAT can change the color (DTM). The adhesion on hot dipped galvanized steel has to be checked before.

