



GRAPHITE HD

Product code: AT04-

Resin base Modified polyacrylate



Mixing ratio 100:25:25 by volume, use mixing stick



Hardener H 350 normal
H 300 fast



Reducer GV 200 for temperatures from +12°C to +22°C
GV 300 for temperatures from +22°C to +30°C
GV 400 for temperatures beyond +30°C



Spray viscosity 18 - 22 s DIN 4
Potlife 1 - 2 h



Application	Number of spraycoats	Spraying pressure	Material pressure	Nozzle diameter	Compliant gun
Double membrane pump Pressure pot	1.5	2,5 bar	0.9 – 1.5 bar	1.1 mm	1.0 mm
Airless/Airmix *	1.5	120 – 150 bar	-	0.23 mm	-
Gravity-feed spraygun	1.5	2.5 bar	-	1.4 mm	1.4 mm
Suction-feed spraygun	1.5	2.5 bar	-	1.7 mm	1.6 mm

Dry film thickness 40 – 60 µm
Spreading rate (DIN 53 219) 536 m²/l at 1 µm film thickness

Solids content 67% by weight ± 4 (74% ± 4 at original viscosity) (DIN EN ISO 3251)



Flash-off at 20°C



Drying	Recoatable	Tack-free	Tapeable	Ready for assembly
Panel temperature 20°C	16 h	2.5 h	16 h	12 h
60°C	30 min.	after cooling	after cooling	after cooling

Substrates

All R-M CV primer fillers and surfacers; sanded old paintwork.

Remarks

Application: Pre-spray 1 thin grip coat with the finishing coat following immediately.
Air drying → up to 16 h recoatable with itself without sanding
after oven an 16 h air drying you have to use an adhesion promoter for multi colour process, for Airmix / airless application the object temperature for oven drying should not be higher than 45°C. Ambient processing temperature should be at least 18° C !
* For Airless / Airmix application use CV 38 M instead of CV 35 M.

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

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules. The products are suitable for professional use only.

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.rmpaint.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. It cannot be ruled out that this product contains particles < 0.1 µm.

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