













# GRAPHITE HD EPOXY CF, for 3-stage system

Prod. code: AS43-7962

<b>Resin base</b>	Epoxy				
 <b>Mixing ratio</b>	100:25:25 , use mixing stick				
 <b>Hardener</b>	GRAPHITE HD EPOXY HARDENER				
 <b>Reducer</b>	GV 100 fast GV 300 slow GV 400 very slow				
 <b>Spray viscosity</b>	18 - 20 s DIN 4				
 <b>Potlife</b>	8 h				
 <b>Application</b>	<b>Number of spraycoats</b>	<b>Spraying pressure</b>	<b>Material pressure</b>	<b>Nozzle diameter</b>	<b>Compliant gun</b>
<b>Double membrane pump Pressure pot</b>	1 - 2	2,5 bar	0.9 – 1.5 bar	0.8 – 1.5 mm	1.0 mm
<b>Airless/Airmix</b>	1 - 2	120 – 150 bar	-	0.33 mm	-
 <b>Gravity-feed spraygun</b>	2 – 3	2,5 bar	-	1.5 mm	1.4 mm
 <b>Suction-feed spraygun</b>	2 – 3	2,5 bar	-	1.7 mm	1.6 mm
<b>Dry film thickness</b>	30 – 35 µm when used as a primer				
<b>Spreading rate (DIN 53 219)</b>	425 m <sup>2</sup> /l at 1 µm film thickness				
<b>Solids content (DIN EN ISO 3251)</b>	59% by weight ± 4 (72% ± 4 at original viscosity)				
 <b>Flash-off at</b>	20°C				
 <b>Drying</b>	<b>Recoatable</b>	<b>Tack-free</b>	<b>Tapeable</b>	<b>Ready for assembly</b>	
<b>Panel temperature 20°C</b>	72 h	3 h	16 h	16 h	
<b>60°C</b>	30 min.				
<b>Substrates</b>	Steel, GRP, SMC, wood, plywood				
<b>Remarks</b>	Minimum ambient temperature during application and drying: +12°C When product is used as a surfacer, film thickness must be 50 – 60 µm. For wet-on-wet application of topcoat: 60 min. flash-off at 20°C or baking at 60°C for 30 min. Dry sanding possible after 16 hours at 20°C or 60 min. at 60°C. Subsequent wet-on-wet application of GRAPHITE HD always requires intermediate drying at 60°C for 30 min. (without flash-off).				
<b>2004/42/IIB(Cl) (540)520</b>	The EU limit value for this product (product category: IIB.Cl) in ready to use form is max 540 g/litre of VOC. The VOC content of this product is 520 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](http://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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