

PRODUCT DATA SHEET

GRAPHITE HD HS EPOXY, P 5420

light grey

PF

Application

busses, fire-fighting vehicle, boxes, bulk loading vehicles, boxes (aluminium)



Description:

- suitable on all metal substrates
- very good levelling
- good filling properties
- all-purpose
- outstanding corrosion protection
- light grey (L05), tintable with GHD CV PRIMER TINTING PASTE
- overcoating with ONYX; DIAMONT; GRAPHITE HD *

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	●

Remarks:

The substrate should be clean, free of dust, rust, oil and grease.

* For overcoating with ONYX or DIAMONT flash off of 1h at 20°C (not less) is mandatory.
** Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test before application. See GHD Painting Manual from block A4 pretreatment.

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 I)(540)455:** 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 455 g/l.**



Paint process

Spreading rate

≈ 477 m² / l / 1µm

Solid content

~78% res. 66% mixed (+/- 2%)

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.

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Perfection made simple



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Mixing ratio	100:25:25 by volume		
Hardener	GHD HS EPOXY HARDENER		
Reducer	GV 200 CV, standard GV 300, slow GV 400, very slow	15 - 20°C 20 - 25°C 25 - 30°C	
Spray viscosity DIN 4 / 20°C	18 - 22s. DIN 4	Potlife 20 °C	8 h

Application		Compliant-gravity feed cup	HVLP-Spray gun	Suction cup	Airless/Airmix (ESTA)	Pressure pot/Dble membr. Pump
Atomization pressure	bar	2,2 - 2,5	2,0	2,5	2	2,5
Material pressure	bar	-	-	-	120 - 150	0,8 - 1,5
Nozzle size	mm	1,4 - 1,6	1,5	1,7	0,28 - 0,33	1,0 - 1,1
Voltage	kV	-	-	-	50 - 80	-
Elect. Resistance	Ω	-	-	-	600 - 900	-
Number of spraycoats		1,5 - 2	1,5 - 2	1,5 - 2	1,5 - 2	1,5 - 2
Flash off	min.	10 - 15	10 - 15	10 - 15	10 - 15	10 - 15
Filmbuild	µm	50 - 70				

Drying		over-coatable	tack free	tapeable	ready to assemble	sandable
		Min.	Max.			
Panel temperat.	20°C	60 min	72 h	3 h	16 h	16 h
Panel temperat.	60°C	30 min		30 min	30 min	30 min
						See remarks
						45 min – 1 h

Remarks



Minimum ambient temperature during application and drying: +12°C (for overcoating with ONYX or DIAMONT flash off at least 1h at 20°C mandatory). The first coat has to be a light closed coat followed after flash off by a second full wet coat. For blasted substrates take care of the roughness depth.

There is no need to sand GHD HS EPOXY because of the very good levelling. If sanding is required: 45 min to 1 h at 60°C object temperature or drying over night (minimum 18°C room temperature). For tinting see GHD CV PRIMER TINTING PASTE.

Before applying polyester products GHD HS EPOXY has to be dried for at least 45 min 60°C (object temperature). The adhesion on hot dipped galvanized steel has to be checked before.

