

# GHD UNIVERSAL EPOXY

**P 5480**

## GHD UNIVERSAL EPOXY

**Application:**



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

**Key Features:**

- suitable on many metal substrates
- very good levelling
- good filling properties
- all-purpose
- outstanding corrosion protection
- tintable with GHD TINTING PASTE
- overcoating with GRAPHITE HD, ONYX HD, DIAMONT \*

**Remarks:**

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

\* For overcoating with ONYX HD or DIAMONT flash off of 1h at 20°C is mandatory.

Because of the variety of metal alloys and manufacturing processes, it is recommended to carry out a preliminary adhesion test before application.

A 5480 GHD ADDITIVE for UNIVERSAL EP 15 - 30°C

**Safety advice:**

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

The products are suitable for professional use only. For the use of this product please adhere to the actual safety recommendations and the personal protective equipment.

**2004/42/IIIB (c I)(540)493:** 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 493 g/l.

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.

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### Substrates

- = Very well suited
- = well suited
- = suited in some cases

Steel	Galvanized steel	Stainless steel	Aluminium	Anodized Aluminium	GRP / SMC	PP-EPDM	R-M CV - Primer	R-M CV - Primer Filler / Filler	Powder coating	Coil-coating	Plywood	Wood	OEM-Paintwork	Old paint work
●●	●●	●●	●●	●●	●●				●●	●●	●●	●●	●	●



### Paint System

**Spreading rate** 430 m<sup>2</sup>/l at 1 µm  
**Solid Content** ~ 77% (RFU~63%)

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### GHD UNIVERSAL EPOXY



**Mixing Ratio** 100:25:25 by volume



**Hardener** H 5480



**Thinner** A 5480



**Spray viscosity at 20°C** DIN 4: 19-22 s

**Potlife at 20°C** 8 h

Application:	Compliant - gravity feed cup	HVLP spray gun	Suction cup	Airless/ Airmix	Pressure pot dbl.-pump
<b>Application pressure</b>	2.2-2.5 bar	2 bar	2.5 bar	2 bar	2.5 bar
<b>Material pressure</b>				120-150 bar	0.8-1.5 bar
<b>Nozzle size</b>	1.4-1.6	1.5	1.7	0.28-0.33	1-1.1
<b>Voltage</b>				50-80 kV	
<b>Elect. Resistance</b>				600-900 Ω	
<b>Number of coats</b>	1.5 - 2	1.5 - 2	1.5 - 2	1.5 - 2	1.5 - 2
<b>Flash off at 20°C</b>	10-15 min	10-15 min	10-15 min	10-15 min	10-15 min
<b>Film thickness</b>	50-70 µm				

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### GHD UNIVERSAL EPOXY



Drying	Overcoatable		Tack-free	Ready for masking	Ready to assemble	Sandable
	Min.	Max.				
Object Temp. 20°C	60 min	72 h	3 h	16 h	16 h	
Object Temp. 60°C	30 min		30 min	30 min	30 min	50-60 min

#### Remark

Minimum ambient temperature during application and drying: +15°C .  
 For overcoating with ONYX HD or DIAMONT flash off at least at 1 h 20°C mandatory, maximum flash off time: within one working day (for over coating with GRAPHITE HD 72 h).  
 Do not adjust P 5480 with reducer GV, only with A 5480 GHD ADDITIVE for UNIVERSAL EP!  
 The first coat has to be a light closed coat followed after flash off by a second full wet coat.  
 On blasted substrates take care of the roughness depth.  
 There is no need to sand P 5480 because of the very good levelling. If sanding is required: Drying of 50 - 60 min at 60°C object temperature or 16 h at 20°C is necessary.  
 For tinting see variant with GHD TINTING PASTE.  
 Before applying polyester products P 5480 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.

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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