

45540: BASE 45549: CURING AGENT 97531

Description:	HEMPADUR MULTI-STRENGTH 45540 is a two component pure epoxy paint which cures to an abrasion and corrosion resistant coating. Applicable by standard heavy duty airless spray equipment. Well suited for application under humid conditions and for early water exposure.
Recommended use:	As a maintenance and repair primer in HEMPADUR systems in severely corrosive environment. As a self-primed, high build coating primarily for maintenance of e.g. splash zones, jetty pilings, ships' hulls and ballast tanks
Service temperature:	Maximum, dry exposure only: 140°C/284°F In water (no temperature gradient): 60°C/140°F Maximum peak temperature in water is 80°C/176°F.
Certificates/Approvals:	
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	19990*/ Black.
Finish:	Glossy
Volume solids, %:	84 ± 1
Theoretical spreading rate:	2.4 m ² /l [96.2 sq.ft./US gallon] - 350 micron/14 mils
Flash point:	26 °C [78.8 °F]
Specific gravity:	1.7 kg/litre [13.9 lbs/US gallon]
Surface-dry:	4 hour(s) 20°C/68°F
Dry to touch:	6 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	176 g/l [1.5 lbs/US gallon]
Shelf life:	1 year for BASE and 3 years (25°C/77°F) for CURING AGENT from time of production. <i>*other shades according to assortment list.</i>
	<i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
APPLICATION DETAILS:	
Version, mixed product:	45540
Mixing ratio:	BASE 45549: CURING AGENT 97531 4:1 by volume
Application method:	Airless spray
Thinner (max.vol.):	08450 (5%)
Pot life:	1 hour(s) 20°C/68°F
Nozzle orifice:	0.021 - 0.023 "
Nozzle pressure:	250 bar [3625 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	350 micron [14 mils]
Indicated film thickness, wet:	425 micron [17 mils]
Overcoat interval, min:	According to specification.
Overcoat interval, max:	According to specification.
Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations.

SURFACE PREPARATION:	<p>New steel: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to minimum Sa 2½ (ISO 8501-1:2007) with a surface profile corresponding to Rugotest No. 3, N9a to N10, preferably BN9a to BN10, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G).</p> <p>Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove all rust and loose material by wet or dry abrasive blasting or power tool cleaning. As an alternative to dry cleaning, wet abrasive blasting or water jetting to min. Wa 2½ (ISO 8501-4:2006) (or according to specification), may be used. A flash-rust degree of maximum L (ISO 8501-4:2006) is acceptable before application. Feather edges to sound and intact areas. After wet abrasive blasting hose down the surface with fresh water and allow drying. Touch up bare spots with: specified HEMPADUR paint</p>
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above: 5°C/41°F. The temperature of the paint itself should be above: 15°C/59°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None. HEMPADUR 15590 may be used as a blast primer.
SUBSEQUENT COAT:	According to specification.
REMARKS:	
Colours/Colour stability:	Light shades will have a tendency to yellow when exposed to sunshine and darken when exposed to heat.
Weathering/service temperatures:	The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.
Induction time:	In order to obtain the best possible spray properties, mix the components thoroughly and allow the mixture to pre-react for 10 - 15 minutes before use (Induction time). 20°C/68°F or 30 minutes , 10°C/50°F.
Application(s):	The product may be immersed after 4 hours of initial curing at 20°C/68°F. Curing will proceed under water. Early immersion may result in some discolouration. This does not affect the protective properties of the product.
Film thicknesses/thinning:	May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and overcoating interval. Normal range dry is: 125 micron/5 mils -350 micron /14 mils. Avoid application of excessive film thickness
Overcoating intervals:	If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	HEMPADUR MULTI-STRENGTH 45540 For professional use only.
ISSUED BY:	HEMPEL A/S 4554019990

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on www.hempel.com. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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