

### Medium to high temperatures 17630 : BASE 17639 : CURING AGENT 97330

<b>Description:</b>	HEMPADUR 17630 is a two-component, high-build, polyamide adduct-cured epoxy paint which cures to a hard and tough coating with good resistance to abrasion, seawater and various oils.
<b>Recommended use:</b>	As a selfprimed coating for ballast water tanks and similar. As a primer for epoxy systems for atmospheric or in-water service, eg ship hulls. Suitable for application down to 0°C/ 32°F. HEMPADUR 17630 is intended for use in temperate to warm climates. For cold/temperate climates use HEMPADUR 17633.
<b>Service temperature:</b>	Maximum, dry exposure only: 120°C/248°F (see REMARKS overleaf) Ballast water service. Resists normal ambient temperatures at sea (Avoid long-term exposure to negative temperature gradients). In water (no temperature gradient): 40°C/105°F Other liquids. Contact HEMPEL
<b>Certificates/Approvals:</b>	Tested for non-contamination of grain cargo at the Newcastle Occupational Health & Hygiene, Great Britain. Approved as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on <a href="http://www.Hempel.com">www.Hempel.com</a> for further details. Complies with EU Directive 2004/42/EC: subcategory j.
<b>Availability:</b>	Part of Group Assortment. Local availability subject to confirmation.

### PHYSICAL CONSTANTS:

Shade nos/Colours:	12170 / Grey.
Finish:	Semi-flat
Volume solids, %:	69 ± 2
Theoretical spreading rate:	4.6 m <sup>2</sup> /l [184.5 sq.ft./US gallon] - 150 micron/6 mils
Flash point:	32 °C [89.6 °F]
Specific gravity:	1.4 kg/litre [11.4 lbs/US gallon]
Dry to touch:	7 - 8 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	302 g/l [2.5 lbs/US gallon]
Shelf life:	3 years for BASE and 3 years (25°C/77°F) for CURING AGENT from time of production.

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.*

### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>17630</b>
Mixing ratio:	BASE 17639 : CURING AGENT 97330 4 : 1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (5%)
Pot life:	2 hour(s) 20°C/68°F
Induction time:	- see REMARKS overleaf
Nozzle orifice:	0.021 - 0.025 "
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:	150 micron [6 mils]
Indicated film thickness, wet:	225 micron [9 mils]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf

<b>Safety:</b>	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.
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**SURFACE PREPARATION:** **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). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating. For repair and touch-up use: HEMPADUR QUATTRO 17630.

**Ballast tanks and cargo oil tanks:** See separate APPLICATION INSTRUCTIONS

**Steel, maintenance:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of the paint. As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be Wa 2 - Wa 2½ (atmospheric exposure) / minimum Wa 2½ (immersion) (ISO 8501-4:2006). A flash-rust degree of maximum M (atmospheric exposure), preferably L (immersion) (ISO 8501-4:2006) is acceptable before application. Feather edges to sound and intact paint. Dust off residues. Touch up to full film thickness. On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting or wet abrasive blasting, alternatively dry abrasive blasting followed by high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.

**Other substrates:** contact Hempel.

**APPLICATION CONDITIONS:** Use only where application and curing can proceed at temperatures above: 0°C/32°F. Apply only on a dry and clean surface with a temperature min. 3°C/5°F above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.

**PRECEDING COAT:** None, or as per specification.

**REMARKS:**

**VOC - EU Directive 2004/42/EC:**

Product	As supplied	5 vol. % thinning	Limit phase II, 2010
1763012170	302 g/l	330 g/l	500 g/l

For VOC of other shades, please refer to Safety Data Sheet.

**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:** To facilitate proper application properties it is recommended to allow the thoroughly mixed BASE and CURING AGENT to prereact before application. In case two-component spray-equipment is used consult separate APPLICATION INSTRUCTIONS.

**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: 125-200 micron/5-8 mils

**Overcoating:** Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

A specification supersedes any guideline overcoat intervals indicated in the table.

Environment	Atmospheric, medium					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	12 h	Ext.	6 h	Ext.	5 h	Ext.
HEMPATEX	10 h	24 h	5 h	12 h	4 h	9 h
HEMPATHANE	12 h	20 d	6 h	10 d	5 h	7½ d
Environment	Immersion					
HEMPADUR	16 h	60 d	8 h	30 d	6 h	22 d

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

**Note:** **HEMPADUR 17630 For professional use only.**

**ISSUED BY:** HEMPEL A/S

1763012170

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on [www.hempel.com](http://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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