

47182: BASE 47188: CURING AGENT 98470

Description:	HEMPADUR 47182 is an anticorrosive two-component, modified polyamide adduct cured epoxy.
Recommended use:	For atmospheric and immersion service used as a "tiecoat" between epoxy and physically drying coatings. For immersion service it can also replace one anti-corrosive primer coat for the underwater coating system and at the same time act as "tiecoat" for antifouling or it may also be used as a "sealer" for old antifoulings.
Service temperature:	Maximum, dry exposure only: 80°C/176°F
Availability:	Subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	25150 / Yellowish grey
Finish:	Flat
Volume solids, %:	62 ± 1
Theoretical spreading rate:	5 m ² /l [200.5 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	28 °C [82.4 °F]
Specific gravity:	1.4 kg/litre [11.7 lbs/US gallon]
Dry to touch:	6 hour(s) 20°C/68°F
Fully cured:	7 day(s) , 20°C/68°F
VOC content:	364 g/l [3 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:

Version, mixed product:	47182
Mixing ratio:	BASE 47188: CURING AGENT 98470 7 : 1 by volume
Application method:	Airless spray / Brush (touch up)
Thinner (max.vol.):	08450 (5%) / 08450 (5%)
Pot life:	2 hour(s) 20°C/68°F
Nozzle orifice:	0.023 "
Nozzle pressure:	230 bar [3335 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	125 micron [5 mils] see REMARKS overleaf
Indicated film thickness, wet:	200 micron [8 mils]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf

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: **New steel:** Abrasive blasting to Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting.
Maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning.
 When used as "tiecoat": Remove all rust and loose material by abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness. see REMARKS below
 When used as "sealer" on old antifouling: a very careful high pressure freshwater cleaning -or jetting, if needed - to remove possible leached layer of antifouling and make sure that old layers of weak intercoat adhesion ("sandwich structure") really are removed.

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above: - 5°/23°F. The temperature of the surface and that of the paint itself must also be above this limit. When the ambient temperature is below 15°C/59°F then the paint should be kept at between 20°C/68°F and 25°C/77°F to maintain application properties. 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.
 Whilst application down to -5°C/23°F is possible, curing (and full hardness) will take longer at lower temperatures.

PRECEDING COAT: According to specification. Recommended systems are: HEMPADUR In case of an old antifouling system this must be well cleaned and in good condition.

SUBSEQUENT COAT: Note that the film must be dry (not tacky) before application of subsequent coats and all minimum overcoating intervals must be observed.

REMARKS:

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: 75 - 150 micron / 5-6 mils.
 As "sealer" typically to be specified in: 100 micron/4 mils dry film thickness. Thinning may be required to facilitate proper film formation.
 When the specified dry film thickness is under 100 micron / 4 mils, or at lower temperatures, it can be advantageous to add up to 5% HEMPEL'S THINNER 08450.
SUBSEQUENT COAT: The product is designed for overcoating with antifouling in any normal specified total film thicknesses. The product is not designed for overcoating with heavy duty epoxy systems. Later maintenance of paint systems with the product as a part of the system is accordingly most conveniently carried out by touch-up with a "mastic" type epoxy and with a proper overlap of intact surrounding paint system.

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					
	0°C (32°F)		10°C (50°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
HEMPATHANE*	NR	NR	14 h	Ext.	7 h	Ext.
HEMPATEX	32 h	31.5 d	15 h	14 d	7 h	7 d
GLOBIC	41 h	22½ d	9 h	5 d	7 h	3½ d
Environment	Immersion					
GLOBIC	41 h	22½ d	9 h	5 d	7 h	3½ d

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

Overcoating note: A completely clean surface is mandatory to ensure intercoat adhesion, especially at long overcoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed by fresh water hosing. Any degraded surface layer, as a result of a long exposure period, must be removed as well. Water jetting may be relevant to remove any degraded surface layer and may also replace the above mentioned cleaning methods when properly executed. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.

*Overcoating with HEMPATHANE is not recommended (NR) if the product has dried at an air temperature below 10°C/50°F.

Note: **HEMPADUR 47182 For professional use only.**

ISSUED BY: HEMPEL A/S

4718225150

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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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