

47800: BASE 47809: CURING AGENT 97800

Description:	HEMPADUR IMPACT 47800 is a self-priming, two-component high build pure epoxy paint which cures to an abrasion, impact and corrosion resistant coating.
Recommended use:	As a dedicated heavy duty coating for hatch coamings and cargo holds of bulk carriers.
Service temperature:	Maximum, dry exposure only: Maximum: 120°C/248°F
Certificates/Approvals:	Complies with Section 175.300 of the Code of Federal Regulations Title 21 – Dry Foodstuff. Consult Hempel for details. Tested for non-contamination of grain cargo at the Newcastle Occupational Health & Hygiene, Great Britain.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	50630 Red
Finish:	Flat
Volume solids, %:	76 ± 1
Theoretical spreading rate:	6.1 m ² /l [244.6 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	33 °C [91.4 °F]
Specific gravity:	1.5 kg/litre [12.8 lbs/US gallon]
Surface-dry:	2.5 hour(s) 20°C/68°F
Through-dry:	5 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	247 g/l [2.1 lbs/US gallon]
Shelf life:	3 years for BASE and 3 years (25°C/77°F) for CURING AGENT from time of production. <i>*other shades according to assortment list.</i>

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

APPLICATION DETAILS:

Version, mixed product:	47800
Mixing ratio:	BASE 47809: CURING AGENT 97800 4:1 by volume
Application method:	Airless spray / Brush (touch up)
Pot life:	1 hour(s) (20°C/68°F)
Induction time:	- see REMARKS overleaf
Nozzle orifice:	0.019 - 0.021 "
Nozzle pressure:	150 bar [2175 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]
Indicated film thickness, wet:	175 micron [7 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.
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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 Sa 2 (ISO 8501-1:2007), with a surface profile equivalent to Rugotest No. 3 BN 10, Keane-Tator Comparator 3.0 G/S or ISO Comparator, rough MEDIUM (G). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating. After blasting, clean the surface carefully from abrasives and dust. Repair and maintenance: Remove oil and grease 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 (ISO 8501-1:2007) (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007). Improved surface preparation will improve the performance of the product. As an alternative to dry cleaning, wet abrasive blasting or water jetting to min. Wa 2½ (ISO 8501-4:2006)
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	(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. Dust off residues. On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting or, alternatively, dry abrasive blasting, high pressure fresh water hosting, drying, and finally dry abrasive blasting again. After wet abrasive blasting hose down the surface with fresh water and allow drying. Touch up bare spots with: specified HEMPADUR paint.
APPLICATION CONDITIONS:	Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 0°C/32°F. The temperature of the paint itself should be above: 15°C/59°F and below 30°C/86°F to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. To achieve full mechanical properties the coating requires a period of cure above 5°C/41°F.
PRECEDING COAT:	None. HEMPADUR 15590 or HEMPADUR IMPACT 47800 can be used as a blast primer (10°C/50°F) diluted 15-25 % with HEMPEL'S THINNER 08450.
REMARKS:	
Colours/Colour stability:	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. Has a tendency to yellow after application. This has no influence on the performance nor does the yellowing affect any topcoat applied.
Induction time:	To facilitate proper application properties it is recommended to allow the thoroughly mixed BASE and CURING AGENT to prereact before application. At a paint temperature of 20°C/68°F the paint may advantageously be prereacted 10 minutes before spray application (20 minutes at 15°C/59°F). Pot life of mixed paint: 1.5 hours - 15°C/59°F 1 hour - 20°C/68°F 45 minutes - 25°C/77°F 30 minutes - 30°C/86°F The viscosity can be too high for airless spray application below: 15°C/59°F Avoid temperature above: 30°C/86°F.
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 amount of thinning, drying time and overcoat interval. Normal range is: 100 -150 micron /4 -6 mils dry film thickness. It is recommended to use heavy airless spray equipment with a pump transmission rate of 60:1 (approximately), and a theoretical output of min. 12 litres per minute. Excessive film thickness must be avoided. Normally not to be diluted.
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
47800	24 h	90 d	8 h	60 d	4 h	30 d

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

Note:	HEMPADUR IMPACT 47800 For professional use only.	
ISSUED BY:	HEMPEL A/S	4780050630

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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