

<b>Description:</b>	HEMUCRYL 48160 is a water-borne high build, acrylic dispersion based paint. Especially suited for application by airless spray.
<b>Recommended use:</b>	As a one coat system for repair and maintenance of steel constructions in mild to moderately corrosive environment.
<b>Service temperature:</b>	Maximum, dry exposure only: 120°C/248°F
<b>Certificates/Approvals:</b>	Complies with EU Directive 2004/42/EC: subcategory i.
<b>Availability:</b>	Not included in Group Assortment. Availability subject to special agreement.
<b>PHYSICAL CONSTANTS:</b>	
Shade nos/Colours:	12170* / Grey.
Finish:	Flat
Volume solids, %:	53 ± 1
Theoretical spreading rate:	2.7 m <sup>2</sup> /l [108.3 sq.ft./US gallon] - 200 micron/8 mils
Flash point:	365 °C [689 °F]
Specific gravity:	1.4 kg/litre [11.3 lbs/US gallon]
Surface-dry:	1 hour(s) 20°C/68°F
Through-dry:	1.5 hour(s) 20°C/68°F (see REMARKS overleaf)
VOC content:	22 g/l [0.2 lbs/US gallon]
Shelf life:	1 year (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage. <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>
<b>APPLICATION DETAILS:</b>	
Application method:	Airless spray / Brush
Thinner (max.vol.):	Fresh water (5%) / Fresh water (5%)
Nozzle orifice:	0.015 - 0.019 " (see REMARKS overleaf)
Nozzle pressure:	130 bar [1885 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	Fresh water (see REMARKS overleaf)
Indicated film thickness, dry:	200 micron [8 mils] (see REMARKS overleaf)
Indicated film thickness, wet:	375 micron [15 mils]
Overcoat interval, min:	According to specification.
Overcoat interval, max:	According to specification.
<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.

SURFACE PREPARATION:	Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove rust and loose paint by abrasive blasting or power tool cleaning to St 3 (ISO 8501-1:2007) (minor areas) before recoating. For repair and touch-up use: HEMUCRYL 48160.											
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above: 5°C/41°F , preferably above 10°C/50°F. Relative humidity during application and drying: maximum 80%, preferably 40-60%. Good ventilation during application and drying is necessary. During drying it is of utmost importance that sufficient ventilation is covering all parts of the surfaces painted. Ventilation requirements to remove the water vapours liberated during application and drying are approx. 75 m³/litre of paint at 20°C/68°F. (Relative humidity of the air supply 40%)											
PRECEDING COAT:	None, or as per specification. Aged, solvent-borne coatings may be overcoated after a very careful cleaning. However, a test patch is recommended to establish intercoat adhesion. Aged, chemically cured coatings (alkyd, epoxy, polyurethane etc.) may also precede. Yet, only recommended in case of later mild exposure - besides a very careful cleaning, roughening may be necessary and a test patch is recommended to establish intercoat adhesion.											
SUBSEQUENT COAT:	None, or as per specification.											
REMARKS:												
VOC - EU Directive 2004/42/EC:	<table><tr><th>Product</th><th>As supplied</th><th>0 vol. % thinning</th><th>Limit phase II, 2010</th></tr><tr><td>4816012170</td><td>22 g/l</td><td>22 g/l</td><td>140 g/l</td></tr></table> For VOC of other shades, please refer to Safety Data Sheet.				Product	As supplied	0 vol. % thinning	Limit phase II, 2010	4816012170	22 g/l	22 g/l	140 g/l
Product	As supplied	0 vol. % thinning	Limit phase II, 2010									
4816012170	22 g/l	22 g/l	140 g/l									
Application(s):	The durability/performance of water-borne coatings is to a very high degree depending on the: fulfilment of good painting practice. For instance application to riveted and skip-welded constructions will require extra care when coating sharp edges, riveted joints, etc. Avoid too high thicknesses per coat. Preferably apply an extra stripe coat. Distance of nozzle to the surface must be kept at: Minimum: 50 cm/20 inches. If the painted items will be exposed to humidity/water at temperatures below 5-10°C/40-50°F temperatures shortly after finishing the paint application, it is of utmost importance for later good performance shortly after that the following rules are complied with: Excessive film thickness must be avoided. Before exposure to temperatures below 5°C/41°F and/or condensation/water, the (last applied) paint layer must dry for at least: 6 hours (20°C/68°F, 40-60% RH) , 12 hours (10°C/50°F 40-60% RH) . Avoid outdoor application in seasons with low night temperatures especially in combination with condensation or rain.											
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 is: 150-300 micron/6-12 mils .											
"Edge effect":	As water-borne paints have a high tendency to "withdraw" from sharp edges, etc., proper corrosion protection will be highly supported by careful rounding of edges and that any joints are completely closed and tight.											
Cleaning of tools:	Clean tools carefully with fresh water or lukewarm soap water immediately after use. Dried remains of paint can be removed with: HEMPEL'S TOOL CLEANER 99610											
Storage Conditions:	Store at temperatures between 5-40°C/41-104°F. Shelf life is reduced at temperatures above 30°C/86°F. Do not expose to frost during storage and transport, or before the coating is dry.											
Note:	<b>HEMUCRYL 48160 For professional use only.</b>											
ISSUED BY:	HEMPEL A/S											

4816012170

4816012170

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.

The Products are supplied and all technical assistance is given subject to HEMPEL'S GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.