

### 48500: BASE 48509: CURING AGENT 98721

<b>Description:</b>	HEMUDUR 48500 is a water-borne, two-component, fast curing polyamine cured epoxy paint containing corrosive inhibiting pigment. It cures to a strong and rust-preventing coat.
<b>Recommended use:</b>	In mildly to moderately corrosive environments as a selfprimed paint system on steel constructions where the usual outdoor cosmetic appearance of epoxy paint is acceptable.
<b>Service temperature:</b>	Maximum, dry exposure only: 140°C/284°F
<b>Availability:</b>	Not included in Group Assortment. Availability subject to special agreement.

#### PHYSICAL CONSTANTS:

Shade nos/Colours:	35670* / Blue.
Finish:	Glossy
Volume solids, %:	48 ± 1
Theoretical spreading rate:	3.8 m <sup>2</sup> /l [152.4 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	100 °C [212 °F]
Specific gravity:	1.4 kg/litre [11.6 lbs/US gallon]
Surface-dry:	30 minute(s) 20°C/68°F
Through-dry:	4 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	36 g/l [0.3 lbs/US gallon]

*\*other shades according to assortment list.*

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

#### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>48500</b>
Mixing ratio:	BASE 48509: CURING AGENT 98721 2 : 3 by volume
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	Fresh water (5%) / Fresh water(20%) / Fresh water (5%)
Pot life:	1 hour(s) 20°C/68°F (see REMARKS overleaf) 30 minutes 10°C/50°F
Nozzle orifice:	0.013 - 0.019 " (see REMARKS overleaf)
Nozzle pressure:	Minimum: 150 bar (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	Fresh water (see REMARKS overleaf)
Indicated film thickness, dry:	125 micron [5 mils] (see REMARKS overleaf)
Indicated film thickness, wet:	275 micron [11 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.
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SURFACE PREPARATION:	<p><b>New steel:</b> Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. 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. For repair and touch-up use: HEMUDUR 48500.</p> <p><b>Repair:</b> 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: HEMUDUR 48500.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above: 15°C/59°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Maximum relative humidity: 80%. Preferable relative humidity range: 40-60%. Good ventilation during application and drying is necessary.</p> <p>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%)</p>
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
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.
Application(s):	<p>Pot life: 3 hour(s) 20°C/68°F; It is important that the paint is no longer used as its protective properties are dramatically reduced after this time. Be aware that the pot life will decrease when the temperature decreases. Eg decreases to: 30 minutes (15°C/59°F). Use eg an alarm clock to indicate when the pot life has been exceeded. Temperatures indicated are understood as the common temperature for both paint material and the steel to be painted.</p> <p>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.</p> <p>It is of utmost importance for later good performance that the following rules are followed if, shortly after the paint has dried, the painted items will be exposed to humidity/water at temperatures below 10°C/50°F.</p> <p>Excessive film thickness must be avoided.</p> <p>Before exposure to temperatures below 10°C/50°F and/or condensation/water exposure the (last applied) paint layer must dry for at least: 24 hour(s) (20°C/68°F 40-60% RH).</p> <p>Avoid outdoor application in seasons with low night temperatures especially in combination with condensation or rain.</p>
Application equipment:	For proper film formation the recommended nozzle sizes should be used.
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 overcoat interval. Normal range is: 75-150 micron/3-6 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:	Tools must be cleaned immediately with lukewarm soap water and/or fresh water followed by thoroughly rinsing to remove residues of detergent. Dried remains of paint may 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.
Overcoating note:	The surface MUST be completely clean before overcoating. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.
Note:	<b>HEMUDUR 48500 For professional use only.</b>
ISSUED BY:	HEMPEL A/S

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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](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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