

47140: BASE 47149: CURING AGENT 98140

Description:	HEMPADUR 47140 is a two-component polyamide adducts cured, high build epoxy paint which combines a relatively high volume solids content with a short drying time. VOC compliant.
Recommended use:	As a primer in mild to medium atmospheric environments. As an intermediate or finishing coat in epoxy systems in medium to severely corrosive atmospheric environment. As a finishing coat where the usual outdoor cosmetic appearance of epoxy paints is acceptable. May be used directly on cured zinc silicate (GALVOSIL products) or spray-metallised surfaces to minimise popping.
Service temperature:	Maximum, dry exposure only: 140°C/284°F
Certificates/Approvals:	Complies with EU Directive 2004/42/EC: subcategory j.
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	20450 (RAL 9001)* / Cream
Finish:	Semi-gloss
Volume solids, %:	70 ± 1
Theoretical spreading rate:	5.6 m ² /l [224.6 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	23 °C [73.4 °F]
Specific gravity:	1.5 kg/litre [12.9 lbs/US gallon]
Surface-dry:	1 hour 20°C/68°F
Through-dry:	2 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	299 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. <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>	
APPLICATION DETAILS:	
Version, mixed product:	47140
Mixing ratio:	BASE 47149: CURING AGENT 98140 4:1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	Usually less than: 5%, depending on purpose see REMARKS overleaf
Pot life:	1 hour 20°C/68°F
Nozzle orifice:	0.019 - 0.021 "
Nozzle pressure:	225 bar [3262.5 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:	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.

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).
Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove all rust and loose material by wet or dry abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. Dust off residues. Touch up bare spots with: specified HEMPADUR paint

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above: 0°C/32°F. The temperature of paint itself should be 15°C/59°F or above. 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: According to specification. Recommended systems are: Spray metallisation, HEMPADUR ZINC 17360, HEMPEL'S GALVOSIL 15700.

SUBSEQUENT COAT: None, or as per specification. Recommended systems are: HEMPATHANE, HEMPAXANE.

REMARKS:

VOC - EU Directive 2004/42/EC:

Product	As supplied	5 vol. % thinning	Limit phase II, 2010
4714020450	299 g/l	327 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.

Application(s): **Irregular surfaces:** Similar to other very fast drying/curing epoxies; this product is sensitive towards the geometry of irregular surfaces. Special care should be taken in relation to irregular surfaces (welding seams, undercuts, corners etc.) as application with an excessive film thickness may result in cracking.

It is recommended to apply the paint by using a "mist-coat" procedure. A thin, undiluted coat is applied (the mist coat) and after a few minutes, a second coat is applied in the full specified film thickness.

Depending on actual conditions of application, such as temperature, porosity of substrate, method of spray, a sealer coat (thinned up to 30%) can be applied as an alternative method to reduce popping, followed by application of the full coat.

Film thicknesses/thinning:

Film thickness:

The recommended nominal dry film thickness (NDFT) is 80-150 micron/3.2-6 mils.

Overthickness on irregular surfaces shall be avoided or highly controlled.

Overthickness on overlapping areas, corners, welding seams, etc should be less than 300 µm/12 mils DFT.

Thinning:

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Recommended systems are: HEMPEL'S THINNER 08450, HEMPEL'S THINNER 08700.

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
HEMPADUR	9 h	90 d	4 h	60 d	2 h	30 d
HEMPATHANE	9 h	14 d	4 h	6 d	2 h	3 d

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

Note:

HEMPADUR 47140 For professional use only.

ISSUED BY:

HEMPEL A/S

4714020450

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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