

### 47510: BASE 47519: CURING AGENT 98510

<b>Description:</b>	HEMPADUR ULTRA-STRENGTH FIBRE 47510 is a self-priming, two-component, high build, pure epoxy paint reinforced with patented FIBRE technology. It is engineered to withstand the harsh conditions of cargo holds, thanks to its superior resistance to abrasion, impact, cracking and chemical attack. It can be applied at surface temperature as low as -5°C/22°F and its fast curing allows a very fast return to service after application.
<b>Recommended use:</b>	As a heavy duty coating for areas exposed to abrasion and aggressive corrosive climate such as hatch coamings and cargo holds of bulk carriers.
<b>Service temperature:</b>	Maximum, dry exposure only: 140°C/284°F
<b>Certificates/Approvals:</b>	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.
<b>Availability:</b>	Part of Group Assortment. Local availability subject to confirmation.
<b>PHYSICAL CONSTANTS:</b>	
Shade nos/Colours:	59630* / Red
Finish:	Semi-gloss
Volume solids, %:	76 ± 1
Theoretical spreading rate:	6.1 m <sup>2</sup> /l [244.6 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	25 °C [77 °F]
Specific gravity:	1.5 kg/litre [12.9 lbs/US gallon]
Surface-dry:	2.5 hour(s) 20°C/68°F
Through-dry:	6.5 hour(s) 20°C/68°F
Fully cured:	3 day(s) 20°C/68°F
VOC content:	233 g/l [1.9 lbs/US gallon]
Shelf life:	1 year for BASE and 2 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>
<b>APPLICATION DETAILS:</b>	
<b>Version, mixed product:</b>	<b>47510</b>
Mixing ratio:	BASE 47519: CURING AGENT 98510 3:1 by volume
Application method:	Airless spray
Thinner (max.vol.):	08450 (5%)
Pot life:	1 hour(s) 20°C/68°F
Nozzle orifice:	0.023 - 0.027 "
Nozzle pressure:	250 bar [3625 psi]
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
<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:	<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 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). After blasting, clean the surface carefully from abrasives and dust.</p> <p><b>Repair and maintenance:</b> Remove oil and grease etc. thoroughly with suitable detergent. Remove salts 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). As an alternative to dry cleaning, wet abrasive blasting or water jetting may be used. Min Wa 2½ (ISO 8501-4:2006). Acceptable flash-rust degree before application: L (ISO 8501-4:2006). Feather edges to sound and intact areas. 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 hosing, drying, and finally dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above: - 5°/23°F. The optimal paint temperature for proper mixing, pumping and spraying is 20°C/68°F. 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. To achieve full mechanical properties the coating requires a curing time according to Application Instructions, section "Time to first cargo". Consult HEMPEL for specific advice if in doubt.
PRECEDING COAT:	None, or as per specification. When diluted to 25-30%, the product can be used as blast primer preceding a full coat application of the product.
SUBSEQUENT COAT:	None.
REMARKS:	
Colours/Colour stability:	Has a tendency to yellow after application. This will have no influence on the performance.
Weathering/service temperatures:	The natural tendency of epoxy coatings to chalk in outdoor exposure is also reflected in this product.
Application equipment:	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.
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: 125-150 micron/5-6 mils.
Curing agent:	The CURING AGENT will become darker during storage. This will have no influence on the performance.
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					
Surface temperature:	0°C (32°F)		10°C (50°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	18 h	30 d	8 h	30 d	4 h	14 d

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

Overcoating note:	Overcoating intervals related to later conditions of exposure: If the maximum over coating 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.
Note:	<b>HEMPADUR ULTRA-STRENGTH FIBRE 47510 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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