

47604: BASE 47606: CURING AGENT 97334

Description:	HEMPADUR QUATTRO FIBRE 47604 is a two-component universal epoxy paint with synthetic mineral fibres, which cures to a hard, tough and abrasion resistant coating with superior anticorrosive properties, good resistance to seawater and various oils and significantly improved crack resistance.
Recommended use:	As a universal epoxy and self primed superior performance coating system for atmospheric or in-water service. HEMPADUR QUATTRO FIBRE 47604 is intended for all year application down to -10°C/ 15°F and for in-shop applications where fast recoating and handling is required. Can reduce cracking and break down in high stress areas characterised by harsh in-service conditions such as mechanical flexing/impacts and cycling of wet/dry conditions and high/low service temperatures. For in-water service, the reddish aluminium shade (19530) can advantageously be used as first coat.
Features:	Improved crack resistance. Superior anticorrosive and mechanical properties. Short drying time. Curing down to -10°C/14°F.
Service temperature:	Maximum, dry exposure only: 120°C/248°F Ballast water service. Resists normal ambient temperatures at sea (Avoid long-term exposure to negative temperature gradients). Other water service: 40°C/104°F (no temperature gradient) Other liquids: Contact HEMPEL
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:	11480* / Grey. (see REMARKS overleaf)
Finish:	Semi-flat
Volume solids, %:	72 ± 2 (see REMARKS overleaf)
Theoretical spreading rate:	6 m ² /l [240.6 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	27 °C [80.6 °F]
Specific gravity:	1.4 kg/litre [11.5 lbs/US gallon]
Surface-dry:	2 hour(s) 20°C/68°F
Through-dry:	4.5 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F 20 days , 5°C/41°F.
VOC content:	272 g/l [2.3 lbs/US gallon]
Shelf life:	3 year for BASE and 1 year (25°C/77°F) for CURING AGENT from time of production. <i>*other shades according to assortment list. see REMARKS overleaf</i>
<i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>	
APPLICATION DETAILS:	
Version, mixed product:	47604
Mixing ratio:	BASE 47606: CURING AGENT 97334 4:1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (5%)
Pot life (Airless spray):	2 hour(s) 20°C/68°F
Pot life (Brush):	2 hour(s) 20°C/68°F
Induction time:	- see REMARKS overleaf
Nozzle orifice:	0.021 - 0.025 "
Nozzle pressure:	250 bar [3625 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] (approx.)
Overcoat interval, min:	According to separate APPLICATION INSTRUCTIONS
Overcoat interval, max:	According to separate APPLICATION INSTRUCTIONS
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:	<p>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). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating. For temporary protection, if required, use a suitable shopprimer. For repair and touch-up use: HEMPADUR QUATTRO FIBRE 47604.</p> <p>Repair and maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to minimum St 2 (ISO 8501-1:2007) (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007). Improved surface preparation will improve the performance. As an alternative to dry cleaning, water jetting to min. Wa 2½ (ISO 8501-4:2006)(or according to specification), may be used. A flash-rust degree of maximum M (ISO 8501-4:2006) is acceptable before application. Feather edges to sound and intact paint. Dust off residues.</p> <p>On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting, wet abrasive blasting, 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: -10°C/14°F. 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.
SUBSEQUENT COAT:	According to specification.
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 and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.
Induction time:	To facilitate proper application properties it is recommended to allow the thoroughly mixed BASE and CURING AGENT to prereact before application. In case two-component spray-equipment is used consult separate APPLICATION INSTRUCTIONS.
Application(s):	Surge tank filter and tip filter should be removed
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: 100-200 micron/4-8 mils
Shades:	This product is available in several aluminium pigmented shades with different volume solids content.
Note:	HEMPADUR QUATTRO FIBRE 47604 For professional use only.
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. 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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