

87591: BASE 87598: CURING AGENT 89600

Description:	HEMPADUR TL97/RAL 87591 is a two-component, fast-curing, polyurethane-acrylic topcoat. It is resistant to atmospheric and mechanical influences while offering outstanding gloss, weathering and colour shade stability.
Recommended use:	As a high-grade topcoat for steel, bridge, tank and plant construction. Material No.697.75 - 697.99 in accordance with TL/TP-KOR-Stahlbauten, Blatt 97 (Technical delivery and test specifications for the corrosion protection of steel structures).
Service temperature:	Maximum, dry exposure only: 150°C/302°F
Certificates/Approvals:	Approved by the German Federal Highway Research Institute (BAST), TL/TP-KOR-Stahlbauten, Blatt 97.
Availability:	Not included in Group Assortment. Availability subject to special agreement.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	37240*/ Sky blue (RAL 5015)
Finish:	Silk gloss
Volume solids, %:	60 ± 1
Theoretical spreading rate:	7.5 m ² /l [300.8 sq.ft./US gallon] - 80 micron/3.2 mils
Flash point:	39 °C [102.2 °F]
Specific gravity:	1.4 kg/litre [11.4 lbs/US gallon]
Surface-dry:	1 hour(s) , 23°C/73°F (50% RH)
Dry to handle:	6 hour(s) , 23°C/73°F (50% RH)
Fully cured:	7 day(s) 20°C/68°F
VOC content:	357 g/l [3 lbs/US gallon]
Shelf life:	Keep cold, dry and free of frost. Minimum 12 months in closed can. <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:	87591
Mixing ratio:	BASE 87598: CURING AGENT 89600 7:1 by volume 9:1 by weight
Application method:	Airless spray / Brush
Thinner (max.vol.):	08080 (5%) / 08080 (5%)
Pot life:	2 hour(s) 20°C/68°F
Nozzle orifice:	0.009 - 0.019 "
Nozzle pressure:	120 - 200 bar [1740 - 2900 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S THINNER 08080
Indicated film thickness, dry:	80 micron [3.2 mils]
Indicated film thickness, wet:	150 micron [6 mils]
Overcoat interval, min:	According to specification or application instruction Blatt 97.
Overcoat interval, max:	According to specification or application instruction Blatt 97.
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:	The primed substrate must be free from oil, dust, grease and loose parts. (DIN EN ISO 12944, Part 4).
APPLICATION CONDITIONS:	Maximum relative humidity: 85%. At temperatures ranging: 3-40°C/37-104°F, minimum 3°C/6°F above dew point. Minimum surface temperature: 3°C/37°F during application and initial curing. At the freezing point and below be aware of the risk of ice on the surface, which will hinder adhesion. The best result is obtained at: 17-23°C/63-73°F
PRECEDING COAT:	According to specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Application(s):	Clean the surface carefully before overcoating. Roughening of the surface may be necessary under special circumstances to ensure sufficient intercoat adhesion. An absolutely clean surface is required for good intercoat adhesion, particularly in the case of long overcoat intervals. Any dirt, oil and grease has to be removed with suitable cleaning agents, followed by high pressure cleaning with fresh water at 120-160 bar/1700-2300 psi. Remove any salts by washing with fresh water. Any degraded surface layer, as a result of a long exposure period, must be removed as well. Water jetting may be relevant to remove any degraded surface layer and may also replace the above mentioned cleaning methods when properly executed. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant. We recommend application by spraying to achieve the best possible optical finish. In the case of light, brilliant colour, several coats may need to be applied to reliably cover dark surfaces.
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: 50-80 micron/2.0-3.2 mils
Curing agent:	CURING AGENT 89600: is sensitive to moisture. Open curing agent cans with caution as overpressure might exist. Store in a dry place and keep the can tightly closed until use.
Note:	HEMPATHANE TL97/RAL 87591 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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