



HEMPADUR 47080

47080: BASE 47089: CURING AGENT 95070

Description:	HEMPADUR 47080 is a high-build, modified, two-component epoxy paint, which cures to a coating with good resistance to water, splashes of mineral oils, aliphatic hydrocarbons, and to abrasion and impact. Limited resistance to aromatic and stronger solvents and to acids and oxidizing materials.
Recommended use:	As an intermediate coat with prolonged recoating interval in HEMPADUR / HEMPETHANE systems.
Service temperature:	Maximum, dry exposure only: 120°C/248°F see REMARKS overleaf.
Certificates/Approvals:	Complies with EU Directive 2004/42/EC: subcategory j. see REMARKS overleaf.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	22090*/ Cream
Finish:	Flat
Volume solids, %:	71 ± 1
Theoretical spreading rate:	5.7 m ² /l [228.6 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	28 °C [82.4 °F]
Specific gravity:	1.4 kg/litre [12.1 lbs/US gallon]
Surface dry:	4 approx. hour(s) 20°C/68°F
Dry to touch:	5 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	250 g/l [2.1 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:

Version; mixed product:	47080
Mixing ratio:	BASE 47089: CURING AGENT 95070 7:1 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):	3 hour(s) 20°C/68°F
Nozzle orifice:	0.019 - 0.023 "
Nozzle pressure:	250 bar [3625 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610 or THINNER 08450
Indicated film thickness, dry:	125 micron [5 mils] see REMARKS overleaf.
Indicated film thickness, wet:	175 micron [7 mils]
Recoat interval, min:	According to specification.
Recoat interval, max:	According to specification.

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.



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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 8501-1:1988) 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 the paint itself should be above: 15°C/59°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.

PRECEDING COAT

According to specification. Recommended systems are: HEMPADUR

SUBSEQUENT COAT:

According to specification. Recommended systems are: HEMPATHANE

REMARKS:

VOC - EU Directive 2004/42/EC:

Product		5 vol. % thinning	Limit phase II, 2010
4708022090	250 g/l	280 g/l	500 g/l

For VOC of other shades, please refer to Safety Data Sheet.

Colours/Colour stability:

The coating will be prone to colour change to a yellowish or darker colour upon exposure to UV light. The nature and extend of the colour change will depend on the exposure time and conditions such as humidity and temperature. This will be especially visible for the lighter colours. 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.

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 recoating interval. Normal range dry is: 75-150 micron/3-6 mils

Recoating note:

Before recoating, clean the surface thoroughly of all contamination. Especially at long intervals before recoating very careful cleaning is required.

To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.

*If there is any doubt about the adequacy of the surface preparation, a thin, fresh coat of the product is applied to secure adhesion of the following coat.

Recoating intervals:

Recoating intervals related to later conditions of exposure: 125 micron/5 mils dry film thickness

Nota:

HEMPADUR 47080 For professional use only.

ISSUED BY:

HEMPEL A/S

4708022090

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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