

4774D: BASE 4774M: CURING AGENT 9874D

Description:	HEMPADUR 4774D is a self-priming, two-component, high-build, pure epoxy paint, polyamide/amine cured. Abrasion and corrosion resistant.
Recommended use:	As a high build primer, intermediate and/or self-primed finish for high performance, heavy-duty coating systems.
Features:	-Heavy duty, abrasion resistant coating. -Overcoatable by a wide range of epoxy- and polyurethane coatings. -Low VOC. -Applicable by standard heavy duty airless spray equipment in a wide range of film thicknesses.
Availability:	Not included in Group Assortment. Availability subject to special agreement.

PHYSICAL CONSTANTS:

Shade nos/Colours:	20450* / Cream
Finish:	Semi-gloss
Volume solids, %:	76 ± 2
Theoretical spreading rate:	5.1 m ² /l [204.5 sq.ft./US gallon] - 150 micron/6 mils
Flash point:	34 °C [93.2 °F]
Specific gravity:	1.5 kg/litre [12.1 lbs/US gallon]
Surface-dry:	2 hour(s) 20°C/68°F
Through-dry:	3 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	229 g/l [1.9 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>

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.

APPLICATION DETAILS:

Version, mixed product:	4774D
Mixing ratio:	BASE 4774M: CURING AGENT 9874D 4 :1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%)
Pot life:	Pot life depends on size of packing and temperature. For large packings and a temperature at 40°C/104°F, pot life will be reduced to approximately 15 minutes.
Pot life (Airless spray):	45 minute(s) 20°C/68°F
Pot life (Brush):	45 minute(s) 20°C/68°F
Nozzle orifice:	see REMARKS overleaf
Nozzle pressure:	see REMARKS overleaf
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	150 micron [6 mils]
Indicated film thickness, wet:	200 micron [8 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.
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SURFACE PREPARATION: **New steel:** Abrasive blasting to min. Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. Welds, rusty spots, etc. to be abrasive spot-blasted.

Stainless steel: To be abrasive blasted to a uniform, sharp, dense profile, ISO Comparator Medium (G), corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.

Repair: 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). Improved surface preparation will improve the performance of the product.

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures between: 5°C/41°F - 60°C/140°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. Maximum relative humidity: 85%.

PRECEDING COAT: None, or as per specification.

SUBSEQUENT COAT: None, or as per specification. Recommended systems are: HEMPADUR, HEMPETHANE.

REMARKS:

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. Light colours will have a tendency to yellow.

Application(s): Can be used on top of Zinc silicate or on metallised area by use of the flash coat technique.

Application equipment: Spray equipment: It is recommended to use heavy-duty airless spray equipment with a pump transmission rate of 60:1 (approximately), and a theoretical output of min. 12 litres per minute. Longer spray hoses and/or bigger spray nozzles will require higher capacity of the spray equipment to maintain a proper spray fan atomisation. Optimum result with undiluted paint material is obtained with an output pressure of 250 bar/3600 psi and nozzle orifices of 0.021"-0.023". Bigger nozzle-sizes are possible, but depends on the skill of the painter, sufficient output pressure and material-flow. Furthermore up to 5% thinner may be needed.

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: 100-250 micron/4-8 mils.

Undiluted, absolute minimum for closed film formation is 100 micron dry film thickness. For the upper end the paint material has sufficient safety in its "application window" to allow for a 250 micron specification provided a skilled application work.

Curing agent: The CURING AGENT will become darker during storage. This will have no influence on the performance. It may influence the shade of the mixed product.

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, severe					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	4 h	60 d	2 h	30 d	1.5 h	22.5 d
HEMPATHANE	4 h	14 d	2 h	7 d	1.5 h	5 d

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

Note: **HEMPADUR 4774D For professional use only.**

ISSUED BY: HEMPEL A/S 4774D20450

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.
The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.