

47960: BASE 47969: CURING AGENT 98140

Description:	HEMPADUR 47960 is a two-component polyamide adducts cured, high build epoxy paint which combines a relatively high volume solids content with a short drying time. VOC compliant. Prolonged recoating properties. Pigmented with zinc phosphate.
Recommended use:	As a primer in mild to medium atmospheric environments. As an intermediate or finishing coat in epoxy systems in medium to severely corrosive atmospheric environment. As a one coat self priming epoxy topcoat available in various shades. May be used directly on cured zinc silicate (GALVOSIL products) or spray-metallised surfaces to minimise popping.
Service temperature:	Maximum, dry exposure only: 140°C/284°F
Certificates/Approvals:	
Availability:	Not included in Group Assortment. Availability subject to special agreement.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	11480* / Grey.
Finish:	Semi-gloss
Volume solids, %:	75 ± 1
Theoretical spreading rate:	6 m ² /l [240.6 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	24 °C [75.2 °F]
Specific gravity:	1 kg/litre [8.3 lbs/US gallon]
Surface-dry:	1 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:	245 g/l [2 lbs/US gallon] <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:	47960
Mixing ratio:	BASE 47969: CURING AGENT 98140 5 : 1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	depending on purpose. Usually less than: 5% HEMPEL'S THINNER 08450 (see REMARKS overleaf)
Pot life:	1 hour(s) 20°C/68°F
Nozzle orifice:	0.019 - 0.021 "
Nozzle pressure:	225 bar [3262.5 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]
Overcoat interval, min:	According to specification.
Overcoat 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.

SURFACE PREPARATION: **New steel:** Abrasive blasting to 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. For repair and touch-up use: HEMPADUR 47960.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 0°C/32°F. The temperature of the paint itself should be: 15-25°C/59-77°F to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. It is important that the surface is completely clean to ensure the adhesion. Any oil, grease, etc. to be removed by suitable detergent.

PRECEDING COAT: According to specification. Recommended systems are: Spray metallisation, HEMPADUR ZINC 17360, HEMPEL'S GALVOSIL 15700, HEMPEL'S GALVOSIL 15780.

SUBSEQUENT COAT: None, or as per specification. Recommended systems are: HEMPATHANE, HEMPAXANE.

REMARKS:

VOC - EU Directive 2004/42/EC:

Product	As supplied	5 vol. % thinning	Limit phase II, 2010
4796011480	245 g/l	275 g/l	500 g/l

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

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. Discolouration may occur. This will not influence the anticorrosive properties of the paint. The product should be overcoated with a more durable cosmetic topcoat if better gloss and colour retention is needed.

Application(s): Irregular surfaces: Special care should be taken in relation to irregular surfaces (welding seams, undercuts, corners etc.) as application with an excessive film thickness may result in cracking. Excessive film thickness is typically 2-3 times higher than the maximum recommended film thickness. Application onto zinc metallized and zinc silicate primed surfaces: It is recommended to apply the paint by using a "mist-coat" procedure. A thin, undiluted coat is applied (the mist coat) and after a few minutes, a second coat is applied in the full specified film thickness. Depending on actual conditions of application, such as temperature, porosity of substrate, method of spray, a sealer coat (thinned up to 30%) can be applied as an alternative method to reduce popping, followed by application of the full coat.

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: 80-125 micron/3.2-5 mils. Selection of proper thinner is related to application conditions. Normally recommended thinner: HEMPEL'S THINNER 08450. HEMPEL'S THINNER 08700 may be used alternatively depending on local conditions.

Overcoating intervals: A completely clean surface is mandatory to ensure intercoat adhesion, especially at long overcoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed by fresh water hosing. **Any degraded surface layer, as a result of a long exposure period, must be removed.** Water jetting may be relevant to remove any degraded surface layer and may also replace the above mentioned cleaning methods when properly executed. Consult HEMPEL for specific advice if in doubt. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant. However, this test patch should not be a final proof of the durability of the coating systems.

Note: **HEMPADUR 47960 For professional use only.**

ISSUED BY:

HEMPEL A/S

4796011480

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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