



Product Data

HEMPADUR® 45080/ HEMPADUR® 45083

Medium to high temperatures 45080: BASE 45089 with CURING AGENT 95010
Low to medium temperatures 45083: BASE 45089 with CURING AGENT 97480

Description: HEMPADUR 45080/45083 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 no maximum recoating interval in HEMPADUR/HEMPATHANE systems.
CURING AGENT 95010, polyamide, is typically for use above 10°C/50°F, CURING AGENT 97480, polyamide adduct, facilitates curing down to -10°C/14°F.

Service temperatures: 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:

	45080	45083
Version; mixed product:	Off-white/11630	Off-white/11630
Colours/Shade nos:	Flat	Flat
Finish:	48 ± 1	45 ± 1
Volume solids, %:	6.4 m ² /litre - 75 micron	6.0 m ² /litre - 75 micron
Theoretical spreading rate:	257 sq.ft./US gallon - 3 mils	241 sq.ft./US gallon - 3 mils
Flash point:	30°C/86°F	30°C/86°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon	1.4 kg/litre - 11.7 lbs/US gallon
Surface dry:	1½ (app) hours at 20°C/68°F (ISO 1517)	3 (app) hours at 10°C/50°F (ISO 1517)
Dry to touch:	4 (app) hours at 20°C/68°F	6 (app) hours at 10°C/50°F
Fully cured:	7 days at 20°C/68°F	14 days at 10°C/50°F
V.O.C.:	500 g/litre - 4.2 lbs/US gallon	5205 g/litre - 4.3 lbs/US gallon

*Other shades according to assortment list.

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

APPLICATION DETAILS:

	45080	45083
Mixing ratio:	Base 45089 : Curing agent 95010 8.4 : 1.6 by volume	Base 45089 : Curing agent 97480 8.4 : 1.6 by volume
Application method:	Airless spray Brush	Airless spray Brush
Thinner (max.vol.):	08450 (5%) 08450 (5%)	08450 (5%) 08450 (5%)
Pot life:	6 hours (20°C/68°F) 8 hours (20°C/68°F)	4 hours (10°C/50°F) (Airless) 8 hours (10°C/50°F) (Brush)
Nozzle orifice:	.015"-.021"	
Nozzle pressure:	150 bar/2100 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:	75 micron/3 mils (See REMARKS overleaf)	
Indicated film thickness, wet:	150 micron/6 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



HEMPADUR 45080/45083

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 10°C/50°F when using CURING AGENT 95010, and above -10°C/14°F when using CURING AGENT 97480. The temperature of the paint itself should be minimum 15°C/59°F.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: HEMPADUR primers/intermediate coats or according to specification.

SUBSEQUENT COAT: HEMPADUR topcoats according to specification.

REMARKS:
VOC - EU directive 2004/42/EC:

45080				
	As supplied	5 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	500	515	550	500
45083				
	As supplied	5 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	520	535	550	500

VOC: 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.

Film thicknesses: 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 50-125 micron/2-5 mils.

Recoating: **Before recoating, clean the surface thoroughly of all contamination. Especially at long intervals before recoating very careful cleaning is required.**
To check adequate quality of the preparatory cleaning a test patch is recommended before actual recoating.
Recoating intervals related to later conditions of exposure:
(75 micron/3 mils dry film thickness of HEMPADUR 45080/45083)

	Curing agent 95010				Curing agent 97480			
	Minimum		Maximum		Minimum		Maximum	
Surface temperature	20°C/68°F				10°C/50°F			
Recoated with	Atmospheric				Atmospheric			
	Medium	Severe	Medium	Severe	Medium	Severe	Medium	Severe
HEMPADUR topcoats	4 hours	8 hours	None*	None*	6 hours	12 hours	None*	None*

*If there is any doubt about the adequacy of the surface preparation, a thin, fresh coat of HEMPADUR 45080/45083 is applied to secure adhesion of the following coat.

Note: HEMPADUR 45080/45083 is for professional use only.

ISSUED BY: HEMPEL A/S - 4508011630C0004/4508311630C0002

This Product Data Sheet supersedes those previously issued.
For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.
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