



Product Data

HEMPADUR® 45182

CURING AGENT 98180

Description: HEMPADUR 45182 is a two-component, low-temperature curing, modified polyamide adduct cured epoxy.

Recommended use: For marine and protective use as a "tie coat" ("tack coat") between epoxy and physically drying coatings. For marine use also as a "sealer" of old antifouling.

Service temperatures: Maximum, dry exposure only: 80°C/176°F

Availability: Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos.: Yellowish grey/25150
Finish: Flat
Volume solids, %: 46 ± 1
Theoretical spreading rate: 4.6 m²/litre - 100 micron
184 sq.ft./US gallon - 4 mils
Flash point: 23°C/73°F
Specific gravity: 1.3 kg/litre - 10.8 lbs/US gallon
Dry to touch: 6 (approx.) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 490 g/litre - 4.1 lbs/US gallon

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:

Mixing ratio for 45182: Base 45187 : Curing agent 98180
4 : 1 by volume
Application method: Airless spray Brush (touch up)
Thinner (max.vol.): 08450 (5%) 08450 (5%)
Pot life: 3 hours (20°C/68°F)
Nozzle orifice: .023"
Nozzle pressure: 200 bar/2900 psi
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry: 100 micron/4 mils *(see REMARKS overleaf)*
Indicated film thickness, wet: 225 micron/9 mils
Recoat interval, min: 6 hours (20°C/68°F)
Recoat interval, max: Antifoulings: 5 days (20°C/68°F)
Other topcoats, for areas above water: according to separate painting specification.

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.



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SURFACE PREPARATION:	<p>New steel: Abrasive blasting to Sa 2½. For temporary protection if required use suitable shopprimer. Any damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For priming purposes, specified HEMPADUR paint.</p> <p>Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning.</p> <p>When used as “tie coat”: remove all rust and other loose material by abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness with specified HEMPADUR paint (see REMARKS below).</p> <p>When used as “sealer” on old antifouling: a very careful high pressure freshwater cleaning -or jetting, if needed - to remove possible leached layer of antifouling and make sure that old layers of weak intercoat adhesion (“sandwich structure”) really are removed.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures higher than -10°C/14°F. The temperature of the surface and that of the paint itself must also be above this limit. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces such as sea chest or stagnant air under large flat bottoms provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	<p>HEMPADUR systems according to specification. In case of an old antifouling system this must be well cleaned and in good condition.</p>
SUBSEQUENT COAT:	<p>Antifouling or other physically drying solvent based paints according to specification.</p>
REMARKS:	
Film thicknesses:	<p>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 75-125 micron/3-5 mils.</p> <p>As “sealer” typically to be specified in 50 -75 micron/2-3 mils dry film thickness. Thinning may be required to facilitate proper film formation.</p>
Film thicknesses, subsequent coats:	<p>HEMPADUR 45182 is designed for recoating with antifouling in any normal specified total film thicknesses. HEMPADUR 45182 is not designed for recoating with heavy duty epoxy systems. Later maintenance of paint systems with HEMPADUR 45182 as a part of the system is accordingly most conveniently carried out by touch-up with a “mastic” type epoxy and with a proper overlap of intact surrounding paint system.</p>
Recoating:	<p>A completely clean surface is mandatory to ensure intercoat adhesion, especially in the case of long recoating intervals. Any dirt, oil and grease have to be removed with eg 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 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. A thin extra coat of HEMPADUR 45182 may advantageously be applied if there is any doubt about suitability of cleaning process.</p>
Note:	<p>HEMPADUR 45182 is for professional use only.</p>
ISSUED BY:	<p>HEMPEL A/S - 4518225150CR001</p>

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see “Explanatory Notes” in the HEMPEL Book.

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