Product Data
HEMPADUR EASY 47700

47700: BASE 47709: CURING AGENT 97702

Description:	HEMPADUR EASY 47700 is a two-component high build pure epoxy paint which cures to a hard and tough coating with good resistance to abrasion and sea water.
Recommended use:	As a self-primed heavy duty coating or intermediate coat for immersed and non-immersed areas exposed to abrasion and corrosive climate such as cargo holds, ship hulls, working decks or steel structures where low VOC, fast drying and high film build are required. HEMPADUR EASY 47700 is intended for all year application down to -10°C/14°F and for applications where fast recoating and handling is required.
Features:	Excellent anticorrosive and very good mechanical properties. Short drying time. Curing down to -10°C/14°F.
Service temperature:	Dry exposure only: Maximum: 120°C/248°F.
Certificates/Approvals:	Complies with Section 175.300 of the Code of Federal Regulations Title 21 – Dry Foodstuff. Consult Hempel for details. Tested for non-contamination of grain cargo at the Newcastle Occupational Health & Hygiene, Great Britain. Approved as a low flame spread material when used as part of a predefined paint system. Please refer to “Declaration of Conformity” on www.Hempel.com for further details.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	50630*/ Red (see REMARKS overleaf)
Finish:	Flat
Volume solids, %:	77 ± 1
Theoretical spreading rate:	6.2 m^2/l [248.6 sq.ft./US gallon] - 125 micron/5 mils
Flash point:	25 °C [77 °F]
Specific gravity:	1.5 kg/litre [12.3 lbs/US gallon]
Surface-dry:	1 hour(s) 20°C/68°F
Through-dry:	3 hour(s) 20°C/68°F
Fully cured:	5 day(s) , 20°C/68°F 15 day(s), 5°C/41°F
VOC content:	236 g/l [2 lbs/US gallon]
Shelf life:	3 years for BASE and 1 year (25°C/77°F) for CURING AGENT from time of production.

**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:	**47700**
Mixing ratio:	BASE 47709: CURING AGENT 97702 4 : 1
Application method:	Airless spray / Brush / Roller
Thinner (max.vol.):	08450 (5%) / 08450 (5%) / 08450 (5%)
Pot life (Airless spray):	1 hour(s) , 20°C/68°F
Pot life (Brush):	1.5 hour(s) , 20°C/68°F
Nozzle orifice:	0.017 - 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, HEMPEL'S THINNER 08450
Indicated film thickness, dry:	125 micron [5 mils]
Indicated film thickness, wet:	175 micron [7 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.

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: 2007) 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). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating. For repair and touch-up use: HEMPADUR QUATTRO 17634.
Ballast tanks and cargo oil tanks: See separate APPLICATION INSTRUCTIONS
Steel, maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of the paint. As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be Wa 2 - Wa 2½ (atmospheric exposure) / minimum Wa 2½ (immersion) (ISO 8501-4:2006). A flash-rust degree of maximum M (atmospheric exposure), preferably L (immersion) (ISO 8501-4:2006) is acceptable before application. Feather edges to sound and intact paint. Dust off residues. Touch up to full film thickness. On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting or wet abrasive blasting, alternatively dry abrasive blasting followed by high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.
Other substrates: contact Hempel.

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above: -10°C/14°F. Apply only on a dry and clean surface with a temperature min. 3°C/5°F above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

None, or as per specification.

SUBSEQUENT COAT:

None, or as per specification.

REMARKS:

Colours/Colour stability:

Has a tendency to yellow after application. 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 overcoating interval. Normal range dry is: 125 - 200 micron / 5 - 8 mils. May be specified in lower film thickness for which purpose additional thinning is required, please see separate APPLICATION INSTRUCTIONS. **Avoid application of excessive film thicknesses.**

Shades:

This product is available in several aluminium pigmented shades with different volume solids content.

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, medium					
Surface temperature:	-10°C (14°F)		0°C (32°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	18 h	90 d	8 h	56 d	2 h	14 d
HEMPATEX	18 h	72 h	8 h	32 h	2 h	8 h
HEMPATHANE	18 h	90 d	8 h	40 d	2 h	10 d
Environment	Immersion					
HEMPADUR	27 h	90 d	12 h	56 d	3 h	14 d

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

Note:

HEMPADUR EASY 47700 For professional use only.

ISSUED BY:

HEMPEL A/S

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