



# Product Data

## HEMPADUR 47200

BASE 47209 with CURING AGENT 97100

<b>Description:</b>	HEMPADUR 47200 is a two-component, polyamine adduct cured epoxy paint with a very short drying time. Contains micaceous iron oxide and zinc phosphate. The product cures at temperatures above -10°C/32°F and form a tough and hardwearing coating.
<b>Recommended use:</b>	As a fast drying primer or intermediate coat in HEMPADUR systems especially suited for fast recoatable shop applications. Can be specified for on-site application. <i>The product can also be specified where long overcoating intervals to polyurethane topcoats are expected (typically as travel coat).</i>
<b>Service temperatures:</b>	Maximum, dry exposure only: 120°C/248°F.
<b>Certificates/Approvals:</b>	Complies with EU Directive 2004/42/EC, subcategory j (see REMARKS overleaf).
<b>Availability:</b>	Part of Group Assortment. Local availability subject to confirmation.

### PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/13610 - Red/50630
Finish:	Flat
Volume solids, %:	63 ± 1
Theoretical spreading rate:	6.3 m <sup>2</sup> /litre - 100 micron 253 sq.ft./US gallon - 4 mils
Flash point:	30°C/86°F
Specific gravity:	1.6 kg/litre - 11.6 lbs/US gallon
Surface dry:	15 minutes at 20°C/68°F (ISO 1517)
Dry to touch:	1 hour at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	355 g/litre - 3.0 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 47200:	Base 47209 : Curing agent 97100 4 : 1 by volume
Application method:	Airless spray      Air Spray      Brush
Thinner (max. vol.):	08450 (5%)      08450 (15%)      08450 (5%)
Pot life:	3 hours (20°C/68°F)
Nozzle orifice:	.015"-.021"
Nozzle pressure:	150 bar/2200 psi <i>(Airless spray data are indicative and subject to adjustment)</i>
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610/HEMPEL THINNER 08450
Indicated film thickness, dry:	100 micron/4 mils (See REMARKS overleaf)
Indicated film thickness, wet:	175 micron/7 mils
Recoat interval, min:	1 hour (20°C/68°C)
Recoat interval, max:	See REMARKS overleaf

<b>Safety:</b>	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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## HEMPADUR 47200

SURFACE  
PREPARATION:

**New steel (dry conditions):** Abrasive blasting to minimum Sa 2½ according to ISO 8501-1:2007. For temporary protection, if required, use 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 47200.

**Maintenance:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by wet or dry abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. After wet abrasive blasting hose down the surface with fresh water and allow to dry. Touch up bare spots to full film thickness.

APPLICATION  
CONDITIONS:

Use only where application and curing can proceed at temperatures above -10°C/32°F. At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion. The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties.

In order to obtain the best possible spray properties, mix the components thoroughly and allow the mixture to pre-react for 10 - 15 minutes before use (Induction time).

In confined spaces provide adequate ventilation during application and drying.

PRECEDING  
COAT:

None, or according to specification.

SUBSEQUENT  
COAT:

HEMPADUR, HEMPATANE, or as per specification.

REMARKS:

VOC - EU directive  
2004/42/EC:

	As supplied	15 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	355	425	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 is 75-200 micron/3-8 mils.

Recoating:

Recoating intervals related to later conditions of exposure (100 micron/4 mils dry):

	Maximum Independent of filmthickness	
Surface temperature	20°C/68°F	
Exposure during service	Atmospheric	
Recoated with	Medium	Severe
HEMPADUR	None	None
HEMPATHANE	None	5 days

If the maximum recoating interval is exceeded, whatever the subsequent coat, roughening of the surface is necessary to ensure optimum intercoat adhesion or in the case of recoating with coatings other than HEMPADUR, apply a (thin) additional coat of HEMPADUR 47200 within the above directions for recoating.

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. 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.

Note:

**HEMPADUR 47200 is for professional use only.**

ISSUED BY:

HEMPEL A/S - 4720013610CRO01

*This Product Data Sheet supersedes those previously issued.*

*For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.*

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*Product data are subject to change without notice and become void five years from the date of issue.*