

45550: BASE 45559 with CURING AGENT 95360

For product description refer to product data sheet <Text> / <Text>

- Scope:** These Application Instructions cover surface preparation, application equipment and application details for HEMPADUR 45550.
- Surface preparation:** Iron and steel: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½, SSPC-SP10. Small areas may be mechanically grinded to leave a metallic clean and rough surface.
- Aluminium:**
Remove oil and grease etc. with suitable detergent for aluminium surfaces, followed by (high pressure) fresh water cleaning.
Abrasive sweeping with non-metallic abrasive to produce a uniformly roughened surface.
- Plywood:**
Sand the surface carefully and remove dust. Saturate the surface, especially the edges, with HEMPADUR SEALER 05990 - remove surplus to avoid a glossy layer of sealer after drying.
- Ferro-cement:**
Abrasive blast or high pressure water jet the surface to obtain a rough and firm surface free of scum layer and contamination. Remove dust and loose material. If mechanical treatment is impossible the surface may be acid etched. For this purpose an approximately 5% w/w nitric or phosphoric acid solution is recommended.
- Note:** Strong acids, avoid skin contact! The concrete should be saturated with fresh water prior to etching to prevent corrosion of the steel reinforcement. Leave the acid to react 3-4 minutes and hose down the surface with fresh water - preferably with a 5% w/w sodium hydroxide solution - and scrub carefully. Hose down with fresh water. After that the surface must dry homogeneously and appear as an even, rough surface free of a loose outer layer. The surface must have a pH reaction of between 6.5 and 8.0. If any of these conditions are not fulfilled, the process must be repeated. The surface must be dried with good ventilation for at least 2 days (65% relative humidity (20°C/68°F)). The pretreatment is controlled by scraping with a strong knife. The surface shall feel solid and hard, and the knife must only leave a clear scratch mark.
- Saturate the surface with HEMPADUR SEALER 05990 - remove surplus to avoid a glossy layer of sealer after drying.
- Full stopping of the surface with suitable epoxy filler.
- Glass fibre reinforced polyester:**
Degrease the surface with suitable degreaser.
Grind the surface with sandpaper no. 180, remove dust.
- Repair and maintenance:**
Remove oil and grease with suitable detergent, salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by abrasive blasting, power tool cleaning, or other suitable cleaning method dictated by the substrate. Feather edges to sound and intact areas. Brush off loose material. HEMPADUR 45550 should not be applied on paints of another generic type.
- Application method:** The paint may be applied by airless spray, brush, paint pad or roller. The indicated dry film thickness of 100 micron is only obtainable by airless spray.
- For brush application approximately 5% thinning is recommended for good brushability.
Tools should be cleaned immediately after use with HEMPEL'S THINNER 08450 or HEMPEL'S TOOL CLEANER 99610.
- Overcoating/overcoating intervals:** When HEMPADUR 45550 is applied in 100 micron dry film thickness, typical for airless spray application, the following recoat/overcoating intervals are valid:

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Surface temperature		5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F
HEMPADUR 45550	Minimum	24 hours	16 hours	8 hours	6 hours
	Maximum	(90 days)	60 days	30 days	20 days
HEMPADUR 45182	Minimum	24 hours	16 hours	8 hours	6 hours
	Maximum	(90 days)	60 days	30 days	20 days
HEMPATHANE TOPCOAT 55210	Minimum	21 hours	14 hours	7 hours	5 hours
	Maximum	9 days	6 days	3 days	2 days
Fully cured		21 days	14 days	7 days	5 days

When HEMPADUR 45550 is applied in 60 micron/2.4 mils dry film thickness, typical for brush application, the following recoat/overcoating intervals are valid:

Surface temperature		5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F
HEMPADUR 45550	Minimum	12 hours	8 hours	4 hours	3 hours
	Maximum	(90 days)	60 days	30 days	20 days
HEMPADUR 45182	Minimum	12 hours	8 hours	4 hours	3 hours
	Maximum	(90 days)	60 days	30 days	20 days
HEMPATHANE TOPCOAT 55210	Minimum	12 hours	8 hours	4 hours	3 hours
	Maximum	9 days	6 days	3 days	2 days
Fully cured		21 days	14 days	7 days	5 days

If the maximum recoat interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

If the antifouling is to be applied at a later stage than given in the tables, then a new coat of HEMPADUR 45550 must be applied before the first coat of the antifouling to ensure intercoat adhesion.

Launching should only take place after the last coat of HEMPADUR 45550 is fully cured. The curing time is given in the above tables.

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.

Issued by:

HEMPEL A/S - 45550

These Application Instructions supersede 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. The Products are supplied and all technical assistance is given subject to Hempel's general conditions of sales, delivery and service, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said general conditions for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.