

Hempadur 45182

Product characteristics

Description

Hempadur 45182 is a low-temperature, modified polyamide adduct curing epoxy.

Recommended use

Hempadur 45182 is recommended for marine and protective use as a tie-coat between epoxy and physically drying coatings. For marine use, also as a "sealer" of old antifouling.

Service temperature:

- Maximum, dry exposure only: 80°C [176°F].

Product safety

Flash point 23°C [73°F]

VOC content mixed product

Legislation	Value
EU	481 g/L [4.01 lb/US gal]
US (coatings)	481 g/L [4.01 lb/US gal]
US (regulatory)	481 g/L [4.01 lb/US gal]
China	481 g/L [4.01 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code

45182

Product components

Base 45187
Curing agent 98180

Standard shade* / code

Light khaki brown 25150

Gloss

Flat

Volume solids

46 ± 2%

Specific gravity

1.3 kg/L [11 lb/US gal]

Reference dry film thickness

100 micron [3.9 mils]

Surface preparation

Cleanliness

- According to Hempel's Specification.

New build:

- According to Hempel's Specification.

Maintenance and Repair

- According to Hempel's Specification.

Consult Hempel's separate Surface Preparation Guidelines for more details.

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Application

Mixing ratio

Base 45187 : Curing agent 98180
(4 : 1 by volume)

Stir well before use.

Thinner

Hempel's Thinner 08450

Cleaner

Hempel's Tool Cleaner 99610

Pot life

Product temperature	0°C [32°F]	10°C [50°F]	20°C [68°F]
Pot life	11 hours	5½ hours	3 hours

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 200 bar [2900 psi] Nozzle orifice: 0.023"
Brush	5%	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	50 micron [2.0 mils]	125 micron [4.9 mils]	100 micron [3.9 mils]
Wet film thickness	110 micron [4 mils]	270 micron [11 mils]	210 micron [9 mils]
Theoretical spreading rate	9.2 m ² /L [370 sq ft/US gal]	3.7 m ² /L [150 sq ft/US gal]	4.6 m ² /L [190 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above -10°C [14°F] during application and curing.

Application remarks

- If used as a sealer on old antifouling, any possible leached layer, patina or old layers with weak intercoat adhesion must be removed prior to application.

Drying and overcoating

Product compatibility

- Previous coat: According to Hempel's Specification.
- Subsequent coat: According to Hempel's Specification.

Drying time

Surface temperature		-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
Touch dry	hours	9	4½	1	½
Hard dry	hours	20	8	4½	1½
Fully cured	days	-	-	7	-

Determined for dry film thickness 100 micron [3.9 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
Immersion					
Hempadur 45182	Min	54 h	27 h	6 h	3 h
	Max	90 d	90 d	30 d	15 d
Hempel's Antifouling Globic 9000 78900	Min	54 h	27 h	6 h	3 h
	Max	45 d	22 d	5 d	60 h

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

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Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]	35°C [95°F]
Base	36 months	24 months
Curing agent	36 months	24 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.

Additional documents

Additional information is available at the Hempel website hempel.com or at your local Hempel website:

- Explanatory Notes explaining the fields in this Product Data Sheet.
- Surface Preparation Guidelines.
- Application Guidelines for different application methods.
- General Application Guidelines

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.