

85531 : BASE 85539 : CURING AGENT 97531

Description:	HEMPADUR 85531 is an amine-adduct, cured epoxy coating. It is a hard, impact and abrasion resistant coating eg for exterior pipelines. The material has excellent properties in respect of temperature resistance, mechanical and chemical resistance and cathodic disbondment resistance.
Recommended use:	For new constructions as well as field-applied renovation and repair coating. As a self-primed, high build coating primarily for protection of interior of steel pipes and of exterior of steel pipes in severely corrosive environment, including permanent immersion. HEMPADUR 85531 is an excellent material for repair and can be applied to lines while in service temperature up to 90°C/194°F.
Service temperature:	Maximum, dry exposure only: 120°C/248°F In water (no temperature gradient): 90°C/194°F
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	50890 / Red
Finish:	Glossy
Volume solids, %:	84 ± 1
Theoretical spreading rate:	2.4 m ² /l [96.2 sq.ft./US gallon] - 350 micron/14 mils
Flash point:	14 °C [57.2 °F]
Specific gravity:	1.7 kg/litre [13.9 lbs/US gallon]
Surface-dry:	2 hour(s) 20°C/68°F
Dry to touch:	6 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	167 g/l [1.4 lbs/US gallon]
Shelf life:	1 year for BASE and 3 years (25°C/77°F) for CURING AGENT from time of production. <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
APPLICATION DETAILS:	
Version, mixed product:	85531
Mixing ratio:	BASE 85539 : CURING AGENT 97531 4 : 1 by volume
Application method:	Airless spray
Thinner (max.vol.):	08450 (5%)
Pot life:	1 hour(s) 20°C/68°F
Nozzle orifice:	0.021 - 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
Indicated film thickness, dry:	350 micron [14 mils]
Indicated film thickness, wet:	425 micron [17 mils]
Overcoat interval, min:	According to specification.
Overcoat interval, max:	According to specification.
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. Gritblasting to minimum Sa 2½ (ISO 8501-1:2007) with a surface profile equivalent to Rugotest No. 3 BN10a, Keane-Tator Comparator, min. 3.0 G/S, or ISO Comparator rough MEDIUM (G). After blasting, clean the surface carefully from abrasives and dust. Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Gritblasting to minimum Sa 2½ (ISO 8501-1:2007) with a surface profile equivalent to Rugotest No. 3 BN10a, Keane-Tator Comparator, min. 3.0 G/S, or ISO Comparator rough MEDIUM (G). After blasting, clean the surface carefully from abrasives and dust.
APPLICATION CONDITIONS:	Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying. Use only where application and curing can proceed at temperatures above: 5°C/41°F The temperature of the paint itself should be above: 15°C/59°F The best result is obtained at: 20-30°C/68-86°F
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Overcoating intervals:	The indicated overcoat intervals will normally only apply in connection with touch-up of too low dry film thicknesses. If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	HEMPADUR 85531 For professional use only.
ISSUED BY:	HEMPEL A/S 8553150890

This Product Data Sheet supersedes 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.

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