

### 47550: BASE 47559: CURING AGENT 97400

**Description:** HEMPADUR MASTIC 47550 is a two component, high solids, high build epoxy coating. It forms a hard and tough coating, has good wetting properties and low temperature curing.

**Recommended use:** As a selfprimed, surface tolerant paint system or as an intermediate or finishing coat in heavy duty paint systems where low VOC and high film build are required.  
For atmospheric service as an intermediate or as a primer in coating systems for new construction and maintenance. May be used directly on cured zinc silicate (GALVOSIL products).

**Service temperature:** Maximum, dry exposure only: 140°C/284°F.

**Availability:** Not included in Group Assortment. Availability subject to special agreement.

#### PHYSICAL CONSTANTS:

Shade nos/Colours: 12430\* / Grey. (MIO)  
Volume solids, %: 81 ± 1  
Theoretical spreading rate: 4.1 m<sup>2</sup>/l [164.4 sq.ft./US gallon] - 200 micron/8 mils  
Flash point: 25 °C [77 °F]  
Specific gravity: 1.8 kg/litre [14.7 lbs/US gallon]  
Surface-dry: 1.5 hour(s) 20°C/68°F  
Dry to touch: 3 hour(s) 20°C/68°F  
Fully cured: 7 day(s) 20°C/68°F  
VOC content: 200 g/l [1.7 lbs/US gallon]  
Shelf life: 2 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:** **47550**  
**Mixing ratio:** BASE 47559: CURING AGENT 97400  
5 : 1 by volume  
**Application method:** Airless spray / Air spray / Brush  
**Thinner (max.vol.):** HEMPEL'S THINNER 08450 (5%) / (15%) / (5%)  
**Pot life:** 1.5 hour(s) 20°C/68°F  
**Nozzle orifice:** 0.018 - 0.025 "  
**Nozzle pressure:** 250 bar [3625 psi]  
(Airless spray data are indicative and subject to adjustment)  
**Cleaning of tools:** HEMPEL'S TOOL CLEANER 99610 or HEMPEL'S THINNER 08450  
**Indicated film thickness, dry:** 200 micron [8 mils]  
**Indicated film thickness, wet:** 250 micron [10 mils]  
**Overcoat interval, min:** According to specification.  
**Overcoat interval, max:** According to specification. (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:	<p><b>New steel:</b> When used as an intermediate or finishing coat please refer to the data sheet for the preceding GALVOSIL or HEMPADUR primer. When used as a primer please refer to the specification.</p> <p><b>Zinc silicate coated surfaces:</b> Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. After exposure to high humidity, zinc salts ("white rust") will have to be carefully removed by high pressure fresh water cleaning, if necessary combined with scrubbing with stiff nylon brushes.</p> <p><b>Concrete:</b> Remove slip agent and other possible contaminants by emulsion washing followed by high pressure hosing with fresh water. Remove scum layer and loose matter to a hard, rough and uniform surface, preferably by abrasive blasting, possibly by other mechanical treatment or acid etching. Seal surface with suitable sealer, as per relevant painting specification.</p> <p><b>Repair and maintenance:</b> 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 minimum St 2 (ISO 8501-1:1988) (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:1988). Improved surface preparation will improve the performance. On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: - 5°/23°F, preferably above 0°C/32°F.</p> <p>The temperature of paint itself should be 15°C/59°F or above. but advantageously below approximately: 30°C/86°F to secure proper application properties. Optimal application properties are obtained at paint temperatures of: 18-22°C/64-72°F. In warmer climates, the paint should be stored in a cool place and the paint temperature should preferably be kept below 30°C/86°F. In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	None, or as per specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
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. <b>Avoid application of excessive film thickness.</b>
Overcoating intervals:	Maximum overcoat interval refers to exterior surfaces exposed to periodical immersion, splash, condensation or abrasion during service life of the coating system. On other areas no maximum overcoat interval for adhesion. If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	<b>HEMPADUR MASTIC 47550 For professional use only.</b>
ISSUED BY:	HEMPEL A/S

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This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on [www.hempel.com](http://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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