

# HEMUCRYL\* TI-COAT 18200

<b>Description:</b>	HEMUCRYL TI-COAT 1820 is a water-borne acrylic dispersion paint with good adhesive properties.
<b>Recommended use:</b>	In mild to moderate corrosive environment as a primer on hot dip galvanized steel, aluminium and stainless steel. See SUBSEQUENT COAT overleaf.
<b>Service temperatures:</b>	Maximum, dry: 120°C/248°F.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Red/50710
Finish:	Flat
Volume solids:	38%
Theoretical spreading rate:	19.0 m <sup>2</sup> /litre - 20 microns 762 sq.ft./US gallon - 0.8 mils
Flash point:	> 66°C/151°F
Specific gravity:	1.2 kg/litre - 10.0 lbs/US gallon
Surface dry:	15 (approx.) min. at 20°C/68°F (ISO 1517)
Dry to touch:	30 (approx.) min. at 20°C/68°F
V.O.C.:	40 g/litre - 0.3 lbs/US gallon 118 g/litre - 1.0 lbs/US gallon (ASTM D 3960 - water reduced)

*The physical constants are subject to normal manufacturing tolerances.  
Further reference is made to "Explanatory Notes" in the Hempel Book.*

## APPLICATION DETAILS:

Application method:	Airless spray	Brush (touch-up)
Thinner (max. vol.):	Fresh water (5%)	Fresh water (5%)
Nozzle orifice:	.015"-.017"	
Nozzle pressure:	130 bar/1900 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	Fresh water (See REMARKS overleaf)	
Indicated film thickness, dry:	20 microns/0.8 mils	
Indicated film thickness, wet:	50 microns/2 mils	
Recoat interval, min:	24 hours (at 20°C/68°F) (See REMARKS overleaf)	
Recoat interval, max:	None (See REMARKS overleaf)	

## 2. HEMUCRYL TI-COAT 18200

SURFACE	<b>Aluminium:</b> Very careful degreasing, followed by (high pressure) fresh water cleaning to remove all
PREPARATION:	salts and other contamination. Any anodizing must be completely removed. Thorough sand papering or abrasive sweeping with mineral abrasives is recommended. Cast aluminium is recommended to be abrasive swept to a uniform, evenly grey appearance. Hot dip galvanized steel: Wet rubbing/grinding with ammonia-water 1:20, followed by fresh water hosing. In case this method not being feasible, the procedure as described for stainless steel may be used. <b>Stainless steel:</b> Very careful degreasing with alkaline degreaser, i.e. HEMPEL'S LIGHT CLEANER 9935, followed by fresh water hosing to remove all contamination. <b>Hot-dipped galvanized steel:</b> Wet rubbing/grinding with ammonia water 1:20 followed by fresh water hosing. In the case this method is not feasible, the procedure as described for stainless steel may be used. <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") must be removed carefully by (high pressure) fresh water cleaning - if necessary combined with scrubbing with stiff nylon brushes. Consult the APPLICATION INSTRUCTIONS for the relevant GALVOSIL product.
APPLICATION CONDITIONS:	Use only where application can proceed at temperatures above 5°C/41°F, preferably above 10°C/50°F. Apply on a clean and dry surface with a temperature above the dew point to avoid condensation. Relative humidity: During application above 60%, preferably 75-90% to avoid dry spray. During drying below 80%, preferably between 40-60%. Good ventilation during application and drying is necessary. During drying it is of utmost importance that sufficient ventilation is covering all parts of the surfaces painted. Ventilation requirements to remove the water vapours liberated during application and drying are approx. 75 m³/litre of paint at 20°C/68°F. (Relative humidity of the air supply 40%).
SUBSEQUENT COAT:	HEMUCRYL, HEMPALIN, HEMPATEX systems according to specification.
REMARKS:	
Recoating:	If the subsequent coat is a HEMUCRYL-system the minimum recoating interval can be reduced to 2 hours at 20°C/68°F and ventilation. (Yet, see below). No maximum recoating interval, but after prolonged exposure to polluted atmosphere remove accumulated contamination by high pressure fresh water cleaning and allow to dry.
Exposure to low temperatures shortly after application:	If the painted items will be exposed to humidity/water at temperatures below 5-10°C/41-50°F after finishing the paint application it is of utmost importance for later good performance that following rules are complied with: a) Excessive film thicknesses must be avoided. b) When overcoated the minimum recoating interval is 24 hours at 20°C/68°F irrespective of the following coat. c) The (last applied) paint layer must dry for at least 24 hours at 20°C/68°F before exposure.
Cleaning of tools:	Clean tools carefully with fresh water or lukewarm soap water immediately after use. Dried remains of paint can be removed with undiluted HEMPEL'S NAVI WASH 9933 or, preferably with HEMPEL'S TOOL CLEANER 9961.
Shelf life/storage:	Store at temperatures between 5-40°C/41-104°F. Shelf life is reduced at temperatures above 30°C/86°F. Do not expose to frost during storage and transport or before the coating is dry.
Note:	<b>HEMUCRYL TI-COAT 1820 is for professional use only.</b>
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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when

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applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.