

# HEMPADUR\* 4530<sub>3</sub>

CURING AGENT 95570

<b>Description:</b>	HEMPADUR 4530 is a high-build, modified, two-component, polyamide adduct cured epoxy paint.
<b>Recommended use:</b>	For recoating with HEMPATANE topcoats and HEMPATEX paints. Not for permanent immersion.
<b>Service temperatures:</b>	Maximum, dry: 120°C/248°F.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Red/50630 - Off-white/11630
Finish:	Flat
Volume solids:	52%
Theoretical spreading rate:	6.9 m <sup>2</sup> /litre - 75 micron 278 sq.ft./US gallon - 3 mils
Flash point:	14°C/57°F
Specific gravity:	1.3 kg/litre - 10.9 lbs/US gallon
Surface dry:	2 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch:	6 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	426 g/litre - 3.5 lbs/US gallon

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

## APPLICATION DETAILS:

Mixing ratio for 4530 <sub>3</sub> :	Base 4530 <sub>7</sub> : Curing agent 95570 8.5 : 1.5 by volume
Application method:	Airless spray                      Brush
Thinner (max. vol.):	0845 (5%)                      0845 (5%)
Pot life:	4 hours (20°C/68°F)
Nozzle orifice:	.018"
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 9961
Indicated film thickness, dry:	75 micron/3 mils (see REMARKS overleaf)
Indicated film thickness, wet:	150 micron/6 mils
Recoat interval, min:	8 hours (20°C/68°F)
Recoat interval, max:	See REMARKS overleaf

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## 2. HEMPADUR 45303

**SURFACE PREPARATION:** **New steel:** Abrasive blasting to Sa 2½. For temporary protection, if required, use suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use a HEMPADUR primer as specified or in the case of mild in-service conditions HEMPADUR 4530.  
**Maintenance and recoating:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. After dedusting, touch up bare spots to full film thickness.

**APPLICATION CONDITIONS:** Apply 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 -10°C/14°F. At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion.  
The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties.  
In confined spaces provide adequate ventilation during application and drying.

**PRECEDING COAT:** None, HEMPADUR PRIMER 1530, HEMPADUR ZINC 1536 or according to specification. In mildly corrosive environment, HEMPADUR 4530 can be applied directly to steel.

**SUBSEQUENT COAT:** HEMPATHANE TOPCOAT 5521, HEMPATEX HI-BUILD 4641, HEMPATEX ENAMEL 5636 or according to specification.

**REMARKS:** 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 recoating interval. The normal range is 50-100 micron/2-4 mils.

**Recoating:** Recoat intervals related to later conditions of exposure:  
(75 micron/3 mils dry film thickness of HEMPADUR 4530)

	Minimum		Maximum		Minimum		Maximum	
Surface temperature	10°C/50°F		10°C/50°F		20°C/68°F		20°C/68°F	
Recoated with (quality nos only)	Medium	Severe	Medium	Severe	Medium	Severe	Medium	Severe
4641, 5636	8 hours	16 hours	None	10 days	4 hours	8 hours	None	5 days
5521	8 hours	16 hours	None	None	4 hours	8 hours	None	None

**Before recoating, clean the surface thoroughly of all contamination. Especially at long intervals before recoating a very careful cleaning is necessary.**  
**To check adequate quality of the preparatory cleaning, a test patch is recommended before actual recoating.**

**Note:** **HEMPADUR 4530 is for professional use only.**

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

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