

# HEMPADUR\* MASTIC 45880

CURING AGENT 95880

**Description:** HEMPADUR MASTIC 4588 is a two-component polyamide adduct cured, high solids, high build epoxy paint. It forms a hard and tough coating and has good wetting properties. Cures at temperatures down to -10°C/14°F.

**Recommended use:** As a selfprimed paint system or as an intermediate or possible finishing coat in epoxy systems in medium to severely corrosive atmospheric environment and where a high solid content is required.  
As a finishing coat where a cosmetic appearance is of less importance.  
As a non-popping coat directly on cured zinc silicate (GALVOSIL products) or spray-metallized surfaces.

**Service temperatures:** Maximum, dry: 120°C/248°F

**Approvals, certificates:** Tested for non-contamination of grain cargo at the Newcastle Occupational Health, Great Britain.

**Availability:** Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos: Grey/12170 (*Other shades according to assortment list*)  
Finish: Semi--gloss  
Volume solids: 80%  
Theoretical spreading rate: 5.3 m<sup>2</sup>/litre - 150 micron  
214 sq.ft./US gallon - 6 mils  
Flash point: 28°C/82°F  
Specific gravity: 1.4 kg/litre - 11.7 lbs/US gallon  
Dry to touch: 4 (approx.) hours at 20°C/68°F  
Fully cured: 7 days at 20°C/68°F  
V.O.C.: 211 g/litre - 1.8 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 45880: Base 45889 : Curing agent 95880  
3 : 1 by volume  
Application method: Airless spray      Brush (*touch up*)  
Thinner (max. vol.): 0845 (5%)      0845 (5%)  
Pot life: 1 hour (20°C/68°F)    2 hours (20°C/68°F)  
Nozzle orifice: .017"-.023"  
Nozzle pressure: 250 bar/3600 psi  
(*Airless spray data are indicative and subject to adjustment*)  
Cleaning of tools: HEMPEL'S TOOL CLEANER 9961 or HEMPEL'S THINNER 0845  
Indicated film thickness, dry: 150 micron/6 mils (*see REMARKS overleaf*)  
Indicated film thickness, wet: 200 micron/8 mils  
Recoat interval, min: As per separate APPLICATION INSTRUCTIONS  
Recoat interval, max: As per separate APPLICATION INSTRUCTIONS

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SURFACE PREPARATION:	<p><b>New steel:</b> When used as an intermediate or finishing coat please refer to the data sheet for the preceding HEMPADUR primer. When used as a primer please refer to the specification. For "heavy duty" purposes, abrasive blasting to minimum Sa 2½ is recommended.</p> <p><b>Zinc silicate painted or spray-metallized surfaces:</b> Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Zinc salts (white rust) must be removed by high pressure hosing combined with rubbing with a stiff nylon brush if necessary. It is recommended to recoat spray-metallized surfaces as soon as possible to avoid possible contamination.</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, eg HEMPADUR SEALER 0597 (furthermore, please see Product Data Sheet for 0597).</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 St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of HEMPADUR MASTIC 4588. As an alternative to dry cleaning, water jetting to min. WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of maximum FR-2 (Hempel standard) is acceptable before application. Feather edges to sound and intact paint. Dust off residues.</p> <p>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 when application and curing can proceed at temperatures above -10°C/14°F. The temperature of the paint itself should be 15°C/59°F or above, but advantageously below approximately 30°C/86°F to secure proper application properties. Optimal spraying properties are obtained at a paint temperature 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°C. In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	None or according to specification.
SUBSEQUENT COAT:	None or according to specification.
REMARKS: Weathering/ service temperatures: Film thicknesses:  Application on zinc silicate or spray- metallized surfaces: Note:	<p>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.</p> <p>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. Normal range dry is 100-200 micron/4-8 mils. <b>Avoid application of excessive film thicknesses.</b></p> <p>It is recommended to apply HEMPADUR MASTIC 4588 by using a "mist-coat" procedure: A thin, undiluted coat is applied (the mist coat) and after a few minutes, a second coat is applied in the full specified film thickness.</p> <p><b>HEMPADUR MASTIC 4588 is for professional use only.</b></p>
SAFETY:	<p>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.</p> <p>Apply only in well ventilated areas and ensure that adequate forced ventilation exists when</p>

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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.