

HEMPADUR* 85671

CURING AGENT 97371

Description:	HEMPADUR 8567 is a two-component, amine adduct cured phenolic epoxy (novolac) coating with very good adhesion and high temperature, water and chemical resistance.		
Recommended use:	As an interior lining in tanks etc. for hot water, brine, crude oil, etc. For coating of potable water tanks.		
Service temperatures:	Dry:	In water (maximum gradient 15°C/59°F):	
Maximum:	160°C/320°F	90°C/194°F	
Approvals, certificates:	HEMPADUR 8567 is in accordance with ARAMCO's specification APCS 2A and 2B. Approved for use in potable water tanks by the Water Research Centre, England.		
Availability:	Subject to confirmation.		

PHYSICAL CONSTANTS:

Colours/Shade nos:	Off-white/11630, Light red/50900
Finish:	Flat
Volume solids:	68%
Theoretical spreading rate:	6.8 m ² /litre - 100 micron 273 sq.ft./US gallon - 4 mils
Flash point:	24°C/75°F
Specific gravity:	1.7 kg/litre - 14.2 lbs/US gallon
Surface dry:	2-3 hours at 20°C/68°F
Dry to touch:	6 (approx.) hours at 20°C/68°F
Fully cured:	10 days at 20°C/68°F
V.O.C.:	316 g/litre - 2.7 lbs/US gallon
Shelf life:	1 year from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

*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 85671:	Base 85675 : Curing agent 97371 8.8 : 1.2 by volume 13.8 : 1.0 by weight		
Induction time:	Minimum 15 minutes at 20°C/68°F		
Application method:	Airless spray	Brush (touch-up)	
Thinner (max.vol.):	0845 (See APPLICATION INSTRUCTIONS)		0845 (see APPLICATION INSTRUCTIONS)
Pot life:	See REMARKS overleaf		
Induction time:	15 minutes (20°C/68°F) (see REMARKS overleaf)		
Nozzle orifice:	.018"-.021"		
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:	100 micron/4 mils (see REMARKS overleaf)		
Indicated film thickness, wet:	150 micron/6 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

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SURFACE PREPARATION:	For optimum performance abrasive blasting to very near white metal Sa 2½-3, with a surface profile corresponding to Rugotest No. 3, BN10b, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself must be above 15°C/59°F, best results are obtained at 17-23°C/62-73°F. Relative humidity max. 80%, preferably 40-60%. Apply on a dry and clean surface with a temperature above the dew point to avoid condensation. Furthermore, reference is made to special APPLICATION INSTRUCTIONS and HEMPEL'S TECHNICAL STANDARD FOR TANK COATING WORK. Provide adequate ventilation during application and drying in confined spaces.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
Film thicknesses:	The minimum total dry film thickness for the system is 300 microns/12 mils. May be specified in higher film thickness than indicated depending on purpose and area of use. This will alter spreading rate, influence drying time and prolong minimum recoating intervals. The specification may read up to 125 micron/5 mils dry film thickness per coat, exceptionally 150 micron/6 mils.
Pot life:	As per Aramco's requirements, gel time is above 8 hours at a can temperature of 23°C/73°F and above 2 hours at a can temperature of 40°C/104°F. For optimum spray application properties, the mixture should be used within 2 hours at 20°C/68°F.
Recoating intervals:	Minimum: Non-potable water service: 36 hours (20°C/68°F) between the first and second coat, 24 hours (20°C/68°F) between the second and third coat. Potable water service: 3 days (20°C/68°F) between coats. Maximum: 21 days (20°C/68°F). If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Notes to application:	<ul style="list-style-type: none">- The coating is to be applied in a dry film thickness as near as possible to the specified 100 micron/4 mils (or higher if specified).- Film formation of each coat has to be of good quality, free from defects such as pinholes and without any dry spray.- Drying and curing conditions have to be according to APPLICATION CONDITIONS until full curing has been obtained.- No kind of surface contamination must exist except loose dust, abrasives, loose dry-spray, which is possible to remove by vacuum cleaning before overcoating. The surface MUST be completely clean before overcoating.- The coating must only be (exceptionally) exposed to strong, direct sunlight (ultraviolet light) in short periods.- The coating is to be checked carefully and should have no patchy, whitish, and/or greasy formation, which can hinder adhesion of the subsequent coat. <p>Note: Exudation of the curing agent causes the mentioned patchy, whitish, and/or greasy formation, which will take place if HEMPADUR 8567 is applied at low temperatures without proper induction time and/or if the coating is exposed to water (rain, condensation) during drying and curing.</p>
Mixing:	The thoroughly mixed BASE and CURING AGENT must be prereacted before application (15 minutes at 20°C/68°F). Keep thinning at an absolute minimum. Do not dilute the components separately - only the mixture.
Note:	HEMPADUR 8567 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.

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. 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. The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise.

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