



Product Data

HEMPEL'S GELPRIMER 45580

BASE 45589 with CURING AGENT 98580

Description:	HEMPEL'S GELPRIMER 45580 is a two-component polyamide adduct cured epoxy high build paint. Fast to recoat.
Recommended use:	As a primer for antifouling paints on boats made of glass fibre reinforced polyester. Especially designed for professional user applications where short recoating intervals are needed.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Off-white/11630
Finish:	Flat
Volume solids, %:	45 ± 1
Theoretical spreading rate:	4.5 m ² /litre - 100 micron 180 sq.ft./US gallon - 4 mils
Flash point:	35°C/95°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon
Dry to touch:	Approx. 2 hours at 20°C/68°F Approx. 4 hours at 10°C/50°F
Fully cured:	7 days at 20°C/68°F 14 days at 10°C/50°F
V.O.C.:	475 g/litre - 3.9 lbs/US gallon

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

APPLICATION DETAILS:

Mixing ratio for 45580:	Base 45589 : Curing agent 98580 4 : 1 by volume
Application method.:	Airless spray
Thinner:	08450 (5%)
Pot life:	2 hours (20°C/68°F)
Nozzle orifice:	.019"-.023"
Nozzle pressure:	175 bar/2450 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S THINNER 08450, HEMPEL'S DEGREASER 99611
Indicated film thickness, dry:	100 micron/4 mils
Indicated film thickness, wet:	225 micron/9 mils
Recoat interval, antifouling:	When still tacky, see REMARKS overleaf

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. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.
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SURFACE PREPARATION:	Degrease the surface with HEMPEL'S DEGREASER 99611/HEMPEL'S TOOL CLEANER 99610. Apply plentiful HEMPEL'S DEGREASER 99611/HEMPEL'S TOOL CLEANER 99610 using a "Scotchbrite Pad". Wipe off the entire surface by using clean rags - replace used rags often with clean rags during the work. The entire degreasing work must be executed very carefully!
APPLICATION CONDITIONS:	Apply only where application and curing can proceed at temperatures above 5°C/41°F. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. Best result is obtained at temperatures between 15-20°C/59-68°F. The surface must be clean and dry and its temperature must be above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
SUBSEQUENT COAT:	Antifouling according to specification.
REMARKS:	<p>The use of HEMPEL'S GELPRIMER 45580 as a "link" between the gel coat and the antifouling implies a good quality GRP and a very careful degreasing. If HEMPEL'S GELPRIMER 45580 is to be used for other/extended purposes, this will eg influence the need and type of surface preparation, the paint system build-up and recoating intervals. Consult Hempel for further advise.</p> <p>May be specified in another film thickness than indicated depending on purpose area of use and application method. This will alter spreading rate and may influence drying time and recoat interval. Launching should not take place until the last coat of HEMPEL'S GELPRIMER 45580 has cured for 1 week at 20°C/68°F, 2 weeks at 10°C/50°F.</p>
Recoating:	<p>The first coat of the chosen antifouling must be applied while the last coat of HEMPEL'S GELPRIMER 45580 is still tacky at 20°C/68°F this will usually be within ½-1 hour.</p> <p>If exceeded, the surface must be "refreshed" by a new thin coat of HEMPEL'S GELPRIMER 45580. Recoating interval for HEMPEL'S GELPRIMER 45580 by itself will be minimum 3 hours (20°C/68°F), maximum 3 days (20°C/68°F).</p>
NOTE:	The information given in the Product Data Sheet is intended for commercial use.
ISSUED BY:	HEMPEL A/S - 4558011630CS001

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.

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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Product data are subject to change without notice and become void five years from the date of issue.