



HEMPADUR FX4 37300

37300: BASE 37309: CURING AGENT 98300

Description:	HEMPADUR FX4 37300 is an amine-cured, solvent-free epoxy coating which cures to a strong and smooth lining. It complies fully with the Federal Food, Drug, and Cosmetic Act and all applicable food additive regulations, including 21 C.F.R. § 175.300 ("Resinous and polymeric coatings").
Recommended use:	As a one coat system on internal surfaces of rail cars transporting bulk quantities of dry food and plastic pellets for the manufacturing of food-contact materials.
Service temperature:	Maximum, dry exposure only: 120°C/248°F see REMARKS overleaf
Availability:	Not included in Group Assortment. Availability subject to special agreement.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	37900/ Blue.
Finish:	Glossy
Volume solids, %:	96 (ISO 3233)
Theoretical spreading rate:	3.8 m ² /l [152.4 sq.ft./US gallon] - 250 micron/10 mils
Flash point:	101 °C [213.8 °F]
Specific gravity:	1.4 kg/litre [11.5 lbs/US gallon]
Dry to touch:	12 hour(s) , 20°C/68°F; 3 3 hours, 50°C/122°F
Fully cured:	7 day(s) , 20°C/68°F
VOC content:	41 g/l [0.3 lbs/US gallon] <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
APPLICATION DETAILS:	
Version, mixed product:	37300
Mixing ratio:	BASE 37309: CURING AGENT 98300 1:1 by volume
Application method:	Heated plural component airless spray equipment (Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.):	Do not dilute. (Consult the separate APPLICATION INSTRUCTIONS)
Pot life:	30 minute(s) , 20°C/68°F or 5-10 minutes, 40°C/105°F
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	250 micron [10 mils] see REMARKS overleaf
Indicated film thickness, wet:	250 micron [10 mils]
Overcoat interval, min:	According to separate APPLICATION INSTRUCTIONS
Overcoat interval, max:	According to separate APPLICATION INSTRUCTIONS
Safety:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations.



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SURFACE PREPARATION:

Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive grit blasting to minimum Sa 2½ (SSPC-SP-10) (ISO 8501-1:1988). Recommended surface profile is Rz 75-100 micron/3-4 mils, corresponding to Rugotest No. 3, BN 10, Keane-Tator Comparator, minimum 3.0 G/S or ISO Comparator, Medium (G). After blasting, clean the surface carefully from abrasives and dust.

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above: 10°C/50°F. Apply only on a dry and clean surface with a temperature min. 3°C/5°F above the dew point to avoid condensation. The temperature for both base and curing agent should not exceed 60°C/140°F. Maximum relative humidity: 90%.

PRECEDING COAT:

None.

SUBSEQUENT COAT:

None.

REMARKS:

Colours/Colour stability:

Elevated temperature may result in discolouration and loss of gloss.

Film thicknesses/thinning:

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 overcoating interval.

Storage Conditions:

The maximum temperature of the substrate should not be more than 45°C/113°F. Ensure that the paint material is applied in a uniform film free of pinholes, dry-spray or forming properties: other irregularities.

Overcoating intervals:

The indicated over coating interval will normally only apply in connection with touch-up of areas with too low dry film thickness. If the maximum over coating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Note:

HEMPADUR FX4 37300 For professional use only.

ISSUED BY:

HEMPEL A/S

3730037900

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on www.hempel.com. 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. Product data are subject to change without notice and become void five years from the date of issue.