



# Specification sheet

Hempel (Croatia) Ltd.

**Customer:** PLOVPUT d.o.o.  
Obala Lazareta 1  
21000 Split

**Project:** Radna brodica od aluminijske legure

**Area:**  
PODVODNI DIO

**Area size:** 43 sqm

## Surface preparation:

Površinu po potrebi odmastiti te oprati slatkom vodom visokim tlakom kako bi se uklonile sve površinske nečistoće i eventualni obrastaj.

Stare slojeve boje ukloniti te površinu nahrapaviti pjeskarenjem nemetalnim (mineralnim) abrazivom do ujednačenog mat izgleda, alternativno za manje površine priprema površine može biti napravljena mehanickim brusenjem papirom granulacije 40-60.

Površinu nako izvršene pripreme detaljno ocistiti od zaostalih kontaminacija.

Bojanje ovako pripremljene površine izvršiti bez odgadanja.

Product name (including quality number)	Treated area		Shade no.	Film thickness (micron)		Theoretical spreading rate (sqm/ltr)	Application methods			Recommended	
	%	Colour		Wet	Dry		Brush	Roller	Spray	Nozzle orifice	Nozzle pressure
HEMPADUR 15570	f/c 100	Red	50630	225	125	4.4	(X)		X	.019"-.021"	175 bar
HEMPADUR 15570	f/c 100	Grey	12170	225	125	4.4	(X)		X	.019"-.021"	175 bar
HEMPADUR 45182	f/c 100	Black	19990	225	100	4.6	(X)		X	.023"	200 bar
HEMPEL'S ALUSAFE 7120D	f/c 100	Blue	31750	100	50	10.0	(X)	(X)	X	.018"-.023"	150 bar
HEMPEL'S ALUSAFE 7120D	f/c 100	Blue	31750	100	50	10.0	(X)	(X)	X	.018"-.023"	150 bar
HEMPEL'S ALUSAFE 7120D	f/c 100	Blue	31750	100	50	10.0	(X)	(X)	X	.018"-.023"	150 bar
t/u: touch up f/c: full coat s/c: stripe coat		Total d.f.t.		500			X: Recommended (X): Possible				

Remarks and Product information see next page.

Hempel's PreSale System 2.6.17 (Build 890) User name: Tomislav Pinterić  
Printed at: 15.12.2014 16:33 Department name: Split  
Created/Last modified: 15.12.2014 16:33 HRTOP0190L Page: 1

Quality Code:  
Environment: Immersion

# HEMPEL



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Obala Lazareta 1  
21000 Split

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**Area:**  
PODVODNI DIO

**Area size:** 43 sqm

Recoating intervals. Ample ventilation

Hrs=Hour(s) Mth=Month(s) N/R=Not Recommended

Quality no	D.F.T. (micron)	Recoated with quality no	40°C		30°C		20°C		10°C		0°C		-10°C	
			Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
15570	125	15570	N/R	N/R	8 Hrs	Ext	11 Hrs	Ext	21 Hrs	Ext	48 Hrs	Ext	4 Day	Ext
15570	125	45182	N/R	N/R	8 Hrs	22½ Day	11 Hrs	30 Day	21 Hrs	60 Day	48 Hrs	90 Day	4 Day	90 Day
45182	100	7120D	3 Hrs	60 Hrs	5 Hrs	3½ Day	6 Hrs	5 Day	12 Hrs	10 Day	27 Hrs	22½ Day	54 Hrs	45 Day
7120D	50	7120D	4 Hrs	None	6 Hrs	None	8 Hrs	None	16 Hrs	None	32 Hrs	None	64 Hrs	None
7120D	50	7120D	4 Hrs	None	6 Hrs	None	8 Hrs	None	16 Hrs	None	32 Hrs	None	64 Hrs	None
Drying time before taking into use, before un-docking			4 Hrs	None	6 Hrs	None	8 Hrs	None	16 Hrs	None	32 Hrs	None	64 Hrs	None

The data, specifications, directions and recommendations (hereinafter "Information") given in this painting specification are based upon test results obtained under controlled or specifically defined conditions and said Information is correct to the best of our knowledge. The User must satisfy itself that it is appropriate to use the Product in accordance with the Information in the actual conditions under which the Product is intended to be used, and the Manufacturer and Seller do not guarantee the accuracy, completeness or appropriateness of the Information when the Product is used in those conditions. The provisions regarding Hempel's liability in its applicable conditions for sale, delivery and service shall apply to any and all claims arising out of or in connection with the use of the products recommended above, overleaf or otherwise.

Hempel's PreSale System 2.6.17 (Build 890)

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# HEMPEL



# Specification sheet

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**Area:**  
PODVODNI DIO

**Area size:** 43 sqm

**Remarks:**

Preporučena minimalna ukupna debljina suhog filma antifoulinga je 120 mikrometara. Za plovila brzine korištenja iznad 15 èvorova preporuča se nanijeti dodatni premaz.

Product information:		Volume solids %	Curing agent	Mixing ratio volume	Pot life 20°C	Dry to touch 20°C	Flash point °C	Thinner	Application restrictions	
Shade no.									Min. Temp. °C	Max. RH%
HEMPADUR 15570	50630	55	95570	3 : 1	2 h	3 h	25	08450	-10	
HEMPADUR 15570	12170	55	95570	3 : 1	2 h	3 h	25	08450	-10	
HEMPADUR 45182	19990	46	98180	4 : 1	3 h	6 h	23	08450	-10	
HEMPEL'S ALUSAFE 7120D	31750	50				4 h	32	08080		
HEMPEL'S ALUSAFE 7120D	31750	50				4 h	32	08080		
HEMPEL'S ALUSAFE 7120D	31750	50				4 h	32	08080		

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# HEMPEL



## HEMPADUR 15570

15570: BASE 15579: CURING AGENT 95570

- Description:** HEMPADUR 15570 is a two component, polyamide-adduct cured epoxy paint, which cures to a strong and highly corrosion resistant coating, at temperatures down to -10°C/14°F. The Micaceous Iron Oxide pigmented light grey 12430 shade is also well suited for application under humid conditions, on damp steel surfaces, and may be applied on moist surfaces. The greyish yellow 21780 shade contains zinc phosphate.
- Recommended use:** As a maintenance and repair primer, intermediate, and/or finishing coat in HEMPADUR systems in severely corrosive environment. As a finishing coat where a cosmetic appearance is of less importance.  
As a low temperature curing epoxy primer, intermediate, and/or finishing coat in paint systems according to specification. Well suited as a (blast) primer in epoxy systems.  
Mist coat on GALVOSIL.
- Service temperature:** Maximum, dry exposure only: 140°C/284°F  
Ballast water service. Resists normal ambient temperatures at sea (Avoid long-term exposure to negative temperature gradients).  
Other liquids: Contact HEMPEL

- Certificates/Approvals:** Approved as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on [www.Hempel.com](http://www.Hempel.com) for further details.  
Complies with EU Directive 2004/42/EC: subcategory j. (see REMARKS overleaf)
- Availability:** Part of Group Assortment. Local availability subject to confirmation.

### PHYSICAL CONSTANTS:

- Shade nos/Colours: 12430 (MIO)\* / Reddish grey  
Finish: Flat  
Volume solids, %: 54 ± 1  
Theoretical spreading rate: 5.4 m<sup>2</sup>/l [216.5 sq.ft./US gallon] - 100 micron/4 mils  
Flash point: 25 °C [77 °F]  
Specific gravity: 1.4 kg/litre [11.6 lbs/US gallon]  
Dry to touch: 3 - 4 approx. hour(s) 20°C/68°F  
Fully cured: 7 day(s) 20°C/68°F  
VOC content: 414 g/l [3.4 lbs/US gallon]

*\*other shades according to assortment list.*

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.*

### APPLICATION DETAILS:

- Version, mixed product:** **15570**
- Mixing ratio: BASE 15579: CURING AGENT 95570  
3 : 1 by volume
- Application method: Airless spray / Air spray / Brush  
Thinner (max.vol.): 08450 (5%) / 08450 (15%) / 08450 (5%)  
Pot life: 2 hour(s) 20°C/68°F  
Nozzle orifice: 0.019 - 0.021 "  
Nozzle pressure: 175 bar [2537.5 psi]  
(Airless spray data are indicative and subject to adjustment)
- Cleaning of tools: HEMPEL'S TOOL CLEANER 99610  
Indicated film thickness, dry: 100 micron [4 mils] see REMARKS overleaf  
Indicated film thickness, wet: 200 micron [8 mils]  
Overcoat interval, min: see REMARKS overleaf  
Overcoat interval, max: see REMARKS overleaf

- 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.



**HEMPADUR 15570**

**SURFACE PREPARATION:**

**New steel:** Abrasive blasting to Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use a 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: HEMPADUR

**Other metals and light alloys:** Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion - surface profile depending on later exposure.

**Stainless steel:** (eg. ballast tanks of chemical carriers) to be abrasive blast cleaned to a uniform, sharp, dense profile (Rugotest No. 3, BN9a, ISO Comparator Medium (G), Keane-Tator Comparator 2.0 G/S) corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.

**Maintenance:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (ISO 8501-1:2007) (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007). Improved surface preparation will improve the performance of the product. As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be: Wa 2 -Wa 2½ (atmospheric exposure) / minimum Wa 2½ (immersion) (ISO 8501-4:2006). Acceptable flash-rust degree before application: maximum M (atmospheric exposure) / M, preferably L (immersion) (ISO 8501-4:2006). Feather edges to sound and intact areas. Dust off residues. Touch up bare spots to full film thickness. This should be done when the painted surface has reached the condition of being damp, possibly moist. In case of wet abrasive blasting a suitable inhibitor may be used. Surplus inhibitor and residual abrasives and sludge must be removed by (high pressure) fresh water cleaning before recoating. Cleaning with hot water is recommended.

**Note 1:** Inhibitors are generally not recommended for surfaces which will be immersed during service.

**Note 2: Damp surfaces:** water is not readily detectable, but the temperature of the surface is below the dew point. **Moist surfaces:** pools of water and droplets have been removed, but there is a noticeable film of water. **Wet surface:** droplets or pools of water are present.

**APPLICATION CONDITIONS:**

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 adhesion. The temperature of paint itself should be 15°C/59°F or above. In confined spaces provide adequate ventilation during application and drying. Occurrence of standing water or droplets on the painted surface immediately after application may result in discolouration.

**PRECEDING COAT:**

None, or as per specification.

**SUBSEQUENT COAT:**

None, or as per specification. Recommended systems are: HEMPADUR, HEMPATHANE, HEMPATEX

**REMARKS:**

**VOC - EU Directive 2004/42/EC:**

Product	As supplied	15 vol. % thinning	Limit phase II, 2010
1557012430	414 g/l	480 g/l	500 g/l

For VOC of other shades, please refer to Safety Data Sheet.

**Weathering/service temperatures:**

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. 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. Normal range dry is: 50-125 micron/2-5 mils

**Film thicknesses/thinning:**

**Overcoating:**

Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

A specification supersedes any guideline overcoat intervals indicated in the table.

Environment	Atmospheric, medium					
	-10°C (14°F)		0°C (32°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	36 h	Ext.	18 h	Ext.	4 h	Ext.
HEMPATEX	18 h	3 d	9 h	36 h	2 h	8 h
HEMPATHANE	36 h	90 d	18 h	45 d	4 h	10 d
Environment	Immersion					
	HEMPADUR	3 d	Ext.	1½ d	Ext.	8 h

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

**Note:**

**HEMPADUR 15570 For professional use only.**

**ISSUED BY:**

HEMPEL A/S



**HEMPADUR 15570**

1557012430

This Product Data Sheet supersedes those previously issued.

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# Product Data

## HEMPADUR 45182

45182: BASE 45187 : CURING AGENT 98180

<b>Description:</b>	HEMPADUR 45182 is a two-component, low-temperature curing, modified polyamide adduct cured epoxy.
<b>Recommended use:</b>	For marine and protective use as a "tiecoat" ("tackcoat") between epoxy and physically drying coatings. For marine use also as a "sealer" of old antifouling.
<b>Service temperature:</b>	Maximum, dry exposure only: 80°C/176°F
<b>Availability:</b>	Part of Group Assortment. Local availability subject to confirmation.

### PHYSICAL CONSTANTS:

Shade nos/Colours:	25150 / Yellowish grey
Finish:	Flat
Volume solids, %:	46 ± 1
Theoretical spreading rate:	4.6 m <sup>2</sup> /l [184.5 sq.ft./US gallon] - 100 micron/4 mils
Flash point:	23 °C [73.4 °F]
Specific gravity:	1.3 kg/litre [11.1 lbs/US gallon]
Dry to touch:	6 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	483 g/l [4 lbs/US gallon]

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.*

### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>45182</b>
Mixing ratio:	BASE 45187 : CURING AGENT 98180 4 : 1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (5%)
Pot life:	3 hour(s) 20°C/68°F
Nozzle orifice:	0.023 "
Nozzle pressure:	200 bar [2900 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	100 micron [4 mils]
Indicated film thickness, wet:	225 micron [9 mils]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf
<b>Safety:</b>	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.





**HEMPADUR 45182**

**SURFACE PREPARATION:**

**New steel:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to minimum Sa 2½ (ISO 8501-1: 2007) with a surface profile corresponding to Rugotest No. 3, N9a to N10, preferably BN9a to BN10, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G). For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting.

**Repair and maintenance:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. When used as "tiecoat": Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up bare spots to full film thickness.

When used as "sealer" on old antifouling: a very careful high pressure freshwater cleaning -or jetting, if needed - to remove possible leached layer of antifouling and make sure that old layers of weak intercoat adhesion ("sandwich structure") really are removed.

**APPLICATION CONDITIONS:**

Apply only 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. The temperature of the surface and that of the paint itself must also be above this limit. In confined spaces provide adequate ventilation during application and drying.

**PRECEDING COAT:**

According to specification. In case of an old antifouling system this must be well cleaned and in good condition.

**SUBSEQUENT COAT:**

According to specification.

**REMARKS:**

**Film thicknesses/thinning:**

The product is designed for overcoating with antifoulings in any normal specified total film thicknesses. The product is not designed for overcoating with heavy duty epoxy systems. Later maintenance of paint systems with the product as a part of the system is accordingly most conveniently carried out by touch-up with a "mastic" type epoxy and with a proper overlap of intact surrounding paint system. 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: 75-125 micron/3-5 mils. As "sealer" typically to be specified in: 50-75 micron/2-3 mils dry film thickness. Thinning may be required to facilitate proper film formation.

**Overcoating:**

Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

A specification supersedes any guideline overcoat intervals indicated in the table.

Environment	Immersion					
	-10°C (14°F)		0°C (32°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
Conventional A/F	54 h	45 d	27 h	22½ d	6 h	5 d

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

**Overcoating note:**

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long overcoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed by fresh water hosing. Any degraded surface layer, as a result of a long exposure period, must be removed as well. Water jetting may be relevant to remove any degraded surface layer and may also replace the above mentioned cleaning methods when properly executed. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant. A thin extra coat of the product may advantageously be applied if there is any doubt about suitability of cleaning process.

**Note:**

**HEMPADUR 45182 For professional use only.**

**ISSUED BY:**

HEMPEL A/S  
4518225150

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## HEMPEL'S ALUSAFE 7120D

**Description:** HEMPEL'S ALUSAFE 7120D is a copper-free self polishing antifouling with organic bioactive material. It changes to its final colour after approximately 1 week of exposure to water. Due to its self-renewing effect this product maintains an effective bioactive surface during its entire service life.

**Recommended use:** As an antifouling for boats of aluminium and other light-alloy metal. Primarily for use in water with relatively low fouling potential. Length of service may have a certain influence on colour. The antifouling may obtain a greenish tinge. For cold and temperate waters.

**Certificates/Approvals:**

**Availability:** Part of European Yacht assortment. Local availability subject to confirmation.

**PHYSICAL CONSTANTS:**

Shade nos/Colours: 10000\*/ White.  
Finish: Semi-flat  
Volume solids, %: 54 ± 1  
Theoretical spreading rate: 13.5 m<sup>2</sup>/l [541.4 sq.ft./US gallon] - 40 micron/1.6 mils  
Flash point: 32 °C [89.6 °F]  
Specific gravity: 1.5 kg/litre [12.6 lbs/US gallon]  
Dry to touch: 4 approx. hour(s) 20°C/68°F  
8 (approx.) hrs at 10°C/50°F  
VOC content: 399 g/l [3.3 lbs/US gallon]

*\*other shades according to assortment list.*

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.*

**APPLICATION DETAILS:**

Application method: Airless spray / Air spray / Brush/Roller/Paint pad  
Thinner (max.vol.): 08081 (5%) / 08081 (15%) / 08081 (5%)  
Nozzle orifice: 0.018 - 0.023 "  
Nozzle pressure: 150 bar [2175 psi]  
(Airless spray data are indicative and subject to adjustment)  
Cleaning of tools: HEMPEL'S THINNER 08081  
Indicated film thickness, dry: 40 micron [1.6 mils] see REMARKS overleaf  
Indicated film thickness, wet: 75 micron [3 mils]  
Recoat interval, min: According to specification.  
Recoat interval, max: According to specification.

**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.



## HEMPEL'S ALUSAFE 7120D

### SURFACE PREPARATION:

**Existing old self-polishing or ablative antifouling:** Remove possible oil and grease etc. with suitable detergent (HEMPEL'S PRE-CLEAN 67602), followed by high pressure fresh water cleaning for a thorough removal of any possible weak structure of leached antifouling. Allow the surface to dry before coating.

**Sealer:** Whether to use a sealer coat/tiecoat or not depends on the type and condition of the existing antifouling.

### APPLICATION CONDITIONS:

The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. The temperature of the paint itself should be above:

15°C/59°F. Do not apply in direct sunlight.

In confined spaces provide adequate ventilation during application and drying.

### PRECEDING COAT

According to specification. Recommended systems are: HEMPEL'S UNDERWATER PRIMER 26030, HEMPEL'S LIGHT PRIMER 45551

### SUBSEQUENT COAT:

None.

### REMARKS:

This product contains heavy particles. Stir well before use.

### Film thicknesses/thinning:

Keep thinning to a minimum to ensure that correct film thickness is obtained.

### Recoating note:

Recommended number of coats:

Airless spray: 2-3 coats, Minimum: 120 micron total dry film thickness.

Air spray, Brush, Roller, Paint pad: 3-5 coats.

When used at speeds above 15 knots, an additional coat must be applied.

Launching: not before 24 hours after application of the last coat.

After painting, the product can be left out of water for up to: 3 months.

No maximum recoat interval, but after prolonged exposure to polluted atmosphere, remove accumulated contamination by high pressure fresh water cleaning and allow to dry before applying next coat.

### Note:

#### HEMPEL'S ALUSAFE 7120D

**The information given in the Product Data Sheet is intended for commercial use.**

### ISSUED BY:

HEMPEL A/S

7120D10000

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