

# Hempadur 37620

## Product characteristics

### Description

Hempadur 37620 is a two-component, amine cured phenolic epoxy paint, which cured to provide excellent resistance to acidic environments.

### Recommended use

For corrosion protection of steel in atmospheric acidic environments such as electrowinning plants, coking works, pickling shops, electroplating plants, dye mills, wood-pulp works, tanneries and oil refineries. Not intended for continuous contact or immersion with acidic solutions.

### Service temperature:

- Please consult the Chemical protection guide at [hempel.com](http://hempel.com).

## Product safety

**Flash point** 128°C [262°F]

### VOC content mixed product

Legislation	Value
EU	49 g/L [0.41 lb/US gal]
US (coatings)	49 g/L [0.41 lb/US gal]
US (regulatory)	49 g/L [0.41 lb/US gal]
China	49 g/L [0.41 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://hempel.com) or at your local Hempel website.

### Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

## Product data

### Product code

37620

### Product components

Base 37629  
Curing Agent 97620

### Standard shade / code

Grey 11621 \*

### Gloss

Glossy

### Volume solids

100%

### Specific gravity

1.3 kg/L [11 lb/US gal]

### Reference dry film thickness

250 micron [10 mils]

## Surface preparation

### Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

### New build:

- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

### Maintenance and Repair

- Spot abrasive blasting to min. P Sa 2½ (ISO 8501-2) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

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## Roughness

- Surface profile Coarse (G) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

## Application

### Mixing ratio

Base 37629 : Curing Agent 97620  
(2 : 1 by volume)

Stir well before use.

### Cleaner

Hempel's Tool Cleaner 99610

### Pot life

<b>Product temperature</b>	<b>30°C</b> [86°F]
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Pot life	30 min
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### Application method

Tool	Application parameters
Airless spray	Nozzle pressure: 250 bar [3600 psi] Nozzle orifice: 0.019-0.023"

Brush	Not Applicable.
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If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

## Film thickness

Specification range	Low	High	Recommended
Dry film thickness	250 micron [10 mils]	400 micron [16 mils]	250 micron [10 mils]
Wet film thickness	249 micron [10.0 mils]	399 micron [16 mils]	249 micron [10.0 mils]
Theoretical spreading rate	4 m <sup>2</sup> /L [163 sq ft/US gal]	2.5 m <sup>2</sup> /L [102 sq ft/US gal]	4 m <sup>2</sup> /L [163 sq ft/US gal]

## Application conditions

- Surface temperature must be above 10°C [50°F] during application and curing.
- Temperature of product must be above 15°C [59°F] during application.
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Optimal paint temperature for proper mixing, pumping and spraying is: 17-23°C [63-73°F].

## Drying and overcoating

### Product compatibility

- Previous coat: None or according to Hempel's specification.  
Recommended product is: Hempadur 37620
- Subsequent coat: None or according to Hempel's specification.  
Recommended product is: Hempadur 37620

### Drying time

Surface temperature	20°C	[68°F]
Hard dry	hours	6

Determined for dry film thickness 250 micron [10 mils] at standard conditions, see Hempel's Explanatory Notes for details.

### Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

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## Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

## Storage

### Shelf life

Ambient temperature	25°C [77°F]
Base	24 months
Curing Agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

### Storage conditions

- The product must be stored in accordance with Safety Data Sheet, label and local regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

## Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	6.7 g CO <sub>2</sub> e/m <sup>2</sup>	0.035 lb CO <sub>2</sub> e/ft <sup>2</sup>

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

## Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- General Application Guidelines

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at [www.hempel.com](http://www.hempel.com) (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from [www.hempel.com](http://www.hempel.com).

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.