



## HEMPADUR BPA FREE 37301

37301: BASE 37308: CURING AGENT 98300

<b>Description:</b>	HEMPADUR BPA FREE 37301 is an amine-cured, solvent-free epoxy coating which cures to a strong and smooth lining. It is Bisphenol A epoxy resin free and comply fully with the Federal Food, Drug, and Cosmetic Act and call applicable food additive regulations, including 21 C.F.R. § 175.300 ("Resinous and polymeric coatings").
<b>Recommended use:</b>	To be specified as a one coat system on internal surfaces of rail cars transporting liquid sugars, bulk quantities of dry food and/or plastic pellets for the manufacturing of food-contact materials.
<b>Service temperature:</b>	Maximum, dry exposure only: 120°C/248°F see REMARKS overleaf
<b>Availability:</b>	Not included in Group Assortment. Availability subject to special agreement.
<b>PHYSICAL CONSTANTS:</b>	
Shade nos/Colours:	3U090/Light blue
Finish:	Glossy
Volume solids, %:	96 ± 1
Theoretical spreading rate:	4 m <sup>2</sup> /l [160.4 sq.ft./US gallon] - 250 micron/10 mils
Flash point:	None.
Specific gravity:	1.4 kg/litre [11.9 lbs/US gallon]
Dry to touch:	12 hour(s) at 20°C/68°F 3 hour(s) at 50°C/122°F
Fully cured:	7 day(s) at 20°C/68°F
VOC content:	36 g/l [0.3 lbs/US gallon] <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
<b>APPLICATION DETAILS:</b>	
<b>Version, mixed product:</b>	<b>37301</b>
Mixing ratio:	BASE 37308: 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 5-10 minute(s) at 45°C/115°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]
Recoat interval, min:	According to specification.
Recoat interval, max:	According to specification.
<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.



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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 (ISO 8501-1:2007). Recommended surface profile is Rz 75-100 micron/3-4 mils, corresponding to Rugotest No. 3, BN10, 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 above the dew point to avoid condensation. The temperature of the substrate: maximum 45°C/113°F. The temperature of the paint itself should be: maximum 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.
Weathering/service temperatures:	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.
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 recoating interval.
Recoating 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.
Nota:	<b>HEMPADUR BPA FREE 37301 is for professional use only.</b>
ISSUED BY:	HEMPEL (USA), Inc.

37303U090

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on [www.hempel.com](http://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.

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