

Hempaline Defend 630

Cure 72

Product characteristics

Description

Hempaline Defend 630 is a solvent free high performance epoxy novolac lining with excellent chemical resistance to a wide range of chemicals and solvents. Hempaline Defend 630 may be applied as a one or two coat scheme, and as part of a hand lay or spray applied glass fibre reinforced system. Hempaline Defend 630 is available in a standard grade (Cure 72) and in a fast-return-to-service grade (Cure 24). Both offer the same high performance.

Recommended use

Hempaline Defend 630 is intended as a high performance tank lining for the storage of a wide range of petrochemicals including (but not limited to) crude oil up to 120°C [250°F], MTBE, produced water, alcohols, aromatic and aliphatic solvents, aviation fuels, gasoline blends, select acidic and caustic chemicals.

Service temperature:

- Maximum, dry exposure only: 150°C [302°F].
- Please contact Hempel for more information.
- Please consult the Chemical protection guide at hempel.com.

Product safety

Flash point 73°C [164°F]

VOC content mixed product

Legislation	Value
EU	21 g/L [0.18 lb/US gal]
US (coatings)	21 g/L [0.18 lb/US gal]
US (regulatory)	21 g/L [0.18 lb/US gal]
China	21 g/L [0.18 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, 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

37820

Product components

Base 37829
Curing Agent 9782S

Standard shade / code

Light blue 36641 *

Gloss

Semi-gloss

Volume solids

100%

Specific gravity

1.4 kg/L [12 lb/US gal]

Reference dry film thickness

500 micron [20 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.
- Concrete: According to Hempel's Specification.

New build:

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

Maintenance and Repair

- According to Hempel's Specification.

Roughness

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

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

* Slight discolouration may occur. This does not affect the performance of the coating.

Hempaline Defend 630

Cure 72

Application

Mixing ratio

Base 37829 : Curing Agent 9782S
(4 : 1 by volume)

Stir well before use. Thinning is not allowed.

Thinner

No thinning

Cleaner

Hempel's Tool Cleaner 99610

Pot life

Product temperature	10°C [50°F]	20°C [68°F]	30°C [86°F]
Pot life	80 min	50 min	20 min

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	No thinning	Nozzle pressure: 200 bar [2900 psi] Nozzle orifice: 0.021-0.029"
Brush/Roller	No thinning	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. As tank lining, brush and roller application must only be limited to stripe coating and touch up areas or minor repairs. 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	300 micron [12 mils]	750 micron [30 mils]	500 micron [20 mils]
Wet film thickness	300 micron [12 mils]	750 micron [30 mils]	500 micron [20 mils]
Theoretical spreading rate	3.3 m ² /L [130 sq ft/US gal]	1.3 m ² /L [53 sq ft/US gal]	2 m ² /L [81 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

Application conditions

- Optimal paint temperature for proper mixing, pumping and spraying is: 20-25 °C [68-77°F].
- 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.
- Surface temperature must be above 10°C [50°F] during application and curing.

Relative Humidity:

- Relative humidity must be below 80% during curing.

Drying and overcoating

Product compatibility

- Previous coat: None or according to Hempel's specification.
Recommended product is: Hempaline Prepare 130, Hempaline Prepare 110.
- Subsequent coat: None or according to Hempel's specification.
Recommended product is: Hempaline Defend 630

Drying time

Surface temperature		10°C [50°F]	20°C [68°F]	30°C [86°F]	40°C [104°F]
Touch dry	hours	8	4	2	1
Hard dry	hours	24	12	5	2½
Fully cured	days	7	3	2	1

Determined for dry film thickness 500 micron [20 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Hempaline Defend 630 Cure 72

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name	Immersion				
		10°C [50°F]	20°C [68°F]	30°C [86°F]	40°C [104°F]
Hempaline Defend	Min	24 h	16 h	16 h	16 h
630 Cure 72	Max	30 d	30 d	21 d	14 d

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

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.
- As tank lining, if the maximum overcoating interval is exceeded, roughening of the surface by sweep abrasive blasting is necessary to ensure intercoat adhesion".

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.
- Epoxy coatings have an inherent tendency of chalking, fading and discolouring. This does not affect the performance of the coating

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	12 months
Curing Agent	18 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

- Product must be stored according to local legislation, at maximum 40 °C [104°F], without direct sunlight and protected from rain and snow.
- Temperature must not go below 5°C [41°F] during transport and storage.

Hempaline Defend 630 Cure 72

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.
- Substrates.
- Surface Preparation.
- Application Instruction for this product.
- Repair & maintenance.
- Inspection & quality control.
- Tank linings.

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 (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 www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

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.

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.