



Coating Standards for Series 51I/52I ISO Series

Preparation:

Oil and grease are removed by use of emulsion cleaning. Salts and other contamination are removed by high pressure fresh water hosing or rinsing. When the surface is dry: Abrasive blasting to minimum Sa 2 1/2 according to ISO 8501-1:1988 with a surface profile corresponding to Rugotest No. 3 BN 9a. Dust off residues.

Coating:

Product Name	Shade / Color	Film thickness (dry) in microns
HEMPADUR 4514	Alu grey	80
HEMPADUR 4514 MIO	Redish grey	80
HEMPATHANE TOPCOAT 5520	as per customer choice	40
Total		200

HEMPADUR 4514:

As a two-component polyamide adducts cured epoxy, it possesses good wetting properties as well as low water permeability. Being self-priming, it is a hard and tough coating that offers good resistance against abrasion and impact. Furthermore, it also delivers good resistance against seawater, mineral oils, aliphatic hydrocarbons and splashes from petroleum and related products and poses no harm to grain cargos. Its uses are varied. HEMPADUR 4514 can be used as a high build primer, intermediate and/or finishing coat.

Max Seal Butterfly Valve Painting Process



**Prior to
First Coat**



**After
First Coat**



**After
Second Coat**



**After
Final Coat**

In addition to our standard coating, Max-Seal can supply a wide selection of special coatings

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HEMPADUR 4514 MIO:

The 4515 MIO layer Micaceous iron Oxide is iron oxide in a form that resembles mica. Micaceous iron oxide is a highly structured, layered mineral, termed lamellar; that is, the pigment particles have flat, plate-like shapes that act like tiny mirrors. These tiny mirrors reflect UV light, protecting the resin from degradation and give the coating an attractive “sparkle.” MIO pigment is outstanding for the protecting of steel. Additionally, the MIO structure provides a layer of coating, which can withstand bumps and scratches to a high extent.

HEMPATHANE TOPCOAT 55210:

A durable recoatable semi-gloss acrylic polyurethane finish. As a two-component polyurethane paint, it delivers superior resistance to water, impact and abrasion and gives an excellent UV protection. Below is a brief outline of its benefits.

Features	Benefits
Excellent gloss and color retention	Long lasting good appearance
Forms a hard and tough coating	Tolerates severely corrosive environments Resistant to impact and abrasion
Good resistance to spillage of chemicals	Excellent topcoat in industry environments
Forms a smooth surface	Easy to clean

It is suitable as a finishing coat for protection of structural steel in severely corrosive environments, where light-fastness and gloss retention are required.

Definition of corrosion categories:

Corrosion category	Example of environment - exterior	Example of environment - interior
C1 - very low		Heated buildings with clean atmospheres, e.g. offices, shops, schools, hotels
C2 - low	Atmospheres with low level of pollution. Mostly rural areas	Unheated buildings where condensation may occur, e.g. depots, sport halls
C3 - medium Max-Seal Standard Coating	Urban and industrial atmospheres, moderate sulfure, dioxide pollution. Coastal areas with low salinity.	Production rooms with high humidity and some air pollution e.g. food-processing plants, laundries, breweries, dairies
C4 - high	Industrial areas and coastal areas with medium salinity	Coastal plants, swimming pools, coastal shipyards and boatyards
C5 - I very high (industrial)	Industrial areas with high humidity and aggressive atmospheres	Buildings or areas with almost permanent condensation and with high pollution
C5 - M very high (marine)	Coastal and offshore areas with high salinity	Buildings or areas with almost permanent condensation and with high pollution



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