

15553: BASE 15557: CURING AGENT 98021

Description:	HEMPADUR 15553 is a two-component epoxy paint. It cures to a flexible, well adhering coating with good abrasion and impact resistance. Contains zinc phosphate. Cures down to -10°C/14°F.
Recommended use:	As a primer for systems on hot dipped galvanized, aluminium and stainless steel surfaces in moderately to severely corrosive environments. HEMPADUR 15553 is also suited when roughening of the surface is not possible. Please see surface preparation overleaf.
Service temperature:	Maximum, dry exposure only: 140°C/284°F
Certificates/Approvals:	Complies with European Fire Standard EN 13501-1; classification B-s1, d0. 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 for further details. Complies with EU Directive 2004/42/EC: subcategory j.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	11320 / Grey.
Finish:	Flat
Volume solids, %:	55 ± 1
Theoretical spreading rate:	11 m ² /l [441.1 sq.ft./US gallon] - 50 micron/2 mils
Flash point:	30 °C [86 °F]
Specific gravity:	1.5 kg/litre [12.5 lbs/US gallon]
Surface-dry:	20 minute(s) 20°C/68°F
Through-dry:	1.5 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	387 g/l [3.2 lbs/US gallon]
Shelf life:	6 months for BASE and 3 years for CURING AGENT (stored in closed container) (25°C/77°F) from time of production. Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F.

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

APPLICATION DETAILS:

Version, mixed product:	15553
Mixing ratio:	BASE 15557: CURING AGENT 98021 3 : 1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (5%)
Pot life:	2 hour(s) 20°C/68°F
Nozzle orifice:	0.017 - 0.019 "
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:	50 micron [2 mils]
Indicated film thickness, wet:	100 micron [4 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.
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SURFACE PREPARATION: **Stainless steel and aluminium:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Roughening of the surface is recommended for optimum adhesion.
Galvanised steel: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Zinc salts (white rust) must be removed by high pressure hosing combined with rubbing with a stiff nylon brush if necessary.
It is recommended to overcoat spray-metallised surfaces as soon as possible to avoid possible contamination.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. At the freezing point and below be aware of the risk of ice on the surface, which will hinder adhesion. Use only where application and curing can proceed at temperatures above: -10°C/14°F The temperature of the surface must also be above these limits. The temperature of the paint itself should be: 15-25°C/59-77°F In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT: According to specification. HEMPADUR, HEMPATANE, HEMPATEX

REMARKS:

Application(s): Ammonium chloride or any other passivation agent should not be present on the surface when coating the galvanized surface. Water should not be used for cooling down the steel. Cleaning of steel should not be initiated unless the steel temperature is below: 30°C/86°F As the galvanized zinc layer may be porous it is recommended to apply a mist coat of diluted product, allow air to escape, and then apply a full coat of the product a few minutes later.

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 overcoating interval. Normal range dry is: 50-80 micron/2.0-3.2 mils

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	27 h	Ext.	14 h	Ext.	3 h	Ext.
HEMPATEX	5 h	9 d	2 h	4½ d	30 m	24 h
HEMPATHANE	27 h	90 d	14 h	45 d	3 h	10 d

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

Overcoating note: In case of overcoating with coating other than HEMPADUR, apply a (thin) additional coat of the product within the described directions for overcoating. 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.** Water jetting may be relevant to remove any degraded surface layer and may also replace the above mentioned cleaning methods when properly executed. Consult HEMPEL for specific advice if in doubt. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.

Note: **HEMPADUR 15553 For professional use only.**

ISSUED BY: HEMPEL A/S 1555311320

This Product Data Sheet supersedes those previously issued. For explanations, definitions and scope, see "Explanatory Notes" available on 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. The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.