

# HEMPADUR\* PRIMER 1530o/ HEMPADUR\* PRIMER 15302

High temperatures: 15300 with CURING AGENT 95040  
Low to medium temperatures: 15302 with CURING AGENT 95570

<b>Description:</b>	HEMPADUR PRIMER 1530 is a two-component epoxy primer containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rust-preventing coating. Is also suited for application under humid conditions, on damp steel surfaces and may be applied on moist surfaces. For definitions, see REMARKS overleaf.	
<b>Recommended use:</b>	<ol style="list-style-type: none"><li>1. As a general purpose primer for HEMPADUR and HEMPATANE systems on steel and other metal surfaces in moderately to severely corrosive environment.</li><li>2. As a blast primer for temporary protection of steel blast cleaned on site.</li><li>3. As a primer or intermediate coat in container systems.</li></ol> CURING AGENT 95040, polyamide, is typically for use in tropical and subtropical climates. CURING AGENT 95570, polyamide adduct, facilitates low temperature curing, but is especially suited for shop coat application with short recoating intervals. HEMPADUR 1557 will usually be used as an alternative primer/blast primer in cold and temperate climate.	
<b>Service temperatures:</b>	Dry: maximum: 140°C/284°F	In water (no temperature gradient): 35°C/95°F
<b>Approvals, certificates:</b>	Approved as a low flame spread material by Nippon Kaiji Kyokai, Japan and See-Berufgenossenschaft, Germany. Approved as a welding primer by Lloyd's Register of Shipping.	
<b>Availability:</b>	Subject to confirmation.	

## PHYSICAL CONSTANTS:

Version; mixed product:	<b>15300</b>	<b>15302</b>
Colours/Shade nos:	Red/50890*	Red/50890*
Finish:	Flat	Flat
Volume solids:	51%	51%
Theoretical spreading rate:	10.2 m²/litre - 50 micron 409 sq.ft./US gallon - 2 mils	10.2 m²/litre - 50 micron 409 sq.ft./US gallon - 2 mils
Flash point:	26°C/79°F	26°C/79°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	2 (approx.) hrs at 20°C/68°F (ISO 1517)	1½ (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	3-4 hours at 20°C/68°F	2-3 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
V.O.C.:	452 g/litre - 3.8 lbs/US gallon	447 g/litre - 3.7 lbs/US gallon

\*Another shade: grey 12170 according to assortment list.

*The physical constants are subject to normal manufacturing tolerances.  
Further reference is made to "Explanatory Notes" in the Hempel Book.*

## APPLICATION DETAILS:

	<b>15300</b>	<b>15302</b>
Mixing ratio:	Base 15309 : Curing agent 95040 4 : 1 by volume	Base 15309 : Curing agent 95570 4 : 1 by volume
Application method:	Airless spray    Air spray    Brush	
Thinner (max.vol.):	0845 (5%)    0845 (15%)    0845 (5%)	
Pot life:	8 hours (20°C/68°F) ( <i>airless</i> ) 8 hours (20°C/68°F) ( <i>brush</i> )	4 hours (20°C/68°F) ( <i>airless</i> ) 6 hours (20°C/68°F) ( <i>brush</i> )
Nozzle orifice:	.021"	
Nozzle pressure:	175 bar/2500 psi ( <i>Airless spray data are indicative and subject to adjustment</i> )	
Cleaning of tools:	HEMPEL'S TOOL CLEANER 9961	
Indicated film thickness, dry:	50 micron/2 mils ( <i>See REMARKS overleaf</i> )	
Indicated film thickness, wet:	100 micron/4 mils	
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS	
Recoat interval, max:	As per separate APPLICATION INSTRUCTIONS	

Issued: October 1997

## 2. HEMPADUR PRIMER 15300/15302

SURFACE PREPARATION:	<p><b>New steel:</b> Abrasive blasting to Sa 2½, SSPC-SP-10. For temporary protection, if required, use suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use HEMPADUR PRIMER 1530.</p> <p><b>Other metals and light alloys:</b> Thorough degreasing and light abrasive sweeping to remove all contamination, and to secure adhesion.</p> <p><b>Repair and maintenance:</b> Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of HEMPADUR PRIMER 1530. As an alternative to dry cleaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of maximum FR-2 (Hempel standard) is acceptable before application. Feather edges to sound intact areas. Dust off residues. Touch up to full film thickness. On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.</p> <p>In case of wet abrasive blasting a suitable inhibitor e.g. an amine type may be used. Surplus inhibitor and residual abrasives and sludge must be removed by high pressure fresh water cleaning before recoating. Cleaning with hot water is recommended.</p>
APPLICATION CONDITIONS:	<p><b>Note:</b> Inhibitors are generally not recommended for surfaces which will be immersed.</p> <p>Use only where application and curing can proceed at temperatures above -10°C/14°F (CURING AGENT 95570) and above +10°C/50°F (CURING AGENT 95040).</p> <p>At the freezing point and below be aware of ice on the surface, which will hinder the adhesion. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p>
SUBSEQUENT COAT:	HEMPADUR 1513, HEMPADUR HI-BUILD 4520, HEMPATEX HI-BUILD 4637 or according to specification.
REMARKS:	<p><b>Definition: Damp/moist/wet surfaces:</b></p> <p><b>Damp surface:</b> Surface on which water is not readily detectable, but the temperature of the surface is below the dew point.</p> <p><b>Moist surface:</b> Surface from which standing water and droplets have been removed, but on which there is a noticeable film of water.</p> <p><b>Wet surface:</b> Surface on which droplets or standing water is present.</p> <p><b>Note:</b> Occurrence of pools of water or droplets on the painted surface immediately after application may result in discolouration.</p>
Service temperatures:	Even though the service temperature is kept below the specified maximum, it should be noted that the higher the temperature, the more sensitive the paint will be to mechanical and/or chemical exposure. Combined thermal/mechanical and/or chemical exposure may therefore increase the risk of damage.
Film thicknesses:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and will influence the amount of thinning necessary, drying time and recoating interval. Normal range dry is 25-75 micron/1-3 mils. Please also consult APPLICATION INSTRUCTIONS.</p> <p>If used as a blast primer, the optimum film thickness is approximately 40 micron/1.6 mils. Additional thinning may be necessary for this purpose.</p>
Recoating:	<p>Recoating intervals related to later conditions of exposure: Consult separate APPLICATION INSTRUCTIONS.</p> <p>Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry.</p> <p>If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.</p>
Note: SAFETY:	<p><b>HEMPADUR PRIMER 1530 is for professional use only.</b></p> <p>Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Material Safety Data Sheets and follow all local or national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.</p>

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. 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.

Issued by HEMPEL'S MARINE PAINTS A/S.

\*This is a corporate trademark of the Hempel Group.

October 1997 - 1530050890CO003  
1530250890CO001