

APPLICATION INSTRUCTIONS

For product description refer to product data sheet

HEMPADUR* PRIMER 15300/ HEMPADUR* PRIMER 15302

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

Film thickness:	Depending on the area of use the typical dry film thickness may vary between 25 micron/1 mil and up to 75 micron/3 mils. This will alter amount of thinning needed, spreading rate, drying time and recoating interval as described below. Indicated film thicknesses are as follows:
Intermediate coat, container systems:	When used as an intermediate coat on zinc (shop) primer in container systems a typical dry film thickness is 25 micron/1 mil. Dilute 10-25% for airless spray, corresponding wet film thickness 50-75 micron/2-3 mils.
Primer, container systems:	When used as a primer in container systems, e.g. refurbishment or on phosphatized steel, dry film thickness is approx. 40 micron/1.6 mils corresponding to 75-100 micron/3-4 mils wet film thickness. Dilute 5-10% for airless spray.
General purpose Primer:	When used as a general purpose primer, dry film thickness is 50-75 micron/2-3 mils corresponding to 100-150 micron/4-6 mils wet film thickness. Thinning is normally not necessary.
Spreading rates:	<p>The film thickness and the spreading rate are inversely proportional. By controlling the spreading rate, a check of the film thickness can be made.</p> <p>Theoretical spreading rate calculated for undiluted paint, at:</p> <p>25 micron/1 mil is 20.4 m²/litre or 818 sq.ft./US gallon 40 micron/1.6 mils is 12.8 m²/litre or 511 sq.ft./US gallon 50 micron/2 mils is 10.2 m²/litre or 409 sq.ft./US gallon 75 micron/3 mils is 6.8 m²/litre or 273 sq.ft./US gallon</p>
Thinners:	<p>Airless spray: THINNER 0845 maximum approx. 25% by volume. Lowest nozzle pressure should be used when highest amount of thinner is added. THINNER 0857 is used for fast setting at application in shops. (Be aware of increased risk of dry spray).</p> <p>Air spray: THINNER 0845, up to approx. 50% by volume.</p> <p>Application by brush: THINNER 0845, up to approximately 5-10% by volume.</p>

**Physical data
versus temperature:**

Drying time and recoating interval vary with film thickness, curing agent used, drying/curing temperature and later exposure conditions:

15300 (CURING AGENT 95040):

Surface temperature	10°C/50°F			20°C/68°F			30°C/86°F		
Dry film thickness, micron	25	40	75	25	40	75	25	40	75
Drying time, approx minutes	75	2½ h	7 h	30	1 h	2½ h	20	40	2 h
Curing time, approx days	18	18	18	7	7	7	4	4	4
Minimum recoating interval related to later conditions of exposure:									
Interval for recoating with 4633, 4637, 4641, 4664, 5803 (5803: 1530 in a dft of 40 micron or less)									
Atmospheric	40 min	1 h	2½ h	15 min	25 min	1 h	7 min	15 min	30 min
Medium	2 h	4½ h	7½ h	45 min	1½ h	3 h	25 min	45 min	1½ h
Severe	5 h	10 h	20 h	2 h	4 h	8 h	1 h	2 h	4 h
Immersion*									
Interval for recoating with HEMPADUR and HEMPATANE qualities									
Atmospheric	5 h	9 h	18 h	2 h	3½ h	7 h	1 h	1½ h	3½ h
Medium	6 h	13 h	25 h	2½ h	5 h	10 h	1½ h	2½ h	5 h
Severe	9 h	15 h	35 h	3½ h	6 h	13½ h	2 h	3 h	7 h
Immersion**									
Maximum recoating interval related to later conditions of exposure:									
Interval for recoating with 4633									
Atmospheric	4 d	4 d	4 d	36 h	36 h	36 h	18 h	18 h	18 h
Medium	2½ d	2½ d	2½ d	24 h	24 h	24 h	12 h	12 h	12 h
Severe	40 h	40 h	40 h	16 h	16 h	16 h	8 h	8 h	8 h
Immersion									
Interval for recoating with 4637, 4641, 4664									
Atmospheric	2½ d	2½ d	2½ d	24 h	24 h	24 h	12 h	12 h	12 h
Medium	45 h	45 h	45 h	18 h	18 h	18 h	9 h	9 h	9 h
Severe	NR	NR	NR	NR	NR	NR	NR	NR	NR
Immersion									
Interval for recoating with 5803									
Atmospheric	10 d	10 d	10 d	4 d	4 d	4 d	2 d	2 d	2 d
Medium	5 d	5 d	5 d	2 d	2 d	2 d	1 d	1 d	1 d
Severe	NR	NR	NR	NR	NR	NR	NR	NR	NR
Immersion									
Interval for recoating with HEMPADUR qualities									
Atmospheric	None	None	None	None	None	None	None	None	None
Medium	75 d	75 d	75 d	30 d	30 d	30 d	15 d	15 d	15 d
Severe***	75 d	75 d	75 d	30 d	30 d	30 d	15 d	15 d	15 d
Immersion***									
Interval for recoating with HEMPATHANE qualities									
Atmospheric	25 d	25 d	25 d	10 d	10 d	10 d	5 d	5 d	5 d
Medium	7½ d	7½ d	7½ d	3 d	3 d	3 d	1½ d	1½ d	1½ d
Severe	NR	NR	NR	NR	NR	NR	NR	NR	NR
Immersion									

* Only 4633 is recommended for this exposure.

** NOT relevant for HEMPATANE qualities.

*** If the coating has been subjected to direct sunlight for a short period only, the maximum recoating interval may be prolonged.

**Physical data
versus temperature:**

Drying time and recoating interval vary with film thickness, curing agent used, drying/curing temperature and later exposure conditions:

15302 (CURING AGENT 95570):

Surface temperature	-10°C/14°F		0°C/32°F		10°C/50°F		20°C/68°F		30°C/86°F	
Dry film thickness, micron	25	40	25	40	25	40	25	40	25	40
Drying time, approx minutes	3 h	5 h	1 h	2 h	30	1 h	15	30	10	20
Curing time, approx days	2 months		1 month		14		7		5	
Minimum recoating interval related to later conditions of exposure:										
Interval for recoating with 4633, 4637, 4641, 4664, 5803 (10°C/50°F or higher), minutes										
Atmospheric										
Medium	1½ h	2½ h	30	1 h	15	30	7	15	5	10
Severe	3 h	5 h	1 h	2 h	30	1 h	15	30	10	20
Immersion*	10 h	18 h	4 h	8 h	2 h	4 h	1 h	2 h	30	1 h
Interval for recoating with HEMPADUR and HEMPATANE qualities, hours										
Atmospheric										
Medium	4½	9	2½	4½	1	2	30min	1	25min	45min
Severe	9	18	4½	9	2	4	1	2	45min	1½
Immersion**	27	54	13½	27	6	12	3	6	2½	4½
Maximum recoating interval related to later conditions of exposure:										
Interval for recoating with 4637, 4641, 4664, hours										
Atmospheric										
Medium	3 d	3 d	36	36	16	16	8	8	6	6
Severe	45 h	45 h	23	23	10	10	5	5	4	4
Immersion	NR	NE	NR	NR	NR	NR	NR	NR	NR	NR
Interval for recoating with 4633, hours										
Atmospheric										
Medium	4½ d	4½ d	54	54	24	24	12	12	9	9
Severe	3 d	3 d	36	36	16	16	8	8	6	6
Immersion	3 d	3 d	36	36	16	16	8	8	6	6
Interval for recoating with 5803										
Atmospheric										
Medium	NR	NR	NR	NR	6 d	6 d	3 d	3 d	54 h	54 h
Severe	NR	NR	NR	NR	3 d	3 d	1½ d	1½ d	27 h	27 h
Immersion	NR	NR	NR	NR	NR	NR	NR	NR	NR	NR
Interval for recoating with HEMPADUR qualities										
Atmospheric										
Medium	None	None	None	None	None	None	None	None	None	None
Severe***	(90 d)	(90 d)	90 d	90 d	60 d	60 d	30 d	30 d	20 d	20 d
Immersion***	(90 d)	(90 d)	90 d	90 d	60 d	60 d	30 d	30 d	20 d	20 d
Interval for recoating with HEMPATHANE qualities										
Atmospheric										
Medium	90 d	90 d	45 d	45 d	20 d	20 d	10 d	10 d	7½ d	7½ d
Severe	30 d	30 d	15 d	15 d	6 d	6 d	3 d	3 d	2 d	2 d
Immersion	NR	NR	NR	NR	NR	NR	NR	NR	NR	NR

* Only 4633 is recommended for this exposure.

** NOT relevant for HEMPATANE qualities.

*** If the coating has been subjected to direct sunlight for a short period only, the maximum recoating interval may be prolonged.

The minimum recoating intervals assume sufficient ventilation and correct application. In case of forced ventilation and/or drying at higher temperatures, sufficient "flash-off" time should be allowed for. For approximately 25 micron/1 mil dry film thickness count for minimum 10 minutes flash-off (at 20°C/67°F), for approximately 40 micron/1.6 mil minimum 20 minutes, for approximately 75 micron/3 mils minimum 45 minutes.

The short minimum recoating intervals when overcoated with 4633, 4637, 4641, 4664 are provided only in case the finished paint system is through dry before exposure to aggressive environments.

If the maximum recoating interval is exceeded, whatever the subsequent coat, roughening of the surface is necessary to ensure optimum intercoat adhesion.

Before recoating after exposure in contaminated environment, irrespective of recoating interval, clean the surface thoroughly e.g. by (high pressure) fresh water hosing and allow to dry.

Safety:

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.

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

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October 1997/15300-15302 - Page 4 of 4