

HEMPADUR* 15400

CURING AGENT 95100

Description: HEMPADUR 1540 is a two-component, amine adduct cured epoxy paint, which cures to a coating with excellent resistance to a wide range of chemicals as tabulated in separate CARGO PROTECTION GUIDE.
Specialized CARGO PROTECTION GUIDE can be tailored for new constructions as well as for major repair/refurbishment.

Recommended use: As a tank lining according to the selected PAINTING SPECIFICATION.

Service temperatures:

	Dry:	In water (no temperature gradient):
Maximum:	140°C/284°F	50°C/122°F

Wet service temperatures, other liquids:
Consult the corresponding CARGO PROTECTION GUIDE.

Approvals, certificates: Complies with Section 175.300 of U.S. Federal Regulations in respect of carriage of dry and wet foodstuffs.
Accepted by Lloyd's Register of Shipping as a recognized corrosion control coating.
Accepted by Kuwaiti, Chinese and Norwegian authorities for fresh water tanks.
Approved as a low flame spread material by Nippon Kaiji Kyokai, Japan.
Tested for non-contamination of grain cargo at the Newcastle Occupational Health Agency, Great Britain.
Tested for non-toxicity of welding fumes by the Danish Welding Institute.

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	White/10000	Light red/50900
Finish:	Semi-flat	Semi-flat
Volume solids:	48%	48%
Theoretical spreading rate:	6.0 m ² /litre - 80 micron 241 sq.ft./US gallon - 3.2 mils	6.0 m ² /litre - 80 micron 241 sq.ft./US gallon - 3.2 mils
Flash point:	26°C/79°F	26°C/79°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon	1.4 kg/litre - 11.7 lbs/US gallon
Surface dry:	3 (approx.) hrs at 20°C/68°F (ISO 1517)	3 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	8-10 hours at 20°C/68°F	8-10 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.:	461 g/litre - 3.8 lbs/US gallon	464 g/litre - 3.9 lbs/US gallon

Shelf life: 1 year from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

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

APPLICATION DETAILS:

Mixing ratio for 15400: Base 15409 : Curing agent 95100
4 : 1 by volume

Application method:	Airless spray	Brush (touch-up)
Thinner (max.vol.):	0845 (5%)	0845 (5%)
Pot life:	2 hours (20°C/68°F)	4 hours (20°C/68°F)
Nozzle orifice:	.021"	
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	HEMPEL'S TOOL CLEANER 9961	
Indicated film thickness, dry:	80 micron/3.2 mils (See REMARKS overleaf)	
Indicated film thickness, wet:	175 micron/7 mils	
Recoat interval, min:	10 hours (20°C/68°F)	
Recoat interval, max:	As per CARGO PROTECTION GUIDE and corresponding painting specification	

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SURFACE PREPARATION:	For optimum performance to the full range of chemicals in accordance with the main CARGO PROTECTION GUIDE, abrasive blasting to very near white metal Sa 2½-3, SSPC-SP-10-5, with a surface profile corresponding to Rugotest No. 3, BN10, Keane-Tator Comparator, 3.0 G/S, or ISO Comparator, Rough Medium (G). (Please do also see Notes under REMARKS).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the surface and that of the paint itself must also be above this limit. Optimum results are obtained at 17-23°C/60-75°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 80%, preferably 40-60%. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None, or as per specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Film thicknesses:	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 recoating interval. Normal range is 80-125 micron/3.2-5 mils.
Recoating:	If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Curing:	Do not put tanks into service until the paint system is completely cured - consult the corresponding CARGO PROTECTION GUIDE and APPLICATION INSTRUCTIONS. Before taking tank into use for drinking water, it is a must that all solvents are evaporated and that the system is fully cured. It is furthermore recommended to fill the tank twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water, please see APPLICATION INSTRUCTIONS.
Notes:	This datasheet outlines the main guidelines and recommendations. For details the corresponding PAINTING SPECIFICATION must be consulted and strictly adhered to during execution of the work. The CARGO PROTECTION GUIDE and the corresponding PAINTING SPECIFICATION may be tailored to meet other conditions than stipulated above. Such adjustments may include the degree of surface preparation, conditions of application, dry film thickness, and recoating interval.
HEMPADUR 1540 is for professional use only.	
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. 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.
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Issued by HEMPEL'S MARINE PAINTS A/S.

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