

HEMPADUR* 15500

CURING AGENT 97580

Description: HEMPADUR 1550 is a two-component, amine adduct cured phenolic epoxy (novolac) paint, which cures to a coating with excellent resistance to a wide range of chemicals as tabulated in separate CARGO PROTECTION GUIDE.

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

Service temperatures:

	Dry:	In water (no temperature gradient):
Maximum:	160°C/320°F	50°C/122°F

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

Approvals: Approved for potable water by Water Research Centre, Great Britain.
Complies with Section 175.300 of the Code of Federal Regulations in respect of carriage of foodstuffs (FDA) for tanks larger than 2006 m³/530,000 US gallon

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Off-white/11630 - Light red/50900
Finish:	Flat
Volume solids:	68%
Theoretical spreading rate:	6.8 m ² /litre - 100 micron 273 sq.ft./US gallon - 4 mils
Flash point:	26°C/79°F
Specific gravity:	1.7 kg/litre - 14.2 lbs/US gallon
Surface dry:	2-3 hrs at 20°C/68°F (ISO 1517)
Dry to touch:	6 (approx.) hours at 20°C/68°F
Fully cured:	10 days at 20°C/68°F (See REMARKS overleaf)
V.O.C.:	322 g/litre - 2.7 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 15500:	Base 15509 : Curing agent 97580 8.9 : 1.1 by volume 93.8 : 6.2 by weight
Application method:	Airless spray Brush (touch-up)
Thinner (max.vol.):	0845 0845 (See APPLICATION INSTRUCTIONS)
Pot life:	3 hours (20°C/68°F)
Induction time:	15 minutes (20°C/68°F) (see REMARKS overleaf)
Nozzle orifice:	.018"-.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:	100 micron/4 mils (See REMARKS overleaf)
Indicated film thickness, wet:	150 micron/6 mils
Recoat interval, min:	36/24 hours (20°C/68°F) (See REMARKS overleaf)
Recoat interval, max:	21 days (20°C/68°F) (See REMARKS overleaf)

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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). Consult separate APPLICATION INSTRUCTIONS..
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself must be above 15°C/59°F, best results are obtained at 17-23°C/62-73°F. Relative humidity max. 80%, preferably 40-60%. Apply on a dry and clean surface with a temperature above the dew point to avoid condensation. Provide adequate ventilation during application and drying in confined spaces. Consult separate APPLICATION INSTRUCTIONS.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
Film thicknesses:	Minimum total dry film thickness for the system is 300 micron/12 mils. May be specified in higher film thickness than indicated depending on purpose and area of use. This will alter spreading rate and influence drying time. For further information about film thicknesses, see separate APPLICATION INSTRUCTIONS.
Recoating:	Minimum: Use in contact with potable water: 3 days (20°C/68°F between each coat Use without contact with potable water: 36 hours (20°C/68°F) between 1 and 2 coat 24 hours (20°C/68°F) between 2 and 3 coat Maximum: 21 days (20°C/68°F) Roughening of the surface is necessary if the maximum recoating interval is exceeded.
Mixing:	The thoroughly mixed BASE and CURING AGENT must be prereacted before application (15 minutes at 20°C/68°F), at other temperatures, please see APPLICATION INSTRUCTIONS.
Thinning:	Keep thinning at an absolute minimum. Do not dilute the components separately - only the mixture.
Curing:	Resistance to the widest range of cargoes is provided by additional heat curing, see APPLICATION INSTRUCTIONS and CARGO PROTECTION GUIDE.
Note:	HEMPADUR 1550 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.

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.

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