

HEMPADUR* 15550

CURING AGENT 95360
GALVOGRIP

Description:	HEMPADUR 1555 is a two-component polyamide adduct-cured epoxy paint. It cures down to -10°C/14°F to a strong coating with good adhesion properties.
Recommended use:	As a primer for HEMPATEX, HEMPADUR and HEMPATANE systems on hot dipped galvanized surfaces. In moderately corrosive environments, HEMPADUR 1555 is also suited when roughening of the surface is not possible. Please see surface preparation overleaf.
Service temperatures:	Maximum, dry: 140°C/284°F.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red/50890
Finish:	Flat
Volume solids:	43%
Theoretical spreading rate:	8.6 m ² /litre - 50 micron 345 sq.ft./US gallon - 2 mils
Flash point:	22°C/72°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon
Surface dry:	¾ (approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch:	2 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	515 g/litre - 4.3 lbs/US gallon

*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 15550:	Base 15559 : Curing agent 95360 7 : 1 by volume
Application method:	Airless spray Brush
Thinner (max.vol.):	0845 (5%) 0845 (5%)
Pot life:	2 hours (20°C/68°F)
Nozzle orifice:	.021"
Nozzle pressure:	175 bar/2450 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:	125 micron/5 mils
Recoat interval, min:	See REMARKS overleaf
Recoat interval, max:	See REMARKS overleaf

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SURFACE PREPARATION: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. "White rust" must be removed by sandpapering or light abrasive sweeping.
In certain cases - related to the structure of the outer zinc layer - roughening of the galvanized surfaces will be necessary to secure adhesion.
Concerning galvanizing it is recommended that fluxing takes place before dipping steel in the zinc kettle.

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 this limit.
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: HEMPADUR, HEMPATANE or HEMPATEX qualities according to specification.

REMARKS:

Passivation: 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.

Application: 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 undiluted HEMPADUR 1555, allow air to escape, and then apply a full coat of HEMPADUR 1555 a few minutes later.

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 dry is 50-80 micron/2-3.2 mils.

Recoating: Recoating intervals related to later conditions of exposure:

	Minimum			Maximum		
Surface temperature	20°C/68°F			20°C/68°F		
	Atmospheric			Atmospheric		
Overcoated with	Mild	Medium	Severe	Mild	Medium	Severe
HEMPATEX	15 minutes	15 minutes	2 hours	None	24 hours	12 hours
HEMPADUR	2 hours	2 hours	6 hours	None	None°	30 days**
HEMPATHANE	2 hours	2 hours	6 hours	None	10 days°	3 days

°Except for mild climatic conditions avoid long-term exposure of galvanized steel only coated with a thin layer of paint as this may create white rust **under** the paint.

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

Periodical and permanent immersion in water is not recommended.

If the maximum recoating interval is exceeded, the surface must be roughened by light sweeping with fine abrasive or in another way roughened to ensure proper adhesion.

In contaminated environments, the surface should be cleaned carefully by high pressure fresh water cleaning.

Note: **HEMPADUR 1555 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.

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