

HEMPADUR* 15570

CURING AGENT 95570

Description:

HEMPADUR 1557 is a two component, polyamide-adduct cured epoxy paint, which cures to a strong and highly corrosion resistant coating, at temperatures down to -10°C/14°F. The Micaceous Iron Oxide pigmented light grey 12430 quality is also well suited for application under humid conditions, on damp steel surfaces, and may be applied on moist surfaces.

Recommended use:

1. As a maintenance and repair primer, intermediate, and/or finishing coat in HEMPADUR systems in severely corrosive environment. As a finishing coat where a cosmetic appearance is of less importance.
2. As a low temperature curing epoxy primer, intermediate, and/or finishing coat in paint systems according to specification. Well suited as a primer in coal tar epoxy systems.

In warm climate HEMPADUR PRIMER 1530 may be used as an alternative to HEMPADUR 1557.

Service temperatures:

	Dry:	In water (no temperature gradient):
Maximum:	140°C/284°F	35°C/95°F
See REMARKS overleaf.		

Approvals, certificates:

Tested for non-contamination of grain cargoes at the Newcastle Occupational Health Agency, Great Britain.

Availability:

Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Light grey/12430* (MIO) - Red/50630*
Finish:	Flat
Volume solids:	54%
Theoretical spreading rate:	5.4 m ² /litre - 100 micron 217 sq.ft./US gallon - 4 mils
Flash point:	25°C/77°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon
Dry to touch:	3-4 (approx) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	430 g/litre - 3.6 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:

Mixing ratio for 15570:	Base 15579 : Curing agent 95570 3 : 1 by volume		
Application method:	Airless spray	Air Spray	Brush
Thinner (max. vol.):	0845 (5%)	0845 (15%)	0845 (5%)
Pot life:	2 hours (20°C/68°F)		
Nozzle orifice:	.019"-.021"		
Nozzle pressure:	175 bar/2500 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:	200 micron/8 mils		
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS		
Recoat interval, max:	As per separate APPLICATION INSTRUCTIONS		

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SURFACE

PREPARATION:

New steel (dry conditions): Abrasive blasting to Sa 2½. 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 1557.

Light alloys: Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion - surface profile depending on later exposure.

Stainless steel: (Eg ballast tanks of chemical carriers) to be abrasive blast cleaned to a uniform, sharp, dense profile (Rugotest No. 3, BN10, ISO Comparator Medium (G), Keane-Tator Comparator 3.0 G/S). Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.

Maintenance: 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 minimum Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of HEMPADUR 1557. As an alternative to dry cleaning, water jetting to minimum WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of FR-1 maximum FR-2 (Hempel standard) is acceptable before application. Feather edges to sound and intact areas. Dust off residues. Touch up bare spots to full film thickness when the surface has reached the condition of being damp, may be moist.

Damp surfaces: Water is not readily detectable, but the temperature of the surface is below the dew point.

Moist surfaces: pools of water and droplets have been removed, but there is a noticeable film of water.

Wet surfaces: Droplets or pools of water are present).

For major repair work/new steel (humid conditions): Dry or wet abrasive blasting to Sa 2½. In case of wet abrasive blasting a suitable inhibitor 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.

Note: Inhibitors are generally not recommended for surfaces which will be immersed.

Use only where curing can proceed at temperatures above -10°C/14°F.

APPLICATION CONDITIONS:

At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion.

The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties.

In confined spaces provide adequate ventilation during application and drying.

Occurrence of standing water or droplets on the painted surface immediately after application may result in discolouration.

PRECEDING

COAT:

SUBSEQUENT

None, or according to specification.

None, HEMPADUR, HEMPATANE, HEMPANYL, HEMPATEX or HEMUCRYL as per specification.

COAT:

REMARKS:

Weathering:

Service

temperatures:

A tendency to chalk in outdoor exposure does not detract from the protective properties.

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:

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 50-125 micron/2-5 mils.

Recoating:

Recoating intervals related to later conditions of exposure: Consult separate APPLICATION INSTRUCTIONS.

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

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

Note:

SAFETY:

HEMPADUR 1557 is for professional use only.

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.

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.

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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.