

# APPLICATION INSTRUCTIONS

For product description refer to the product data sheet

## HEMPADUR\* 15570

CURING AGENT 95570

### Physical data versus temperature:

Drying time and recoating interval vary with film thickness, temperature and later exposure conditions, thus: **In-field application:**  
(100 micron/4 mils dry film thickness of HEMPADUR 1557)

|   |              |              |           |           |           |
|---|--------------|--------------|-----------|-----------|-----------|
| Surface temperature   | -10°C/14°F   | 0°C/32°F     | 10°C/50°F | 20°C/68°F | 30°C/86°F |
| Drying time, approx   | 36 hours     | 16 hours     | 8 hours   | 4 hours   | 3 hours   |
| Curing time, approx   | 2 months     | 1 month      | 14 days   | 7 days    | 5 days    |
| <b>Minimum recoating interval related to later conditions of exposure:</b>                |              |              |           |           |           |
| <b>Interval for recoating with<br/>4633, 4637, 4641, 4664, 5803 (10°C/50°F or higher)</b> |              |              |           |           |           |
| Atmospheric   |              |              |           |           |           |
| Medium  | 18 hours     | 9 hours      | 4 hours   | 2 hours   | 1½ hours  |
| Severe  | 36 hours     | 18 hours     | 8 hours   | 4 hours   | 3 hours   |
| Immersion*  | 36 hours     | 18 hours     | 8 hours   | 4 hours   | 3 hours   |
| <b>Interval for recoating with<br/>HEMPADUR and HEMPATANE qualities</b>                   |              |              |           |           |           |
| Atmospheric   |              |              |           |           |           |
| Medium  | 36 hours     | 18 hours     | 8 hours   | 4 hours   | 3 hours   |
| Severe  | 36 hours     | 18 hours     | 8 hours   | 4 hours   | 3 hours   |
| Immersion**   | 3 days       | 36 hours     | 16 hours  | 8 hours   | 6 hours   |
| <b>Maximum recoating interval related to later conditions of exposure:</b>                |              |              |           |           |           |
| <b>Interval for recoating with<br/>4637, 4641, 4664</b>                                   |              |              |           |           |           |
| Atmospheric   |              |              |           |           |           |
| Medium  | 3 days       | 36 hours     | 16 hours  | 8 hours   | 6 hours   |
| Severe  | 2 days       | 23 hours     | 10 hours  | 5 hours   | 4 hours   |
| <b>Interval for recoating with<br/>4633</b>   |              |              |           |           |           |
| Atmospheric   |              |              |           |           |           |
| Medium  | 4½ days      | 54 hours     | 24 hours  | 12 hours  | 9 hours   |
| Severe  | 3 days       | 36 hours     | 16 hours  | 8 hours   | 6 hours   |
| Immersion*  | 3 days       | 36 hours     | 16 hours  | 8 hours   | 6 hours   |
| <b>Interval for recoating with<br/>5803</b>   |              |              |           |           |           |
| Atmospheric   |              |              |           |           |           |
| Medium  | Not relevant | Not relevant | 6 days    | 3 days    | 1½ days   |
| Severe  | Not relevant | Not relevant | 3 days    | 1½ days   | 1 days    |
| <b>Interval for recoating with<br/>HEMPADUR qualities</b>                                 |              |              |           |           |           |
| Atmospheric   |              |              |           |           |           |
| Medium  | None         | None         | None      | None      | None      |
| Severe***   | (90 days)    | (90 days)    | 60 days   | 30 days   | 23 days   |
| Immersion***  | (90 days)    | (90 days)    | 60 days   | 30 days   | 23 days   |
| <b>Interval for recoating with<br/>HEMPATHANE qualities</b>                               |              |              |           |           |           |
| Atmospheric   |              |              |           |           |           |
| Medium  | 90 days      | 45 days      | 20 days   | 10 days   | 5 days    |
| Severe  | 27 days      | 14 days      | 6 days    | 3 days    | 1½ days   |

\* 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.

**Workshop application:**  
(75 micron/3 mils dry film thickness of HEMPADUR 1557)

|  |            |            |            |
|--|------------|------------|------------|
| Surface temperature  | 10°C/50°F  | 20°C/68°F  | 30°C/86°F  |
| Drying time, approx  | 4 hours    | 2 hours    | 1½ hours   |
| Curing time, approx  | 14 days    | 7 days     | 5 days     |
| <b>Minimum recoating interval related to later conditions of exposure:</b> |            |            |            |
| <b>Interval for recoating with<br/>4633, 4637, 4641<br/>4664, 5803</b>     |            |            |            |
| Atmospheric  |            |            |            |
| Medium (and mild)  | 30 minutes | 15 minutes | 10 minutes |
| Severe   | 4 hours    | 2 hours    | 1½ hours   |
| Immersion*   | 8 hours    | 4 hours    | 3 hours    |
| <b>Interval for recoating with<br/>HEMPADUR and HEMPATANE qualities</b>    |            |            |            |
| Atmospheric  |            |            |            |
| Medium (and mild)  | 4 hours    | 2 hours    | 1½ hours   |
| Severe   | 4 hours    | 2 hours    | 1½ hours   |
| Immersion**  | 16 hours   | 8 hours    | 6 hours    |

\* Only 4633 is recommended for this exposure

\*\* NOT relevant for HEMPATANE Qualities

Maximum recoating intervals as per preceding table.

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure optimum intercoat adhesion or application of a thin coat of 1557 in case of recoating with non-HEMPADURs.

The above 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.

The short minimum recoating intervals when overcoated with 4633, 4637, 4641, 4664 and 5803, HEMPADUR and HEMPATANE in case of workshop application, are only possible if the finished paint system is through dry before exposure to the environment.

Before recoating after exposure in contaminated environment, irrespective of recoating interval, clean 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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