

# HEMPADUR\* 15590

CURING AGENT 95100

<b>Description:</b>	HEMPADUR 1559 is a two-component, epoxy amine adduct primer especially for use on surfaces exposed to severe abrasion.
<b>Recommended use:</b>	As a blast primer for heavy duty epoxy systems according to specification.
<b>Service temperatures:</b>	maximum, dry: 140°C/284°F.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Red/56880
Finish:	Semi-gloss
Volume solids:	44%
Theoretical spreading rate:	11.0 m <sup>2</sup> /litre - 40 micron 441 sq.ft./US gallon - 1.6 mils
Flash point:	26°C/79°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	¾ (approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch:	3 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	497 g/litre - 4.2 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 15590:	Base 15599 : Curing agent 95100 3.7 : 1.0 by volume
Application method:	Airless spray                      Air spray
Thinner (max.vol.):	0845 (5%)                      0845 (15%)
Pot life:	2 hours (20°C/68°F)
Nozzle orifice:	.021"
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 9961
Indicated film thickness, dry:	40 micron/1.6 mils
Indicated film thickness, wet:	100 micron/4 mils
Recoat interval, min:	8 hours (20°C/68°F)
Recoat interval, max:	14 days (20°C/68°F) (See REMARKS overleaf)

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## 2. HEMPADUR 15590

**SURFACE PREPARATION:** **New steel:** Abrasive blasting to Sa 2½-3, SSPC-SP-10-5, depending on area of use. Minimum surface profile corresponding to Rugotest No. 3, BN11a, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G) - or as per the specification for the subsequent coat(s). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water cleaning prior to blasting. After blasting, clean the surface carefully from abrasives and dust.

**Maintenance:** On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for wet abrasive blasting followed by dry abrasive blasting. Alternatively, dry abrasive blasting, high pressure fresh water cleaning, drying, and finally, dry abrasive blasting again.

**APPLICATION CONDITIONS:** Clean and dry surface with a temperature above the dew point to avoid condensation. Minimum temperature 5°C/41°F, best above 10°C/50°F. Relative humidity maximum 80%, preferably below 60%.

The temperature of the paint itself should preferably be between 15°C/59°F and 25°C/77°F. In confined spaces provide adequate ventilation during application and drying.

**PRECEDING COAT:** None.

**SUBSEQUENT COAT:** HEMPADUR or according to 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 dry is 30-50 mciron/1.2-2 mils.

The stated maximum recoating interval implies the following to secure good adhesion and the best mechanical properties:

- The coating has been applied in a dry film thickness as near as possible to the specified 40 micron.
- The film formation has been of good quality and without any dry spray.
- The drying and curing conditions have been according to APPLICATION CONDITIONS (please see above) until full cure has been obtained.
- No kind of surface contamination exists, except loose dust, abrasive, loose dry spray, which is possible to remove by vacuum cleaning (tanks) / hosing down (exterior). The surface MUST be completely clean before recoating.
- The coating has only been exposed to short periods of strong, direct sunlight (ultra violet light).

**Note:** Inside closed tanks the maximum recoating interval is three weeks provided that the demands for recoating otherwise are fulfilled.

- The coating is checked carefully and should be without patchy, whitish, and/or greasy formations, which can hinder adhesion of subsequent coat.

**Note:** Exudation of curing agent causes the mentioned patchy, whitish, and/or greasy formations which will take place if HEMPADUR 1559 is applied at low temperature without proper induction time and/or if the coating is exposed to water (rain, condensation) during drying and curing. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before recoating after exposure in contaminated environment, clean surface thoroughly by (high pressure) fresh water hosing and allow to dry. HEMPADUR 1559 will resist a hosing down of the surface 8 hours after application at a steel temperature of 20°C/68°F.

**Note:** **HEMPADUR 1559 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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