

# HEMPATHANE\* ENAMEL 55100

CURING AGENT 95370

<b>Description:</b>	HEMPATHANE ENAMEL 5510 is a two-component acrylic polyurethane enamel with good gloss and colour retention. Resistant to water, impact and abrasion. Easy to clean.
<b>Recommended use:</b>	As a glossy decorative finishing coat on a variety of substrates such as steel, aluminium, glassfibre, reinforced polyester, plywood, hardwood etc. in severely corrosive environment. Minimum temperature for curing is -10°C/14°F.
<b>Service temperatures:</b>	Maximum, dry: 120°C/248°F (see REMARKS overleaf).
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	White/10000*	Black/19990*
Finish:	High-gloss	High-gloss
Volume solids:	52%	44%
Theoretical spreading rate:	14.9 m <sup>2</sup> /litre - 35 micron 596 sq.ft./US gallon - 1.4 mil	12.6 m <sup>2</sup> /litre - 35 micron 504 sq.ft./US gallon - 1.4 mil
Flash point:	31°C/88°F	31°C/88°F
Specific Gravity:	1.3 kg/litre - 10.8 lbs/US gallon	1.0 kg/litre - 8.3 lbs/US gallon
Surface dry:	2½ (approx.) hrs at 20°C/68°F (ISO 1517)	2½ (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	4-5 hours at 20°C/68°F	4-5 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
V.O.C.:	437 g/litre - 3.6 lbs/US gallon	500 g/litre - 4.2 lbs/US gallon

*\*Other shades 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 55100:	Base 55109 : Curing agent 95370 7 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	See REMARKS overleaf	See REMARKS overleaf	0808 (5%)
Pot life:	2 hours (20°C/68°F)		
Nozzle orifice:	.017"-.019"		
Nozzle pressure	75-100 bar /1100 -1450 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 0808 or 0851		
Indicated film thickness, dry:	35 micron/1.4 mil		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	8 hours (20°C/68°F)		
Recoat interval, max:	See REMARKS overleaf		

Issued: March 1998

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APPLICATION AND CURING CONDITIONS:	The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is -10°C/14°F. At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. Light rain, high humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. The humidity of plywood/hardwood should not exceed 16% w/w. In confined spaces provide adequate ventilation during application and drying.						
PRECEDING COAT:	HEMPADUR HI-BUILD 4520, HEMPADUR 4530 or according to specification.						
SUBSEQUENT COAT:	None.						
REMARKS:							
Colours:	Certain lead-free red and yellow colours may discolour when exposed to sulphide and chlorine-containing atmosphere.						
Service temperatures:	At service temperatures above 100°C/212°F, slight discoloration may be expected.						
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 20-40 micron/0.8 -1.6 mils.						
Thinning:	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. THINNER 0808 is recommended in general. THINNER 0851 may be used alternatively depending on local conditions. <b>Airless spray:</b> 15-20% thinning is recommended. Under extreme conditions more than 25% may be necessary to obtain satisfactory film formation. <b>Conventional air spray:</b> Dilute to a viscosity of 17-20 s/DIN 4 (approx 35% by volume). Use lowest possible air pressure and a small nozzle. For both kinds of spray application the best result is obtained by applying a mist coat of HEMPATHANE ENAMEL 5510 at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.						
Recoating and drying/curing time:	<b>Physical data versus temperatures</b> (35 micron/1.4 mil dry film thickness - sufficient ventilation):						
	Surface temperature		-10°C/14°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/86°F
	Dry to touch, approx.		45 hours	20 hours	9 hours	5 hours	3 hours
	Resist condensing humidity/light showers after:		(7 days)	3 days	32 hours	16 hours	12 hours
	Fully cured, 70% RH		(2 months)	32 days	14 days	7 days	5 days
	Recoating interval, recoating 5510 with 5510	Min	3 days	1½ day	16 hours	8 hours	6 hours
		Max*	(6 months)	(6 months)	(6 months)	3 months	2 months
	*The maximum recoating intervals apply to surfaces exposed to very severe conditions of periodical immersion, heavy condensation, great variations in temperatures, chemical attack and/or abrasion during service life of the coating system. Under other conditions no maximum recoating interval. <b>A completely clean surface is anyhow mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt,oil, and grease has to be removed. e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.</b> If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. In the case of recoating with other paint materials maximum will be 1-3 days (20°C/68°F) depending on type.						
Notes:	CURING AGENT 95370 is sensitive to moisture. Store in a dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot-life and result in film defects.						
SAFETY:	<b>HEMPATHANE ENAMEL 5510 is for professional use only.</b> 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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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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March 1998 - 5510010000CO005