

HEMPEL'S ENAMEL 55850

CURING AGENT 97550

Description:	HEMPEL'S ENAMEL 5585 is a two-component oxiraneester based topcoat. Resistant to splashes of petrol, mineral oils, and mild acids.
Recommended use:	As a finishing coat in two-pack anti-corrosive systems where safety rules preclude the use of isocyanate cured paints.
Service temperatures:	Maximum, dry: 140°C/282°F.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	White/10000*
Finish:	Glossy
Volume solids:	64%
Theoretical spreading rate:	10.7 m ² /litre - 60 micron 428 sq.ft./US gallon - 2.4 mils
Flash point:	43°C/105°F
Specific gravity:	1.4 kg/litre 11.7 lbs/US gallon
Surface dry:	3 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch:	8-10 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	336 g/litre - 2.8 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 55850:	Base 55859 : Curing agent 97550 2 : 1 by volume		
Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	0808 (5%)	0808 (15%)	0808 (5%)
Pot life:	8 hours (20°C/68°F)		
Nozzle orifice:	.018"-.021"		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 0808		
Indicated film thickness, dry:	60 micron/2.4 mils		
Indicated film thickness, wet:	100 micron/4 mils		
Recoat interval, min:	24 hours (20°C/68°F)		
Recoat interval, max:	See REMARKS overleaf)		

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APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the surface and that of the paint itself must also be above this limit.
Apply only on a dry and completely clean surface with a temperature above the dew point to avoid condensation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: According to specification.

SUBSEQUENT COAT: None.

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 recoat interval. Normal range is 50-75 micron/2.0-3.0 mils.

Recoating: Maximum recoat interval related to later conditions of exposure:

Steel temperature	20°C/68°F			
	Atmospheric			
Recoated with (quality numbers only)	Mild	Medium	Severe	Water immersion
5585	None	None	3 months	Not relevant

A completely clean surface is anyhow mandatory to ensure intercoat adhesion, especially at long recoat 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.

The test patch reveals insufficient intercoat adhesion, roughening of the surface is necessary. If the maximum recoat interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

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

Note: **HEMPEL'S ENAMEL 5585 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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Issued by HEMPEL'S MARINE PAINTS A/S.

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