



Product Data

HEMPADUR® PRIMER 15300

BASE 15309 with CURING AGENT 95040

Description: HEMPADUR PRIMER 15300 is a two-component polyamide-cured epoxy primer containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rust-preventing coating.

Recommended use: As a primer or intermediate coat in container systems. May be used as a general purpose epoxy primer according to painting specification.

Service temperatures:

	Dry exposure only:	In water (no temperature gradient):
Maximum:	140°C/284°F	35°C/95°F

Certificates/Approvals: Approved as a welding primer by Lloyd's Register of Shipping.
Complies with EU Directive 2004/42/EC, subcategory j (see REMARKS overleaf).

Availability: Generally for container newbuildings only.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red/50890 - Grey/12170
Finish:	Flat
Volume solids, %:	51 ± 1
Theoretical spreading rate:	12.8 m ² /litre - 40 micron 51.1 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:	1 (app.) hour at 20°C/68°F (ISO 1517)
Dry to touch:	2-3 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	445 g/litre - 3.7 lbs/US gallon

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

APPLICATION DETAILS:

Mixing ratio for 15300:	Base 15309 : Curing agent 95040 4 : 1 by volume
Application method:	Airless spray Air spray Brush
Thinner (max.vol.):	08450 (25%) 08450 (50%) 08450 (5%)
Pot life:	For on-line container production thinning according to specification 8 hours (20°C/68°F) (airless spray) 8 hours (20°C/68°F) (brush)
Nozzle orifice:	.021"
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	40 micron/1.6 mils (See REMARKS overleaf)
Indicated film thickness, wet:	75 micron/3 mils
Recoat interval:	See REMARKS overleaf

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. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



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SURFACE PREPARATION: **New steel:** Abrasive blasting to Sa 2½. For temporary protection, if required, use a 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 PRIMER.
Other metals and light alloys: Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile.
Repair and 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 min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of HEMPADUR PRIMER 15300. Feather edges to sound intact areas. Dust off residues. Touch up to full film thickness. On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.

SUBSEQUENT COAT: HEMPATEX HI-BUILD 46370 or according to specification.

REMARKS:

VOC - EU directive 2004/42/EC:
VOC:

	As supplied	35 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	445	550	550	500

For VOC of other shades, please refer to Safety Data Sheet.

Weathering/ service temperatures: **Certificate** has been issued under the former quality number 1530. The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.
Film thicknesses: May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and will influence the amount of thinning necessary, drying time and recoating interval. Normal range dry is 25-75 micron/1-3 mils.

Recoating:

Recoating intervals:

Minimum (primarily only relevant for container coatings): 20 minutes' flash-off time for 40 micron/1.6 mils HEMPADUR PRIMER 15300 when topcoated with designed container coatings, epoxy, polyurethane, acrylic or CR types.

The minimum recoating interval only applies in the case of forced ventilation, proper application and if the completed paint system is thoroughly dry before exposed to aggressive environments. *Maximum:* Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for PUs and none for epoxies.

In the case of long recoating intervals, a completely clean surface is mandatory to ensure intercoat adhesion. Any dirt, oil and grease to be removed with eg suitable detergent followed by high pressure fresh water cleaning. Salts to be removed by fresh water hosing. Any degraded surface layer, as a result of a long exposure period, must be removed as well. Water jetting may be relevant to remove any degraded surface layer and may also replace the above-mentioned cleaning methods when properly executed. Consult HEMPEL for specific advice if in doubt.

To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.

Note: **HEMPADUR PRIMER 15300 is for professional use only.**

ISSUED BY: HEMPEL A/S - 1530050890C0004

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.

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Product data are subject to change without notice and become void five years from the date of issue.