



Product Data

HEMPADUR 15553

BASE 15557 with CURING AGENT 98021

Description: HEMPADUR 15553 is a two-component polyamide adduct-cured epoxy paint. It cures to a flexible, well adhering coating with good abrasion and impact resistance. Contains zinc phosphate. Cures down to -10°C/14°F.

Recommended use: As a primer for HEMPATEX, HEMPADUR and HEMPETHANE systems on hot dipped galvanized surfaces, aluminium and stainless steel in moderately corrosive environments. HEMPADUR 15553 is also suited when roughening of the surface is not possible. Please see surface preparation overleaf.

Service temperatures: Maximum, dry exposure only: 140°C/284°F.

Certificates/Approvals: Complies with EU Directive 2004/42/EC, subcategory j (see REMARKS overleaf).

Availability: Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos: Off-white/11630
Finish: Flat
Volume solids, %: 55 ± 1
Theoretical spreading rate: 11.0 m²/litre - 50 micron
441 sq.ft./US gallon - 2.0 mils
Flash point: 30°C/86°F
Specific gravity: 1.6 kg/litre - 13.4 lbs/US gallon
Dry to touch: 3 (app) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 400 g/litre - 3.3 lbs/US gallon. See REMARKS overleaf.

Shelf life: ½ year (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.
If the shelf life is exceeded please contact HEMPEL for further advice.

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 15553: Base 15557 : Curing agent 98021
3 : 1 by volume
Application method: Airless spray Brush
Thinner (max.vol.): 08450 (5%) 08450 (5%)
Pot life: 2 hours (20°C/68°F)
Nozzle orifice: .017"-.019"
Nozzle pressure: 175 bar/2450 psi
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry: 50 micron/2 mils
Indicated film thickness, wet: 100 micron/4 mils
Recoat interval, min: See REMARKS overleaf
Recoat interval, max: 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: **Stainless steel and aluminium surfaces:** Remove dirt, oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. It is very important that all contamination and dust are removed. Roughening of the surface is recommended for optimum adhesion.
Galvanizing: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Zinc salts (white rust) must be removed by high pressure hosing combined with rubbing with a stiff nylon brush if necessary.
It is recommended to recoat spray-metallised surfaces as soon as possible to avoid possible contamination.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. At the freezing point and below be aware of the risk of ice on the surface, which will hinder adhesion.
 Use only where application and curing can proceed at temperatures above -10°C/14°F. The temperature of the surface must also be above this limit.
 The temperature of the paint itself should be 15-25°C/59-77°F.
 In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT: HEMPADUR, HEMPATHANE or HEMPATEX qualities according to specification.

REMARKS:

VOC - EU directive 2004/42/EC:

	As supplied	5 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	400	425	550	500

VOC:

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

Passivation/ surface preparation: Ammonium chloride or any other passivation agent should not be present on the surface when coating the galvanized surface.

Water should not be used for cooling down the steel.

Application:

Cleaning of steel should not be initiated unless the steel temperature is below 30°C/86°F.

As the galvanized zinc layer may be porous it is recommended to apply a mist coat of undiluted HEMPADUR 15553, allow air to escape, and then apply a full coat of HEMPADUR 15553 a few minutes later.

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 50-80 micron/2.0-3.2 mils.

Recoating:

Recoating intervals related to later conditions of exposure (50 micron/2 mils dry):

	Minimum			Maximum		
	20°C/68°F					
Recoated with	Atmospheric			Atmospheric		
	Mild	Medium	Severe	Mild	Medium	Severe
HEMPATEX	30 minutes	30 minutes	3 hours	None	24 hours	12 hours
HEMPADUR	3 hours	3 hours	6 hours	None	None*	None*
HEMPATHANE	3 hours	3 hours	6 hours	None	10 days*	3 days

*Except for mild climatic conditions avoid long-term exposure of galvanized steel coated with a thin layer of paint only as this may create white rust **under** the paint.

If the maximum recoating interval is exceeded, whatever the subsequent coat, roughening of the surface is necessary to ensure optimum intercoat adhesion or in the case of recoating with coatings other than HEMPADUR, apply a (thin) additional coat of HEMPADUR 15553 within the above directions for recoating.

A completely clean surface is mandatory to ensure intercoat adhesion, especially in the case of long recoating intervals. Any dirt, oil and grease have 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.



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Note: **HEMPADUR 15553 is for professional use only.**

ISSUED BY: HEMPEL A/S - 1555311630C0002

This Product Data Sheet supersedes those previously issued.

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

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