



Product Data

HEMPADUR® 15570

BASE 15579 with CURING AGENT 95570

Description:

HEMPADUR 15570 is a two component, polyamide-adduct cured epoxy paint, which cures to a strong and highly corrosion resistant coating, at temperatures down to -10°C/14°F. The Micaceous Iron Oxide pigmented light grey 12430 quality is also well suited for application under humid conditions, on damp steel surfaces, and may be applied on moist surfaces.

Recommended use:

1. As a maintenance and repair primer, intermediate, and/or finishing coat in HEMPADUR systems in severely corrosive environment. As a finishing coat where a cosmetic appearance is of less importance.
2. As a low temperature curing epoxy primer, intermediate, and/or finishing coat in paint systems according to specification. Well suited as a (blast) primer in coal tar epoxy systems.

Service temperatures:

Dry exposure only: Maximum 140°C/284°F (See REMARKS overleaf)
Ballast water service: Resists normal ambient temperatures at sea*
Other water service: 40°C/104°F (no temperature gradient)
Other liquids: Contact HEMPEL
*Avoid long-term exposure to negative temperature gradients.

Certificates/Approvals:

Tested for non-contamination of grain cargoes at the Newcastle Occupational Health, Great Britain.
Approved as a low flame spread material by Danish, French and Spanish authorities according to IMO resolution MSC 61 (67).
Has a Danish, French, Spanish, Singaporean, Malaysian and Indonesian EC-type Examination Certificate.
Complies with EU Directive 2004/42/EC, subcategory j.
Please see REMARKS overleaf.

Availability:

Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Reddish grey/12430* (MIO)	Red/50630*
Finish:	Flat	Flat
Volume solids, %:	54 ± 1	55 ± 1
Theoretical spreading rate:	5.4 m ² /litre - 100 micron 217 sq.ft./US gallon - 4 mils	5.5 m ² /litre - 100 micron 221 sq.ft./US gallon - 4 mils
Flash point:	25°C/77°F	25°C/77°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon	1.3 kg/litre - 10.8 lbs/US gallon
Dry to touch:	3-4 (approx) hours at 20°C/68°F	3-4 (approx) 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.:	420 g/litre - 3.5 lbs/US gallon	415 g/litre - 3.4 lbs/US gallon

*Another shade: grey 12170 may be available according to assortment list.

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 15570: Base 15579 : Curing agent 95570
3 : 1 by volume

Application method:	Airless spray	Air Spray	Brush
Thinner (max. vol.):	08450 (5%)	08450 (15%)	08450 (5%)
Pot life:	2 hours (20°C/68°F)		
Nozzle orifice:	.019"-.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: 100 micron/4 mils (See REMARKS overleaf)
Indicated film thickness, wet: 200 micron/8 mils
Recoat interval, min: As per separate APPLICATION INSTRUCTIONS
Recoat interval, max: As per separate APPLICATION INSTRUCTIONS

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 (dry conditions): Abrasive blasting to Sa 2½. For temporary protection, if required, use 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 15570.

Light alloys: Thorough degreasing and (light) abrasive sweeping to remove contamination and to secure adhesion - surface profile depending on later exposure.

Stainless steel: (Eg ballast tanks of chemical carriers) to be abrasive blast cleaned to a uniform, sharp, dense profile (Rugotest No. 3, BN9a, ISO Comparator Medium (G), Keane-Tator Comparator 2.0 G/S) corresponding to Rz minimum 50 micron. Any salts, grease, oil, etc. to be removed before abrasive blasting is commenced.

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 minimum Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of HEMPADUR 15570.

As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be Wa 2 - Wa 2½ (atmospheric exposure) / minimum Wa 2½ (immersion) (ISO 8501-4:2006). A flash-rust degree of maximum M (atmospheric exposure) / M, preferably L (immersion) (ISO 8501-4:2006) is acceptable before application. Feather edges to sound and intact areas. Dust off residues. Touch up bare spots to full film thickness when the surface has reached the condition of being damp, may be moist.

In case of wet abrasive blasting a suitable inhibitor may be used. Surplus inhibitor and residual abrasives and sludge must be removed by (high pressure) fresh water cleaning before recoating. Cleaning with hot water is recommended.

Note 1: Inhibitors are generally not recommended for surfaces which will be immersed during service.

Note 2: Damp surfaces: Water is not readily detectable, but the temperature of the surface is below the dew point. **Moist surfaces:** pools of water and droplets have been removed, but there is a noticeable film of water. **Wet surfaces:** Droplets or pools of water are present).

APPLICATION CONDITIONS:

Use only where curing can proceed at temperatures above -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.

The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties.

In confined spaces provide adequate ventilation during application and drying.

Occurrence of standing water or droplets on the painted surface immediately after application may result in discolouration.

PRECEDING COAT: None, or according to specification.

SUBSEQUENT COAT: None, HEMPADUR, HEMPATHANE or HEMPATEX as per specification.

REMARKS:

VOC - EU directive

2004/42/EC:

VOC:

	As supplied	15 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	425	485	550	500

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

Certificates are issued under the former quality number 1557.

Weathering/ service

temperatures:

Film thicknesses:

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.

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 50-125 micron/2-5 mils.

Curing agent:

Note:

Curing agent 95570 is hazy. This is intended and has no negative influence on the performance.

HEMPADUR 15570 is for professional use only.

ISSUED BY:

HEMPEL A/S - 1557012430C00011

This Product Data Sheet supersedes those previously issued.

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

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.

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Application Instructions

For product description refer to product data sheet

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Physical data versus temperature:

Drying time and recoating interval vary with film thickness, temperature and later exposure conditions, thus:
(75-100 micron/3-4 mils dry film thickness of HEMPADUR 15570)

Surface temperature	-10°C/14°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/86°F
Drying time, approx	36 hours	16 hours	8 hours	4 hours	3 hours
Curing time, approx	2 months	1 month	14 days	7 days	5 days
MINIMUM recoating interval related to later conditions of exposure:					
Interval for recoating with HEMPATEX HI-BUILDS					
Atmospheric, medium	18 hours	9 hours	4 hours	2 hours	1½ hours
Atmospheric, severe	36 hours	18 hours	8 hours	4 hours	3 hours
Interval for recoating with HEMPASIL NEXUS 27302					
Surface temperature	-10°C/14°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/86°F
Immersion	Not relevant	Not relevant	11 hours	6 hours	4 hours
Interval for recoating with HEMPADUR and HEMPATANE qualities					
Atmospheric, medium	36 hours	18 hours	8 hours	4 hours	3 hours
Atmospheric, severe	36 hours	18 hours	8 hours	4 hours	3 hours
Immersion*	3 days	36 hours	16 hours	8 hours	6 hours
MAXIMUM recoating interval related to later conditions of exposure:					
Interval for recoating with HEMPATEX HI-BUILDS					
Atmospheric, medium	3 days	36 hours	16 hours	8 hours	6 hours
Atmospheric, severe	2 days	23 hours	10 hours	5 hours	4 hours
Interval for recoating with HEMPASIL NEXUS 27302					
Immersion	Not relevant	Not relevant	48 hours	24 hours	18 hours
Interval for recoating with itself or other HEMPADUR qualities as per specification					
Atmospheric, medium	None	None	None	None	None
Atmospheric, severe	None	None	None	None	None
Immersion	Extended**	Extended**	Extended**	Extended**	Extended**
Interval for recoating with HEMPATANE qualities					
Atmospheric					
Medium	90 days	45 days	20 days	10 days	5 days
Severe	27 days	14 days	6 days	3 days	1½ days

* NOT relevant for HEMPATANE Qualities.

** Extended recoating intervals can be utilised when the following is strictly observed:

The surface shall be thoroughly cleaned from all sorts of contaminants including deposits of water soluble salts, oil, grease and similar harmful chemical substances.

Surfaces having any degraded layer from exposure to UV radiation, heat etc. must have this layer removed by mechanical cleaning methods like, water jetting, abrading or sweep blasting.

The existing coating system must in all respects be sound and applied according to Product Data Sheets, Application Instructions and Specification.

The new coat is to be a HEMPADUR 15570 or equivalent, approved HEMPADUR.

To determine whether the quality of the surface cleaning is adequate, a test patch may be relevant. However, such a test is not the final proof of long-term durability, but if the result is doubtful, repeated cleaning will be relevant. If next coat is not a HEMPADUR 15570 a "refresh" of the surface with a new thin (diluted) coat of HEMPADUR 15570 may be needed.



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Maximum recoating intervals, for HEMPASIL NEXUS 27302:

If the maximum recoating interval is exceeded, apply a (thin) additional coat of HEMPADUR 15570 within the above directions for recoating. Furthermore, reference is made to special Application Instructions/painting specifications for HEMPASIL paint systems.

Long recoating intervals, in general:

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.

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.

ISSUED BY:

HEMPEL A/S - 1557012430C0009

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