



HEMPADUR 1555E

1555E: BASE 1555S: CURING AGENT 97290

Description: HEMPADUR 1555E 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 general purpose primer for HEMPATEX, HEMPADUR and HEMPATANE systems on steel. May also be used as primer for hot dipped galvanized surfaces, aluminium and stainless steel.

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

Availability: Not included in Group Assortment. Availability subject to special agreement.

PHYSICAL CONSTANTS:

Shade nos/Colours: 22430 / Cream
Finish: Flat
Volume solids, %: 40 ± 1
Theoretical spreading rate: 10 m²/l [401 sq.ft./US gallon] - 40 micron/1.6 mils
Flash point: 30 °C [86 °F]
Specific gravity: 1.3 kg/litre [11.2 lbs/US gallon]
Surface dry: 1 approx. hour(s) 20°C/68°F
Dry to touch: 3 approx. hour(s) 20°C/68°F
Fully cured: 7 day(s) 20°C/68°F
VOC content: 531 g/l [4.4 lbs/US gallon]
Shelf Life: 6 months (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.

APPLICATION DETAILS:

Version; mixed product: **1555E**
Mixing ratio: BASE 1555S: CURING AGENT 97290
3 : 1 By volume
Application method: Airless spray / Brush
Thinner (max.vol.): 08450 (5%) / 08450 (5%)
Pot life: 2 hour(s) 20°C/68°F
Nozzle orifice: 0.017 - 0.019 "
Nozzle pressure: 175 bar [2537.5 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]
Indicated film thickness, wet: 100 micron [4 mils]
Recoat interval, min: According to specification.
Recoat interval, max: According to specification.

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations.



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SURFACE PREPARATION:

New steel: Abrasive blasting to Sa 2½ (ISO 8501-1:1988). 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/roughening is recommended for optimum adhesion.

Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:1988). Improved surface preparation will improve the performance. As an alternative to dry cleaning, waterjetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of maximum FR-2 (Hempel standard) is acceptable before application. Improved surface preparation will improve the performance of the product. Feather edges to sound and 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 hosting, drying, and finally dry abrasive blasting again.

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 these limits.

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:

According to specification. Recommended systems are: HEMPADUR, HEMPATANE, HEMPATEX.

REMARKS:

Film thicknesses/thinning:

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: 30-50 micron/1.2-2 mils. For containers: 30 micron/1.2 mils.

Recoating note:

In case of recoating with coating other than HEMPADUR, apply a (thin) additional coat of the product with the described directions for recoating.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed with by fresh water hosting.

Any degraded surface layer, as a result of a long exposure period, must be removed. 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.

Nota:

HEMPADUR 1555E For professional use only.

ISSUED BY:

HEMPEL A/S

1555E22430

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on www.hempel.com. 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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