Hempadur 15553

Product characteristics

Description
Hempadur 15553 is a two-component 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. Complies with EU Directive 2004/42/EC, The Paints Directive on the limitation of volatile organic compounds: subcategory j.

Recommended use
Hempadur 15553 is recommended as a primer for systems on hot dipped galvanized steel, aluminium, mild steel and stainless steel surfaces in moderately to severely corrosive environments. Hempadur 15553 is also suited in moderate corrosive environments when roughening of the surface is not possible. Please see surface preparation overleaf.

Service temperature:
- Maximum, dry exposure only: 140°C [284°F].

Certificates / Approvals
- EC-type examined as a low flame spread material when used as part of a predefined paint system. Please refer to “Declaration of Conformity” on hempel.com for further details.
- Complies with the European Fire Standard EN 13501-1, reaction to fire classification, when used as part of a predefined paint system. B-s1, d0.

Product safety

Flash point 30°C [86°F]

VOC content mixed product

Legislation	Value	5% thinning, by volume	Limit value, phase II (2010)[a]
EU	388 g/L [3.24 lb/US gal]	411 g/L [3.43 lb/US gal]	500 g/L [4.17 lb/US gal]
US (coatings)	388 g/L [3.24 lb/US gal]	-	-
US (regulatory)	388 g/L [3.24 lb/US gal]	-	-
China	388 g/L [3.24 lb/US gal]	-	-

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9. [a]EU Directive 2004/42/CE.

Handling
Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel’s Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code
15553

Product components
Base 15557
Curing Agent 98021

Standard shade* / code
Pebble Grey 11320

Gloss
Flat

Volume solids
55 ± 2%

* Other shades are available, please contact your local Hempel representative.

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Specific gravity
1.5 kg/L [13 lb/US gal]

Reference dry film thickness
50 micron [2.0 mils]

Surface preparation

Cleanliness
- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

New build:
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Stainless steel, aluminium and other non ferric metals and alloys: use non-metallic blast media (corundum, garnet, etc.). Sweep blasting to a uniform dense sharp profile, without blank spots.
- Remove dust, blast media and loose materials.
- In some cases, roughening of the surface is not required for galvanized and stainless steel. Consult Hempel for advice.

Maintenance and Repair
- Abrasive blasting to min. Sa 2 (ISO 8501-1) / SP 6 (SSPC).
- Stainless steel, aluminium and other non ferric metals and alloys: use non-metallic blast media (corundum, garnet, etc.). Sweep blasting to a uniform dense sharp profile, without blank spots.
- Feather edges to sound surrounding coating.
- Remove dust, blast media and loose materials.
- In some cases, roughening of the surface is not required for galvanized and stainless steel. Consult Hempel for advice.

Roughness
- Surface profile Medium (G) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratio
Base 15557 : Curing Agent 98021
(3 : 1 by volume)

Stir well before use.

Thinner
Hempel's Thinner 08450

Cleaner
Hempel's Tool Cleaner 99610

Pot life

Product temperature	20°C [68°F]
Pot life	2 hours

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 175 bar [2500 psi] Nozzle orifice: 0.017-0.019"

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	50 micron [2.0 mils]	80 micron [3.1 mils]	50 micron [2.0 mils]
Wet film thickness	90 micron [3.5 mils]	150 micron [6 mils]	90 micron [3.5 mils]
Theoretical spreading rate	11 m²/L [450 sq ft/US gal]	6.9 m²/L [280 sq ft/US gal]	11 m²/L [450 sq ft/US gal]

For best performance, avoid excessive film thickness.

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Application conditions
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above -10°C [14°F] during application and curing.
- Optimal paint temperature for proper mixing, pumping and spraying is: 15-25°C [59-77°F].

Application remarks
- Flash-coat technique is recommended when overcoating porous substrates.

Drying and overcoating

Product compatibility
- Previous coat: None.
- Subsequent coat: According to Hempel's Specification. Recommended products are: Hempadur, Hempathane, Hempatex

Drying time

Surface temperature		20°C [68°F]
Touch dry	min	18
Hard dry	min	90
Fully cured	days	7

Determined for dry film thickness 50 micron [2.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		-10°C [14°F]	0°C [32°F]	20°C [68°F]
Atmospheric medium				
Hempadur 15553	Min	27 h	14 h	3 h
	Max	Ext*	Ext	Ext
Hempathane HS 55610	Min	27 h	14 h	3 h
	Max	90 d	45 d	10 d

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions
- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details
- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be clean before overcoating.

Other remarks
- Epoxy coatings have an inherent tendency of chalking, fading and discolouring. This does not affect the performance of the coating
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]	35°C [95°F]
Base	9 months	9 months
Curing Agent	36 months	24 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

Storage conditions
- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.

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Additional documents

Additional information is available at the Hempel website hempel.com or at your local Hempel website:

- Explanatory Notes explaining the fields in this Product Data Sheet.
- Surface Preparation Guidelines.
- Application Guidelines for different application methods.
- General Application Guidelines

This Product Data Sheet ("**PDS**") relates to the supplied product ("**Product**") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "**Additional documents**"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.