

Hempadur 1555E

Product characteristics

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 Hempthane 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].

Product safety

Flash point 30°C [86°F]

VOC content mixed product

Legislation	Value
EU	528 g/L [4.41 lb/US gal]
US (coatings)	528 g/L [4.41 lb/US gal]
US (regulatory)	528 g/L [4.41 lb/US gal]
China	528 g/L [4.41 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.

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

1555E

Product components

Base 1555S
Curing Agent 97290

Standard shade / code

Beige 22430

Gloss

Flat

Volume solids

39 ± 2%

Specific gravity

1.3 kg/L [11 lb/US gal]

Reference dry film thickness

40 micron [1.6 mils]

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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).
- Remove dust, blast media and loose materials.
- All damage of shopprimer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting.

Maintenance and Repair

- Minor areas can be cleaned by power tool to St 3 provided the surface is roughened and not polished.
- Feather edges to sound surrounding coating.
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Water jetting to min. Wa 2 (ISO 8501-4).

Roughness

- Surface profile Medium (S) (ISO 8503-2).

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

Application

Mixing ratio

Base 1555S : Curing Agent 97290
(3 : 1 by volume)

Stir well before use. It is recommended to use fixed volumes/can size for multi-component products.

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 Application parameters

Airless spray Nozzle pressure: 175 bar [2500 psi]
Nozzle orifice: 0.017-0.019"

Brush Not Applicable.

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	30 micron [1.2 mils]	50 micron [2.0 mils]	40 micron [1.6 mils]
Wet film thickness	80 micron [3 mils]	130 micron [5 mils]	100 micron [4 mils]
Theoretical spreading rate	13 m ² /L [530 sq ft/US gal]	7.7 m ² /L [310 sq ft/US gal]	10 m ² /L [410 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

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.
- Optimal paint temperature for proper mixing, pumping and spraying is: 15°C [59°F].
- Surface temperature must be above -10°C [14°F] during application and curing.
- Beware of ice on the surface at low temperatures.

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Drying and overcoating

Product compatibility

- Previous coat: None.
- Subsequent coat: According to Hempel's Specification.

Drying time

Surface temperature		20°C [68°F]
Touch dry	min	60
Hard dry	hours	2½

Determined for dry film thickness 40 micron [1.6 mils] at standard conditions, see Hempel's Explanatory Notes for details.

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 dry and clean prior to application.

Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. 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]
Base		6 months
Curing Agent		24 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	17.9 g CO ₂ e/m ²	0.093 lb CO ₂ e/ft ²

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

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Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.

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.