



HEMPADUR 15400

15400: BASE 15409: CURING AGENT 95100

Description:	HEMPADUR 15400 is a two-component, amine adduct cured epoxy paint, which cures to a coating with excellent resistance to a wide range of chemicals as tabulated in separate CARGO PROTECTION GUIDE.
Recommended use:	As a tank lining.
Service temperature:	Maximum, dry exposure only: 140°C/284°F In water (no temperature gradient): 50°C/122°F Wet service temperatures, other liquids: Consult the corresponding CARGO PROTECTION GUIDE.
Certificates/Approvals:	Tested for non-toxicity of welding fumes by the Danish Welding Institute Complies with Section 175.300 of U.S. Federal Regulations Tested for non-contamination of grain cargo at the Newcastle Occupational Health & Hygiene, Great Britain.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	10000* / White.
Finish:	Semi-flat
Volume solids, %:	48 ± 1
Theoretical spreading rate:	6 m ² /l [240.6 sq.ft./US gallon] - 80 micron/3.2 mils
Flash point:	26 °C [78.8 °F]
Specific gravity:	1.4 kg/litre [12 lbs/US gallon]
Surface dry:	3 approx. hour(s) 20°C/68°F
Dry to touch:	8 - 10 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	463 g/l [3.8 lbs/US gallon]
Shelf life:	1 year for BASE and 3 years for CURING AGENT (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage. *other shades according to assortment list.

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

APPLICATION DETAILS:

Version, mixed product:	15400
Mixing ratio:	BASE 15409: CURING AGENT 95100 4 : 1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (5%) According to separate APPLICATION INSTRUCTIONS
Pot life (Airless spray):	2 hour(s) 20°C/68°F
Pot life (Brush):	4 hour(s) 20°C/68°F
Nozzle orifice:	0.021 "
Nozzle pressure:	200 bar [2900 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	80 micron [3.2 mils] see REMARKS overleaf
Indicated film thickness, wet:	175 micron [7 mils]
Recoat interval, min:	According to separate APPLICATION INSTRUCTIONS
Recoat interval, max:	According to separate APPLICATION INSTRUCTIONS
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:	Steel: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to near white metal Sa 2½ (ISO 8501-1:2007) with a surface profile corresponding to Rugotest No. 3, BN10a, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G).
APPLICATION CONDITIONS:	Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 10°C/50°F. Maximum relative humidity: 80%, preferably 40-60%. A Special curing agent 95990 may be available for curing between 5°C/41°F and 10°C/50°F if required, see Application Instructions. The temperature of the surface and that of the paint itself must also be above this limit. Optimal spraying properties for proper mixing and pumping are obtained at paint temperature: 15-25°C/59-77°F. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT	None, or as per specification.
SUBSEQUENT COAT:	None, or as per specification.
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: 80-125 micron/3.2-5 mils
Curing before filling of tanks:	Do not put tanks into service until the paint system is completely cured - consult the corresponding CARGO PROTECTION GUIDE and APPLICATION INSTRUCTIONS.
Recoating intervals:	If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	HEMPADUR 15400 For professional use only. This datasheet outlines the main guidelines and recommendations. For details the corresponding PAINTING SPECIFICATION must be consulted and strictly adhered to during execution of the work. The CARGO PROTECTION GUIDE and the corresponding PAINTING SPECIFICATION may be tailored to meet other conditions than stipulated above. Such adjustments may include the degree of surface preparation, conditions of application, dry film thickness, and recoating interval.
ISSUED BY:	HEMPEL A/S 1540010000

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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