



HEMPADUR 15500

15500: BASE 15509: CURING AGENT 97580

Description:	HEMPADUR 15500 is a two-component, amine adduct cured phenolic epoxy (novolac) 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. 150°C/302°F
Service temperature:	Maximum, dry exposure only: 160°C/320°F In seawater (no temperature gradient): 50°C/122°F. Wet service temperatures, other liquids: Consult the corresponding CARGO PROTECTION GUIDE.
Certificates/Approvals:	Complies with Section 175.300 of U.S. Federal Regulations in respect of carriage of foodstuff (FDA) for tanks larger than 2006 m ³ /530,000 US gallon.
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	11150* / Light grey
Finish:	Flat
Volume solids, %:	68 ± 1
Theoretical spreading rate:	6.8 m ² /l [272.7 sq.ft./US gallon] - 100 micron/4 mils
Flash point:	26 °C [78.8 °F]
Specific gravity:	1.7 kg/litre [13.9 lbs/US gallon]
Surface dry:	2 - 3 approx. hour(s) 20°C/68°F
Dry to touch:	4 - 6 hour(s) 20°C/68°F
Fully cured:	10 day(s) 20°C/68°F (see REMARKS overleaf)
VOC content:	321 g/l [2.7 lbs/US gallon]
Shelf life:	1 Year for BASE and 3 years for CURING AGENT (stored in closed container) (25°C/77°F) from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage. <i>*other shades according to assortment list.</i>
<i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>	
APPLICATION DETAILS:	
Version, mixed product:	15500
Mixing ratio:	BASE 15509: CURING AGENT 97580 8.9 : 1.1 by volume. 93.8 : 6.2 by weight
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 / 08450 According to separate APPLICATION INSTRUCTIONS
Pot life:	3 hour(s) 20°C/68°F
Induction time:	minutes 20°C/68°F (see REMARKS overleaf)
Nozzle orifice:	0.018 - 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:	100 micron [4 mils] (see REMARKS overleaf)
Indicated film thickness, wet:	150 micron [6 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 very near white metal Sa 2½-3 (ISO 8501-1:2007) with a surface profile corresponding to Rugotest No. 3, BN10, or ISO Comparator Rough Medium (G). According to separate APPLICATION INSTRUCTIONS
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. The steel temperature must never drop below this limit until full curing has taken place. The temperature of the paint itself must be above 15°C/59°F, best results are obtained at 17-23°C/62-73°F. Maximum relative humidity: 80%, preferably 40-60%. In confined spaces provide adequate ventilation during application and drying. See separate APPLICATION INSTRUCTIONS
PRECEDING COAT	None.
SUBSEQUENT COAT:	None.
REMARKS:	
Colours/Colour stability:	Minor differences may occur in shade: 11150
Induction time:	The thoroughly mixed BASE and CURING AGENT must be prereacted before application (15 minutes at 20°C/68°F), at other temperatures, please see APPLICATION INSTRUCTIONS.
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. Minimum film thickness for the full system 300 micron/12 mils . (Consult the separate APPLICATION INSTRUCTIONS) Keep thinning at absolute minimum. Do not dilute the components separately - only the mixture.
Curing agent:	Resistance to the widest range of cargoes is provided by additional heat curing, see APPLICATION INSTRUCTIONS and CARGO PROTECTION GUIDE.
Recoating note:	If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
Note:	HEMPADUR 15500 For professional use only.
ISSUED BY:	HEMPEL A/S

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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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