



HEMPADUR 15553

15553: BASE 15557: CURING AGENT 98021

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.
Recommended use:	As a primer for HEMPATEX, HEMPADUR and HEMPETHANE systems on hot dipped galvanized surfaces, aluminium and stainless steel in moderately corrosive environments. HEMPADUR 15553 is also suited 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:	Complies with EU Directive 2004/42/EC: subcategory j.
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	11630 / Off-white.
Finish:	Flat
Volume solids, %:	55 ± 1
Theoretical spreading rate:	11 m ² /l [441.1 sq.ft./US gallon] - 50 micron/2 mils
Flash point:	30 °C [86 °F]
Specific gravity:	1.5 kg/litre [12.9 lbs/US gallon]
Dry to touch:	3 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	389 g/l [3.2 lbs/US gallon]
Shelf life:	6 months for the BASE and 2 years for the CURING AGENT (stored in closed container) (25°C/77°F) from time of production. Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F. <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
APPLICATION DETAILS:	
Version, mixed product:	15553
Mixing ratio:	BASE 15557: CURING AGENT 98021 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:	50 micron [2 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:

Stainless steel and aluminium: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Roughening of the surface is recommended for optimum adhesion.

Galvanised steel: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Zinc salts (white rust) must be removed by high pressure hosing combined with rubbing with a stiff nylon brush if necessary.

It is recommended to recoat spray-metallised surfaces as soon as possible to avoid possible contamination.

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. HEMPADUR, HEMPATHANE, HEMPATEX

REMARKS:

VOC - EU Directive 2004/42/EC:

Product	As supplied	5 vol. % thinning	Limit phase II, 2010
1555311630	389 g/l	412 g/l	500 g/l

For VOC of other shades, please refer to Safety Data Sheet.

Application(s)

Ammonium chloride or any other passivation agent should not be present on the surface when coating the galvanized surface.

Water should not be used for cooling down the steel.

Cleaning of steel should not be initiated unless the steel temperature is below: 30°C/86°F

As the galvanized zinc layer may be porous it is recommended to apply a mist coat of diluted product, allow air to escape, and then apply a full coat of the product a few minutes later.

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: 50-80 micron/2.0-3.2 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 hosing. **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.

Note:

ISSUED BY:

HEMPADUR 15553 For professional use only.

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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