

15275: BASE 15274: CURING AGENT 95175

Description:	HEMPEL'S SHOPPRIMER E 15275 is a two-component epoxy polyamide shopprimer, pigmented with zinc phosphate rust-inhibiting pigments. It is designed for automatic spray application.
Recommended use:	As a shopprimer for protection of blast cleaned steel plate and other structural steel during the storage and building period.
Service temperature:	Maximum, dry exposure only: 140°C/284°F
Certificates/Approvals:	Complies with European Fire Standard EN 13501-1; classification B-s1, d0.
Availability:	Not included in Group Assortment. Availability subject to special agreement.

PHYSICAL CONSTANTS:

Shade nos/Colours:	50890/ Red
Finish:	Flat
Volume solids, %:	26 ± 1
Theoretical spreading rate:	see REMARKS overleaf
Flash point:	4 °C [39.2 °F]
Specific gravity:	1.2 kg/litre [9.9 lbs/US gallon]
Dry to handle:	6 minute(s) (approx.), 20°C/68°F
Fully cured:	7 day(s) , 20°C/68°F
VOC content:	637 g/l [5.3 lbs/US gallon]

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

APPLICATION DETAILS:

Version, mixed product:	15275
Mixing ratio:	BASE 15274: CURING AGENT 95175 6.5:3.5 by volume
Application method:	Airless spray / Air spray / Brush (touch up)
Thinner (max.vol.):	08570 (20%) / 08570 (20%) / 08570 (20%)
Pot life:	24 approx. hour(s) 20°C/68°F
Nozzle orifice:	0.021 "
Nozzle pressure:	75 bar [1087.5 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	20 micron [0.8 mils] see REMARKS overleaf
Indicated film thickness, wet:	Not relevant
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf

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: **New steel:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to the cleaning degree specified for the final coating system, usually Sa 2½ (ISO 8501-1:2007). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating. For repair and touch-up use: primer specified for final coating system.

APPLICATION CONDITIONS: Use only where application and drying can proceed at temperatures above: 10°C/50°F. The temperature of the surface and that of the paint itself must also be above this limit. Maximum steel temperature approximately: 45°C/113°F. Special measures must be taken for shopprimer applications at temperatures above app.: 45°C/113°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None.

SUBSEQUENT COAT: According to specification.

REMARKS:

Application(s): Theoretical spreading rate: On steel abrasive blasted to a profile, Ra = 12½ micron/0.5 mils, equivalent to Rugotest No. 3, N10a-b, or Keane-Tator Comparator, 3.0 mils segments, or ISO Comparator Medium (G), the indicated 15 micron/0.6 mils film thickness corresponds to approximately 25 micron/1 mil measured on a smooth test panel (see special instructions for this procedure). Corresponding "theoretical" spreading rate will be 10.4 m²/l (417 sq.ft./US gallon). On steel abrasive blasted to a profile, Ra = 6.3 micron/¼ mil, equivalent to Rugotest No. 3, N9a, or Keane-Tator Comparator, 2.0 mils segments, or ISO Comparator Fine (G) the indicated 15 micron/0.6 mils film thickness corresponds to approximately 20 micron/0.8 mils measured on a smooth test panel (see special instructions for this procedure). Corresponding "theoretical" spreading rate will be 13 m²/l (521 sq.ft./US gallon).

Film thicknesses/thinning: Air spray: Air spray is usually performed by having a low pressure (e.g. 10:1) piston pump pumping the shopprimer under constant re-circulation. Recommended dry film thickness: 15 - 25 micron/ 0.2 - 1 mils measured on a smooth test panel. When applied at higher temperatures extra thinning or use of thinner with slower flash-off time may be needed to secure proper paint film formation. It is a must that a homogenous and smooth paint film is obtained.

Overcoating: Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

A specification supersedes any guideline overcoat intervals indicated in the table.

Environment	Atmospheric, medium					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	15 h	None	6 h	None	3 h	None

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

Overcoating note: Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

Overcoating intervals: No maximum overcoat interval for adhesion, but dictated by gradual breakdown and damage during exposure and fabrication.

Note: **HEMPEL'S SHOPPRIMER E 15275 For professional use only.**

ISSUED BY: HEMPEL A/S 1527550890

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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