

### 15400: BASE 15409: CURING AGENT 95100

<b>Description:</b>	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.
<b>Recommended use:</b>	As a tank lining. HEMPADUR 15400 is suitable for application down to minimum 10°C/50°F. For colder application temperatures down to minimum 5°C/41°F use HEMPADUR 15402.
<b>Service temperature:</b>	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.
<b>Certificates/Approvals:</b>	Tested for non-toxicity of welding fumes by the Danish Welding Institute Tested according to section 175.300 of the Code of Federal Regulations Title 21 – Liquid Foodstuff. Consult Hempel for details.
<b>Availability:</b>	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 <sup>2</sup> /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:	1.5 hour(s) 20°C/68°F
Through-dry:	4.5 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. <i>*other shades according to assortment list.</i>

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

#### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>15400</b>
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]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf

<b>Safety:</b>	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. The optimal paint temperature for proper mixing, pumping and spraying is 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 overcoating 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.
- 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	Immersion					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	30 h	28 d	10 h	21 d	5 h	14 d

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

**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

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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](http://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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