

15590: BASE 15599: CURING AGENT 95100

Description:	HEMPADUR 15590 is a two-component epoxy primer coating especially for use on surfaces exposed to severe abrasion.
Recommended use:	As a blast primer for heavy duty epoxy systems on submerged and non-submerged areas according to specification.
Service temperature:	Maximum, dry exposure only: 140°C/284°F
Certificates/Approvals:	
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	56880 / Red.
Finish:	Semi-gloss
Volume solids, %:	44 ± 1
Theoretical spreading rate:	11 m ² /l [441.1 sq.ft./US gallon] - 40 micron/1.6 mils
Flash point:	26 °C [78.8 °F]
Specific gravity:	1.3 kg/litre [11 lbs/US gallon]
Surface-dry:	1 hour(s) 20°C/68°F
Through-dry:	3.5 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	499 g/l [4.1 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.

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

APPLICATION DETAILS:

Version, mixed product:	15590
Mixing ratio:	BASE 15599: CURING AGENT 95100 15 : 4 by volume
Application method:	Airless spray / Air spray
Thinner (max.vol.):	08450 (5%) / 08450 (15%)
Pot life:	2 hour(s) 20°C/68°F
Nozzle orifice:	0.017 - 0.019 "
Nozzle pressure:	150 bar [2175 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	40 micron [1.6 mils]
Indicated film thickness, wet:	100 micron [4 mils]
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 minimum Sa 2½ (ISO 8501-1: 2007) with a surface profile corresponding to Rugotest No. 3, N9a to N10, preferably BN9a to BN10, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G). After blasting, clean the surface carefully from abrasives and dust.
Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting or, alternatively, dry abrasive blasting, high pressure fresh water hosing, drying, and finally dry abrasive blasting again.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Minimum temperature for application is 5°C/41°F, preferably above 10°C/50°F. Relative humidity maximum 80 %, preferably below 60%.
The temperature of the paint itself should be: Between 15°C (59°F) and 25°C (77°F).
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None.

SUBSEQUENT COAT: Recommended systems are: HEMPADUR MULTI-STRENGTH 35530, HEMPADUR MULTI-STRENGTH 45751.
HEMPADUR 15590 can be used as a blast primer.

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: 30-50 micron/1.2-2 mils.

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)	
Surface temperature:	Min	Max	Min	Max	Min	Max
HEMPADUR	18 h	67½ d	8 h	30 d	5 h	20 d
Environment	Immersion					
HEMPADUR	18 h	67½ d	8 h	30 d	5 h	20 d

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

Overcoating note: The coating is to be applied in a dry film thickness as near as possible to the specified: 40 micron. Film formation of each coat has to be of good quality, free from defects such as pinholes and without any dry spray.
Drying and curing conditions have to be according to APPLICATION CONDITIONS until full curing has been obtained.
No kind of surface contamination must exist except loose dust, abrasives, loose dry-spray, which is possible to remove by vacuum cleaning before overcoating.
The surface MUST be completely clean before overcoating. The coating is to be checked carefully and should have no patchy, whitish, and/or greasy formation, which can hinder adhesion of the subsequent coat.
Exudation of the curing agent causes the mentioned patchy, whitish, and/or greasy formation, which will take place if the product is applied at low temperatures without proper induction time and/or if the coating is exposed to water (rain, condensation) during drying and curing.

Overcoating intervals: Overcoating intervals: According to specification.
The stated minimum overcoating interval may be halved for areas not intended for water immersion. Depending on actual local conditions, extended maximum overcoating interval may apply. Contact HEMPEL for more information. If the maximum over coating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly by high pressure water cleaning and allow drying. The product will resist a hosing down of the surface 8 hours after application at a steel temperature of 20°C/68°F.

Note: **HEMPADUR 15590 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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