

15560: BASE 15569 : CURING AGENT 97560

Description:	HEMPADUR FAST DRY 15560 is a two-component epoxy paint with a very short drying time. Contains zinc phosphate.
Recommended use:	As a quick drying primer or intermediate coat in HEMPADUR systems for especially fast recoatable in-shop applications. Can be used for on-site work too if eg VOC compliance is requested.
Service temperature:	Maximum, dry exposure only: 140°C/284°F
Certificates/Approvals:	Approved as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on www.Hempel.com for further details. Complies with EU Directive 2004/42/EC: subcategory j.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	11320* / Grey. see REMARKS overleaf
Finish:	Flat
Volume solids, %:	62 ± 1
Theoretical spreading rate:	6.2 m ² /l [248.6 sq.ft./US gallon] - 100 micron/4 mils
Flash point:	27 °C [80.6 °F]
Specific gravity:	1.4 kg/litre [11.9 lbs/US gallon]
Surface-dry:	0.5 hour(s) 20°C/68°F
Through-dry:	2 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	350 g/l [2.9 lbs/US gallon]
Shelf life:	2 years for BASE and 2 years (25°C/77°F) for CURING AGENT from time of production. <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:

Version, mixed product:	15560
Mixing ratio:	BASE 15569 : CURING AGENT 97560 4 : 1 by volume
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (15%) / 08450 (5%)
Pot life:	2 hour(s) 20°C/68°F
Nozzle orifice:	0.019 - 0.021 "
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:	100 micron [4 mils] see REMARKS overleaf
Indicated film thickness, wet:	175 micron [7 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 Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use: HEMPADUR FAST DRY 15560.
Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove all rust and loose material by wet or dry abrasive blasting or power tool cleaning. After wet abrasive blasting hose down the surface with fresh water and allow drying. Feather edges to sound and intact areas. Dust off residues. Touch up bare spots to full film thickness.

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: 0°C/32°F
The temperature of paint itself should be 15°C/59°F or above.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None, or as per specification.

SUBSEQUENT COAT: According to specification. HEMPADUR HEMPATEX HEMPETHANE HEMUCRYL

REMARKS:

Colours/Colour stability: Has a tendency to yellow after application. This will have no influence on the performance.

Weathering/service temperatures: The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

Application(s): **Irregular surfaces:** Similar to other very fast drying/curing epoxies; this product is sensitive towards the geometry of irregular surfaces. Special care should be taken in relation to irregular surfaces (welding seams, undercuts, corners etc.) as application with an excessive film thickness may result in cracking.

Film thicknesses/thinning: **Film thickness:**
The recommended nominal dry film thickness (NDFT) is 75-150 micron/3-6 mils.
Overthickness on irregular surfaces shall be avoided or highly controlled.
Overthickness on overlapping areas, corners, welding seams, etc should be less than 300 µm/12 mils DFT.

Shades: CURING AGENT 97560 will become darker during storage. This will result in darker and more yellowish shade than grey 12170. The colour change will have no influence on the performance. The product is also available in a Micaceous Iron Oxide (MIO) pigmented shade (Shade no. 12430 – reddish grey).

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	4 h	90 d	2 h	90 d	90 m	60 d
HEMPATEX	2 h	16 h	1 h	8 h	45 m	6 h
HEMPATHANE	4 h	20 d	2 h	10 d	90 m	8 d

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

Overcoating note: In case of overcoating with coating other than HEMPADUR, apply a (thin) additional coat of the product within the described directions for overcoating.
A completely clean surface is mandatory to ensure intercoat adhesion, especially at long overcoating 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 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: **HEMPADUR FAST DRY 15560 For professional use only.**

ISSUED BY: HEMPEL A/S 1556011320

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.
The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.