

### 15300: BASE 15309: CURING AGENT 95040

<b>Description:</b>	HEMPADUR PRIMER 15300 is a two-component epoxy primer containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rustpreventing coating.
<b>Recommended use:</b>	As a primer or intermediate coat in container systems. May be used as a general purpose epoxy primer according to painting specification.
<b>Service temperature:</b>	Maximum, dry exposure only: 140°C/284°F In water (no temperature gradient): 35°C/95°F
<b>Availability:</b>	Generally for container newbuildings only.

### PHYSICAL CONSTANTS:

Shade nos/Colours:	50890* / Red.
Finish:	Flat
Volume solids, %:	51 ± 1
Theoretical spreading rate:	12.8 m <sup>2</sup> /l [513.3 sq.ft./US gallon] - 40 micron/1.6 mils
Flash point:	26 °C [78.8 °F]
Specific gravity:	1.3 kg/litre [10.8 lbs/US gallon]
Surface-dry:	1 hour 20°C/68°F
Dry to touch:	2 - 3 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	438 g/l [3.6 lbs/US gallon]
Shelf life:	3 years for BASE and 3 years (25°C/77°F) for CURING AGENT from time of production.

*\*other shades according to assortment list.*

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

### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>15300</b>
Mixing ratio:	BASE 15309: CURING AGENT 95040 4 : 1 by volume
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	08450 (25%) / 08450 (50%) / 08450 (5%) For on-line container production thinning according to specification
Pot life (Airless spray):	8 hour(s) 20°C/68°F
Pot life (Brush):	8 hour(s) 20°C/68°F
Nozzle orifice:	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:	40 micron [1.6 mils] see REMARKS overleaf
Indicated film thickness, wet:	75 micron [3 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:** **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 PRIMER 15300.  
**Other metals and light alloys:** Thorough degreasing and removal of any salty contamination. Abrasive sweeping to create a suitable dense anchor profile.  
**Repair and maintenance:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007). Improved surface preparation will improve the performance. As an alternative to dry cleaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of maximum FR-2 (Hempel standard) is acceptable before application. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness.  
 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. Use only where application and curing can proceed at temperatures above: 10°C/50°F. The temperature of paint itself should be 15°C/59°F or above. In confined spaces provide adequate ventilation during application and drying.

**SUBSEQUENT COAT:** According to specification. HEMPATEX HI-BUILD 46370.

**REMARKS:**

**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.

**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: 25-80 micron/1-3.2 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	Immersion					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	15 h	75 h	6 h	30 d	3 h	15 d

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

**Overcoating intervals:** Minimum (primarily only relevant for container coatings): 20 minutes' flash-off time for 40 micron/1.6 mils HEMPADUR PRIMER 15300 when topcoated with designed container coatings, epoxy, polyurethane, acrylic or CR types.  
 The minimum recoating interval only applies in the case of forced ventilation, proper application and if the completed paint system is thoroughly dry before exposed to aggressive environments.  
 Maximum: Recoating interval for non-immersion services is 24 hours for acrylic or CRs, 3 days for PUs and none for epoxies.  
 In the case of long recoating intervals, a completely clean surface is mandatory to ensure intercoat adhesion. Any dirt, oil and grease to be removed with eg 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 as well. 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 PRIMER 15300 For professional use only.**

**ISSUED BY:** HEMPEL A/S 1530050890

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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