



Product Data

HEMPADUR® FAST DRY 15560

BASE 15569 with CURING AGENT 97560

Description: HEMPADUR FAST DRY 15560 is a two-component, polyamine adduct cured 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 temperatures: Maximum, dry exposure only: 140°C/284°F. See REMARKS overleaf.

Availability: Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/12170*	Reddish grey/12430* (MIO version) (See REMARKS overleaf)
Finish:	Flat	Flat
Volume solids, %:	62 ± 1	62 ± 1
Theoretical spreading rate:	6.2 m ² /litre - 100 micron 249 sq.ft./US gallon - 4 mils	6.2 m ² /litre - 100 micron 249 sq.ft./US gallon - 4 mils
Flash point:	27°C/81°F	27°C/81°F
Specific gravity:	1.4 kg/litre - 11.6 lbs/US gallon	1.5 kg/litre - 12.5 lbs/US gallon
Surface dry:	½ (approx.) hr at 20°C/68°F (ISO 1517)	½ (approx.) hr at 20°C/68°F (ISO 1517)
Dry to touch:	1-1½ hour at 20°C/68°F	1-1½ hour at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
V.O.C.:	330 g/litre - 2.7 lbs/US gallon (According to EPA Fed Ref Method 24)	330 g/litre - 2.7 lbs/US gallon (According to EPA Fed Ref Method 24)

*Another shade: red 50630 may be available according to assortment list.

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

APPLICATION DETAILS:

Mixing ratio for 15560:	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 hours (20°C/68°F)	
Nozzle orifice:	.019"-.021"	
Nozzle pressure:	175 bar/2500 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	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



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SURFACE PREPARATION: **New steel (dry conditions):** Abrasive blasting to Sa 2½. For temporary protection, if required, use 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 15560.

Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt 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. Feather edges to sound and intact areas. After wet abrasive blasting hose down the surface with fresh water and allow drying. Touch up bare spots to full film thickness.

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 0°C/32°F. The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None, or according to specification.

SUBSEQUENT COAT: HEMPADUR, HEMPATHANE, HEMPATEX or HEMUCRYL as per specification.

REMARKS:

Shade: CURING AGENT 97560 will become darker during storage. This will result in a darker and more yellowish shade than grey 12170. The colour change 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.

Film thicknesses: 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 recoating interval. Normal range is 75-150 micron/3-6 mils.

Irregular surfaces: Special care should be taken in relation to irregular surfaces (welding seams, undercuts etc.) as application with an excessive film thickness - typically being more than 400 micron/16 mils per coat - may result in cracking especially on such areas.

Recoating: Recoating intervals related to later conditions of exposure:
(Dry film thickness of HEMPADUR FAST DRY 15560 as indicated below)

	Minimum In-field application* 100 micron/4 mils		Minimum Workshop application 75 micron/3 mils		Maximum**	
Surface temperature	20°C/68°F		20°C/68°F		20°C/68°F	
Exposure during service	Atmospheric		Atmospheric		Atmospheric	
Recoated with	Medium	Severe	Medium	Severe	Medium	Severe
HEMPATEX	1 hour	2 hours	15 minutes	1 hour	8 hours	8 hours
HEMPADUR	2 hours	3 hours	1 hour	1½ hours	None	None
HEMPATHANE	2 hours	3 hours	1 hour	1½ hours	10 days	3 days
58030	1 hour	2 hours	1 hour	1½ hours	24 hours	8 hours

*In case of general maintenance involving epoxy systems of high total dry film thickness, the minimum recoating interval may advantageously be doubled up.

** For mild atmospheric exposure recoating with HEMPADUR and HEMPATHANE qualities has no maximum. For other qualities please contact HEMPEL.

If the maximum recoating interval is exceeded, whatever the subsequent coat, roughening of the surface is necessary to ensure optimum intercoat adhesion or in the case of recoating with coatings other than HEMPADUR, apply a (thin) additional coat of HEMPADUR FAST DRY 15560 within the above directions for recoating.

A completely clean surface is mandatory to ensure intercoat adhesion, especially in the case of long recoating intervals. Any dirt, oil and grease have 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 FAST DRY 15560 is for professional use only.**

ISSUED BY: HEMPEL A/S - 1556012170C0007

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