



# Product Data

## HEMPEL'S SHOPPRIMER E 15275

BASE 15274 with CURING AGENT 95175

**Description:** HEMPEL'S SHOPPRIMER E 15275 is a two-component epoxy polyamide shopprimer, pigmented with zinc phosphate rust-inhibiting pigments. It is designed for automatic spray application.

**Recommended use:** As a shopprimer for protection of blast cleaned steel plate and other structural steel during the storage and building period.

**Service temperatures:** Maximum, dry: 140°C/284°F.

**Certificates/Approvals:** Approved as a welding primer by Lloyd's Register of Shipping.

**Availability:** Not included in Group Assortment. Availability subject to special agreement.

### PHYSICAL CONSTANTS:

Colours/Shade nos: Red/50890  
Finish: Flat  
Volume solids, %: 23 ± 1  
Theoretical spreading rate: See REMARKS overleaf  
Flash point: 4°C/39°F  
Specific gravity: 1.1 kg/litre  
9.2 lbs/US gallon  
Dry to handle: 6 approx. min. at 20°C/68°F  
Fully cured: 7 days at 20°C/68°F  
V.O.C.: 650 g/litre - 5.4 lbs/US gallon

*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 15275: Base 15274 : Curing agent 95175  
6.5 : 3.5 by volume

Application method:	Airless spray	Air spray	Brush (touch up)
Thinner (max.vol.):	08570 (20%)	08570 (20%)	08570 (20%) (See REMARKS overleaf)
Pot life:	24 hours (20°C/68°F)		
Nozzle orifice:	.021"		
Nozzle pressure:	75 bar/1100 psi (Airless spray data are indicative and subject to adjustment)		

Cleaning of tools: HEMPEL'S TOOL CLEANER 99610

Indicated film thickness, dry: 15 micron/0.6 mils (See REMARKS overleaf)  
Indicated film thickness, wet: Not relevant

Recoat interval, min: 6 hours (20°C/68°F)  
Recoat interval, max: None (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:	<b>New steel:</b> Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to cleaning degree specified for final coating system, usually Sa 2½. Apply immediately after cleaning. All damaged shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to recoating. For repair and touch-up use primer specified for final coating system.
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the surface and that of the paint itself must also be above this limit. Maximum steel temperature approximately 45°C/113°F. For shopprimer application at temperatures above app. 45°C/113°F special measures must be taken (See "Thinning" under REMARKS below). Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	As per specification.
REMARKS:	Certificates are issued under the former quality number 1527. Recommended dry film thickness: 20-25 micron/0.8-1 mil measured on a smooth test panel.
Theoretical spreading rate:	On steel abrasive blasted to a profile, Ra = 12½ micron/0.5 mils, equivalent to Rugotest No. 3, N10a-b, or Keane-Tator Comparator, 3.0 mils segments, or ISO Comparator Medium (G), the indicated 15 micron/0.6 mils film thickness corresponds to approximately 25 micron/1 mil measured on a smooth test panel (see special instructions for this procedure). Corresponding "theoretical" spreading rate will be 9.2 m <sup>2</sup> /litre (369 sq.ft./US gallon). On steel abrasive blasted to a profile, Ra = 6.3 micron/¼ mil, equivalent to Rugotest No. 3, N9a, or Keane-Tator Comparator, 2.0 mils segments, or ISO Comparator Fine (G) the indicated 15 micron/0.6 mils film thickness corresponds to approximately 20 micron/0.8 mils measured on a smooth test panel (see special instructions for this procedure). Corresponding "theoretical" spreading rate will be 11.5 m <sup>2</sup> /litre (461 sq.ft./US gallon).
Air Spray:	Air spray is usually performed by having a low pressure (e.q. 10:1) piston pump pumping the shopprimer under constant re-circulation.
Recoating interval:	No maximum recoat interval for adhesion, but dictated by gradual breakdown and damage during exposure and fabrication.
Thinning:	When applied at higher temperatures extra thinning or use of thinner with slower flash-off time may be needed to secure proper paint film formation. It is a must that a homogenous and smooth paint film is obtained.
Notes:	Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure water cleaning and allow to dry.
	<b>HEMPEL'S SHOPPRIMER E 15275 is for professional use only.</b>
ISSUED BY:	HEMPEL A/S - 1527550890CS001

***This Product Data Sheet supersedes those previously issued.***

***For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.***

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***Product data are subject to change without notice and become void five years from the date of issue.***