

55610: BASE 55619: CURING AGENT 97050

Description:	HEMPATHANE HS 55610 is a two-component glossy acrylic polyurethane topcoat, cured with aliphatic isocyanate, with good gloss and colour retention. Contains zinc phosphate.
Recommended use:	As a VOC-compliant, high-build finishing coat for protection of structural steel in severely corrosive environment. May be specified as a one coat "Direct To Metal" system in environments classified as C2 and C3.
Service temperature:	Maximum, dry exposure only: 120°C/248°F see REMARKS overleaf
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:	10000/ White. (see REMARKS overleaf)
Finish:	Glossy
Volume solids, %:	67 ± 1
Theoretical spreading rate:	6.7 m ² /l [268.7 sq.ft./US gallon] - 100 micron/4 mils
Flash point:	31 °C [87.8 °F]
Specific gravity:	1.4 kg/litre [12 lbs/US gallon]
Surface-dry:	3 hour(s) 20°C/68°F
Through-dry:	8 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	337 g/l [2.8 lbs/US gallon]
Shelf life:	3 years for BASE and 2 years (25°C/77°F) for CURING AGENT from time of production. <i>*Wide range of colours available via Hempel's MULTI-TINT system. *other shades according to assortment list. The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>

APPLICATION DETAILS:

Version, mixed product:	55610
Mixing ratio:	BASE 55619: CURING AGENT 97050 7:1 by volume
Application method:	Airless spray/ Brush
Thinner (max.vol.):	08080 (5%) / 08080 (5%)
Pot life:	2 hour(s) 20°C/68°F
Nozzle orifice:	0.017 - 0.021 "
Nozzle pressure:	175 bar [2537.5 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S THINNER 08080
Indicated film thickness, dry:	100 micron [4 mils] / 4 mils (see REMARKS overleaf)
Indicated film thickness, wet:	150 micron [6 mils] / 6 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, min.AN10b. Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating. **Steel, maintenance:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½. Improved surface preparation will improve the performance of the paint. As an alternative to dry cleaning, water jetting to sound, well adhering coat and/or to steel. Intact coat must appear with roughened surface after the water jetting. By water jetting to steel, cleanliness shall be Wa 2 - Wa 2½ (atmospheric exposure) / minimum Wa 2½ (immersion) (ISO 8501-4:2006). A flash-rust degree of maximum M (atmospheric exposure), preferably L (immersion) (ISO 8501-4:2006) is acceptable before application. Feather edges to sound and intact paint. Dust off residues. Touch up to full film thickness. On pit-corroded surfaces, excessive amounts of salt residues may call for water jetting or wet abrasive blasting, alternatively dry abrasive blasting followed by 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 curing is: -10°C/14°F
At the freezing point and below be aware of the risk of ice on the surface, which will hinder adhesion. The film formation may be adversely affected by light rain, high humidity and/or condensation during application and the following interval after application: 8 hours, 20°C/68°F
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: According to specification. Recommended systems are: HEMPADUR AVANTGUARD 1736G / 1734G / 17382 / 17990, HEMPADUR MASTIC 45880/45881

SUBSEQUENT COAT: None.

REMARKS:

VOC - EU Directive 2004/42/EC:

Product	As supplied	5 vol. % thinning	Limit phase II, 2010
5561010000	337 g/l	363 g/l	500 g/l

For VOC of other shades, please refer to Safety Data Sheet.

Colours/Colour stability: Colour stability for some shades may be effected by exposure to harsh chemical atmospheres. This does not affect the performance of the coating. For certain colours extra coats may be necessary to obtain full opacity.
For aluminium pigmented shades scratching actions or high humidity/water may cause discolouration/ disturbances of the surface. This will have no influence on the performance. This phenomenon may be avoided by applying a clear varnish.

Weathering/service temperatures: At service temperature above 100°C/212°F, slight discolouration may be expected. The product will become softer.

Application(s): When specified as a one coat "Direct to Metal"-system follow "Good Painting Practise" and apply stripe coating before the spray application on areas difficult to cover properly by spray application.
CURING AGENT 97050 : is sensitive to moisture.
Even small traces of water in the mixed paint will reduce the pot life and result in film defects.

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: minimum 50 micron/2 mils (diluted), minimum 75 micron/3 mils (undiluted), maximum 125 micron/5 mils
Storage Conditions: Store in a dry place and keep the can tightly closed until use.

Shades: This product is available in several aluminium pigmented shades with different volume solids content. Contact HEMPEL for more information.

Curing agent: Open curing agent cans with caution as overpressure might exist.

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 (14°F)		0°C (32°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
HEMPATHANE	30 h	None	18 h	None	6 h	None

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

Overcoating note: 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. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.

Note: **HEMPATHANE HS 55610 For professional use only.**

ISSUED BY: HEMPEL A/S

5561010000

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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