Hempadur 15400

Product characteristics

Description
Hempadur 15400 is a two-component, amine adduct cured epoxy paint, which cures to a coating with excellent resistance to a wide range of chemicals as tabulated in separate CARGO PROTECTION GUIDE.

Recommended use
As a tank lining. Hempadur 15400 is suitable for application down to minimum 10°C/50°F. For colder application temperatures down to minimum 5°C/41°F use Hempadur 15402.

Service temperature:
- Maximum, dry exposure only: 140°C [284°F].
- Maximum, in water (no temperature gradient): 50°C [122°F].
- Other liquids: Please contact Hempel.

Certificates / Approvals
- Complies with US FDA and EU food regulations for contact with dry foodstuff. Consult Hempel for details.

Product safety

Flash point 26°C [79°F]

VOC content mixed product

Legislation	Value
EU	463 g/L [3.86 lb/US gal]
US (coatings)	463 g/L [3.86 lb/US gal]
US (regulatory)	463 g/L [3.86 lb/US gal]
China	463 g/L [3.86 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

Handling
Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code
15400

Product components
Base 15409
Curing Agent 95100

Standard shade / code
White 10000

Gloss
Semi-flat

Volume solids
48 ± 2%

Specific gravity
1.4 kg/L [12 lb/US gal]

Reference dry film thickness
80 micron [3.1 mils]

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Surface preparation

Cleanliness
- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

New build:
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

Maintenance and Repair
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

Roughness
- Surface profile Medium (G) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratio
Base 15409 : Curing Agent 95100
(4 : 1 by volume)

Stir well before use. It is recommended to use fixed volumes/can size for multi-component products.

Thinner
Hempel's Thinner 08450

Cleaner
Hempel's Tool Cleaner 99610

Pot life

Product temperature	15°C [59°F]	20°C [68°F]	30°C [86°F]
Induction time	25 min	15 min	5 min
Pot life	3 hours	2 hours	1 hour
Pot life (spray)	3 hours	2 hours	1 hour
Pot life (brush)	5 hours	4 hours	2 hours

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 200 bar [2900 psi] Nozzle orifice: 0.018-0.021"
Brush	5%	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	80 micron [3.1 mils]	125 micron [4.9 mils]	80 micron [3.1 mils]
Wet film thickness	170 micron [7 mils]	250 micron [10 mils]	170 micron [7 mils]
Theoretical spreading rate	6 m²/L [240 sq ft/US gal]	3.8 m²/L [150 sq ft/US gal]	6 m²/L [240 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

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Application conditions
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above 10°C [50°F] during application and curing.
- Optimal paint temperature for proper mixing, pumping and spraying is: 15-25°C [59-77°F].
- Temperature of product must be above 10°C [50°F] during application.
- Provide adequate ventilation during application and drying.

Relative Humidity:
- Relative humidity must be below 80% during curing.
- Relative humidity must be below 80% during application.

Drying and overcoating

Product compatibility
- Previous coat: None or according to Hempel's specification.
- Subsequent coat: None or according to Hempel's specification.

Drying time

Surface temperature		20°C [68°F]
Touch dry	hours	1½
Hard dry	hours	4½

Determined for dry film thickness 80 micron [3.1 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		10°C [50°F]	20°C [68°F]	30°C [86°F]
		Immersion		
Hempadur 15400	Min	30 h	10 h	5 h
	Max	28 d	21 d	14 d

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions
- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details
- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

Other remarks
- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	36 months
Curing Agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Storage conditions
- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.

Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	12.2 g CO_2e/m^2	0.063 lb CO_2e/ft^2

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

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The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

Additional documents

Additional information is available at the Hempel website https://www.hempel.com/service-and-support/technical-guidelines or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- General Application Guidelines