

# Hempadur Primer 15300

## Product characteristics

### Description

Hempadur Primer 15300 is an epoxy primer containing zinc phosphate as corrosion inhibiting pigment. It cures to a strong and rust preventing coating.

### Recommended use

Hempadur Primer 15300 is recommended as a primer or intermediate coat in container systems. The product can be used as a general purpose epoxy primer according to painting specification.

### Service temperature:

- Maximum, dry exposure only: 140°C [284°F].
- Maximum, in water (no temperature gradient): 35°C [95°F].

## Product safety

**Flash point** 26°C [79°F]

### VOC content mixed product

Legislation	Value
EU	440 g/L [3.67 lb/US gal]
US (coatings)	440 g/L [3.67 lb/US gal]
US (regulatory)	440 g/L [3.67 lb/US gal]
China	440 g/L [3.67 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://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

15300

### Product components

Base 15309  
Curing Agent 95040

### Standard shade\* / code

Brownish red 50890 \*\*

### Gloss

Flat

### Volume solids

51 ± 2%

### Specific gravity

1.3 kg/L [11 lb/US gal]

### Reference dry film thickness

40 micron [1.6 mils]

\* Other shades are available, please contact your local Hempel representative.

\*\* Epoxy coatings have an inherent tendency of chalking, fading and discolouring. This does not affect the performance of the coating

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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:

- All damage of shopprimer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting.
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Stainless steel, aluminium and other non ferric metals and alloys: use non-metallic blast media (corundum, garnet, etc.).
- Remove dust, blast media and loose materials.

### Maintenance and Repair

- Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC).
- Stainless steel, aluminium and other non ferric metals and alloys: use non-metallic blast media (corundum, garnet, etc.).
- Minor areas can be cleaned by power tool to St 3 provided the surface is roughened and not polished.
- Water jetting to min. Wa 2 (ISO 8501-4).
- Flash rust degree of maximum FR M (ISO 8501-4).
- Remove dust, blast media and loose materials.

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

## Application

### Mixing ratio

Base 15309 : Curing Agent 95040  
(4 : 1 by volume)

Stir well before use.

### Thinner

Hempel's Thinner 08450

### Cleaner

Hempel's Tool Cleaner 99610

### Pot life

Product temperature	20°C [68°F]
Pot life	8 hours
Pot life (spray)	8 hours
Pot life (brush)	8 hours

### Application method

Tool	Application parameters
Airless spray	Nozzle pressure: 175 bar [2500 psi] Nozzle orifice: 0.021"
Air spray	Not Applicable.
Brush	Not Applicable.

To comply with Korean VOC regulation, thinning is limited to max. vol. 1%. 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	25 micron [1.0 mils]	80 micron [3.2 mils]	40 micron [1.6 mils]
Wet film thickness	49 micron [2.0 mils]	157 micron [6.3 mils]	78 micron [3.1 mils]
Theoretical spreading rate	20 m <sup>2</sup> /L [815 sq ft/US gal]	6.4 m <sup>2</sup> /L [261 sq ft/US gal]	13 m <sup>2</sup> /L [530 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.

### 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.
- Temperature of product must be above 15°C [59°F] during application.

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## Drying and overcoating

### Product compatibility

- Previous coat: None.
- Subsequent coat: According to Hempel's Specification.

### Drying time

Surface temperature		20°C [68°F]
Surface dry	min	120
Fully cured	days	7

Determined for dry film thickness 40 micron [1.6 mils] at standard conditions, see Hempel's Explanatory Notes for details.

### Overcoating

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

- 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

- The product must be stored in accordance with Safety Data Sheet, label and local regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

## Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	9.6 g CO <sub>2</sub> e/m <sup>2</sup>	0.05 lb CO <sub>2</sub> e/ft <sup>2</sup>

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

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.

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## 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

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at [www.hempel.com](http://www.hempel.com) (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from [www.hempel.com](http://www.hempel.com).

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.