

Hempadur Enamel

Product characteristics

Description

Hempadur Enamel 55340 is a two-component, polyamide cured epoxy enamel. Resistant to impact and abrasion and to splashes of petrol, mineral oils, vegetable and animal oils, but not to acids or strong solvents. A tendency to chalk in outdoor exposure does not detract from the protective properties.

Recommended use

Hempadur Enamel is recommended as a topcoat in epoxy paint systems on structural steel, in moderately to severely corrosive environment.

May be used on dry concrete floors not exposed to heavy traffic.

Service temperature:

- Maximum, dry exposure only: 140°C [284°F].

Product safety

Flash point 23°C [73°F]

VOC content mixed product

Legislation	Value
EU	499 g/L [4.16 lb/US gal]
US (coatings)	499 g/L [4.16 lb/US gal]
US (regulatory)	499 g/L [4.16 lb/US gal]
China	499 g/L [4.16 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

55340

Product components

Base 55349

Curing Agent 95020

Standard shade* / code

White 10000

Gloss

Glossy

Volume solids

42 ± 2%

Specific gravity

1.2 kg/L [10 lb/US gal]

Reference dry film thickness

40 micron [1.6 mils]

Surface preparation

Cleanliness

- According to Hempel's Specification.

New build:

- According to Hempel's Specification.

Maintenance and Repair

- According to Hempel's Specification.

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

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Application

Mixing ratio

Base 55349 : Curing Agent 95020
(1.5 : 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

Application method

Tool	Application parameters
Airless spray	Nozzle pressure: 150 bar [2200 psi] Nozzle orifice: 0.018-0.021"
Air spray	Not Applicable.
Brush	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	30 micron [1.2 mils]	50 micron [2.0 mils]	40 micron [1.6 mils]
Wet film thickness	71 micron [2.8 mils]	118 micron [4.7 mils]	94 micron [3.8 mils]
Theoretical spreading rate	14 m ² /L [570 sq ft/US gal]	8.5 m ² /L [346 sq ft/US gal]	11 m ² /L [448 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 10°C [50°F] during application.

Drying and overcoating

Product compatibility

- Previous coat: None or according to Hempel's specification.
Recommended products are: Hempadur
- Subsequent coat: None.

Drying time

Surface temperature	20°C [68°F]
Hard dry	hours 5½

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

Drying conditions

- Condensation on the freshly applied coating should be avoided.

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Overcoating details

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

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)	15.6 g CO ₂ e/m ²	0.081 lb CO ₂ e/ft ²

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.

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.
- For further information see Hempel's Technical Guidelines.
- 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 (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 www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

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.

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.