Hempadur XP 87550

Product characteristics

Description
Hempadur XP 87550 is an amine-adduct cured epoxy coating. It is hard, impact and abrasion resistant with excellent temperature resistance and cathodic disbondment resistance. The product can be applied by standard heavy duty airless spray equipment.

Recommended use
As a self-primed, high build coating primarily for protection of exterior of steel pipes in severely corrosive environment, including burried pipelines in wet grounds.

For new constructions as well as a field-applied renovation and repair coating.

Can be applied to lines while in service at temperatures up to 90°C/194°F.

Service temperature:
- Maximum, dry exposure only: 130°C [266°F].
- Wet (as external coating on hot pipes only): 110°C [230°F].

Product safety

Flash point 14°C [57°F]

VOC content mixed product

Legislation	Value
EU	159 g/L [1.33 lb/US gal]
US (coatings)	159 g/L [1.33 lb/US gal]
US (regulatory)	159 g/L [1.33 lb/US gal]
China	159 g/L [1.33 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.

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
87550

Product components
Base 87559
Curing Agent 98550

Standard shade / code
Aluminium brown 59700 *

Gloss
Glossy

Volume solids
90 ± 2%

Specific gravity
1.6 kg/L [13 lb/US gal]

Reference dry film thickness
600 micron [24 mils]

* Epoxy coatings may discolour and chalk when exposed to UV light. 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:
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

Maintenance and Repair
- According to Hempel's Specification.

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

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

Application

Mixing ratio
Base 87559 : Curing Agent 98550
(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	90 min

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	2%	Nozzle pressure: 250 bar [3600 psi] Nozzle orifice: 0.023-0.025"

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	400 micron [16 mils]	900 micron [35 mils]	600 micron [24 mils]
Wet film thickness	450 micron [18 mils]	1000 micron [40 mils]	650 micron [26 mils]
Theoretical spreading rate	2.3 m²/L [94 sq ft/US gal]	1 m²/L [41 sq ft/US gal]	1.5 m²/L [61 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.
- Can be applied onto hot substrate up to maximum 90°C [194°F].
- Temperature of product must be above 10°C [50°F] during application.
- Optimal paint temperature for proper mixing, pumping and spraying is: 20-30°C [68-86°F].

Relative Humidity:
- Relative humidity must be in the range 30-85% during curing.
- Relative humidity must be in the range 30-85% during application.

Application remarks
- Due to a high concentration of conductive barrier pigments in the product, high voltage holiday detection is not applicable.

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Drying and overcoating

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

Drying time

Surface temperature		20°C [68°F]
Hard dry	hours	7

Determined for dry film thickness 600 micron [24 mils] at standard conditions, see Hempel's Explanatory Notes for details.

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	24 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)	8.3 g CO_2e/m^2	0.043 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.

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 (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.