



HEMPAXANE CLASSIC 55000

APPLICATION AND CURING CONDITIONS: The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 0°C/32°F, minimum relative humidity 30%. In confined spaces provide adequate ventilation during application and drying.
Reference is made to separate application instructions.

PRECEDING COAT: HEMPADUR-system or GALVOSIL according to specification.

SUBSEQUENT COAT: None.

REMARKS:

VOC - EU directive 2004/42/EC:

	As supplied	10 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	225	290	550	500

VOC:

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

Colours:

Certain lead-free red and yellow colours may discolour when exposed to chlorine- containing atmosphere.
Leaded colours may become discoloured when exposed to sulphide-containing atmosphere.

Service

temperatures:

At service temperature above 100°C/212°F, slight discoloration may be expected

Film thicknesses:

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 recoating interval. Normal range is 100 - 125 micron/4 -5 mils.
If the product is specified in lower film thickness, more thinning will be needed for proper film formation during spray application - additionally the colour in the preceding coat should be considered to reduce contrast.

Recoating on HEMPADUR:

Recoat intervals related to later conditions of exposure:
(150 micron/6 mils dry film thickness of HEMPAXANE CLASSIC 55000):

	Minimum			Maximum		
Surface temperature	20°C/68°F			20°C/68°F		
Recoated with (quality numbers only)	Atmospheric			Atmospheric		
	Mild	Medium	Severe	Mild	Medium	Severe
55000	6 hours	6 hours	7 hours	30 days	30 days	30 days

Thinner: THINNER 08080 is recommended in general. THINNER 08510 may be used alternatively depending on local conditions.

Exposure to humidity: HEMPAXANE CLASSIC 55000 will resist condensation and light rain after the dry to touch stage has been reached.

Recoating: If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Application onto zinc silicate:

It is recommended to apply HEMPAXANE CLASSIC 55000 by using a "mist-coat" procedure **provided** the paint temperature is approximately above 20°C/68°F: A thin, undiluted coat is applied (the mist coat) and after a few minutes, a second coat is applied in the full specified film thickness. If the paint temperature is below 20°C/68°F, thinning (max 15%) may be required.
HEMPAXANE CLASSIC 55000 is for professional use only.

ISSUED BY: HEMPEL A/S - 5500017380CR005

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.

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