



HEMPATHANE HS 55610

BASE 55619 with CURING AGENT 97050

Description: HEMPATHANE HS 55610 is a two-component polyurethane topcoat, cured with aliphatic isocyanate, with good gloss and colour retention. Contains zinc phosphate.

Recommended use: As a VOC-compliant, high-build finishing coat for protection of structural steel in corrosive environment.
May be specified as a one coat "Direct To Metal" system in mild atmospheric environments.

Service temperatures: Maximum, dry exposure only: 120°C/248°F (see *REMARKS overleaf*)

Availability: Not included in Group Assortment. Availability subject to special agreement.

PHYSICAL CONSTANTS:

Colours/Shade nos: White/10000*
Finish: Glossy
Volume solids, %: 65 ± 1
Theoretical spreading rate: 6.5 m²/litre - 100 micron
261 sq.ft./US gallon - 4 mils
Flash point: 31°C/88°F
Specific gravity: 1.4 kg/litre - 11.7 lbs/US gallon
Surface dry: 3 (approx.) hours at 20°C/68°F (ISO 1517)
Dry to touch: 5 (approx.) hours at 20°C/68°F
Fully cured: 7 days at 20°C/68°F
V.O.C.: 330 g/litre - 2.7 lbs/US gallon

**Wide range of colours available via Hempel's MULTI-TINT system.*

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

APPLICATION DETAILS:

Mixing ratio for 55610: Base 55619 : Curing agent 97050
7 : 1 by volume

Application method:	Airless spray (see <i>REMARKS overleaf</i>)	Brush (see <i>REMARKS overleaf</i>)
Thinner (max.vol.):	08080 (5%)	08080 (5%)
Pot life:	2 hours (20°C/68°F)	
Nozzle orifice:	.017"-.021"	
Nozzle pressure:	175 bar/2540 psi (<i>Airless spray data are indicative and subject to adjustment</i>)	
Cleaning of tools:	THINNER 08080/08880	
Indicated film thickness, dry:	100 micron/4 mils (see <i>REMARKS overleaf</i>)	
Indicated film thickness, wet:	150 micron/6 mils	
Recoat interval, min:	16 hours (20°C/68°F)	
Recoat interval, max:	None (see <i>REMARKS overleaf</i>)	

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



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SURFACE PREPARATION: For one coat, direct to metal: as per relevant painting specification.

APPLICATION 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 -10°C/ 14°F.
At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 24 hours (20°C/68°F) may adversely affect the film formation.
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: HEMPADUR FAST DRY 15560, HEMPADUR MASTIC 45880/45881 or according to specification.

SUBSEQUENT COAT: None.

REMARKS:
Service temperatures: At service temperatures above 100°C/212°F HEMPATHANE HS 55610 will become more soft. Furthermore, discolouration may occur.

VOC - EU directive 2004/42/EC:
VOC:

	As supplied	5 vol. % thinning	Limit phase, 2010
VOC in g/l	330	360	500

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.
To obtain full opacity, an extra coat may be necessary, especially for certain lead-free colours in eg red, orange, yellow and green.

Stripe coating: When specified as a one coat "Direct to Metal"-system 100 micron/4 mils must be applied. In addition follow "Good Painting Practise" and apply stripe coating before the spray application on areas difficult to cover properly by spray application.

Film thicknesses: May be specified in another film thickness than indicated depending on purpose and area of use. Normal range dry is minimum 50 micron/2 mils (diluted) and minimum 75 micron/3 mils (undiluted), maximum 125 micron/5 mils. This will alter spreading rate and may influence drying time and recoat interval.

Recoat interval: **Maximum recoating interval: A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoat intervals. Any dirt, oil, and grease have to be removed. e.g. with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed by fresh water hosing.**
To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

Notes: CURING AGENT 97050 is sensitive to moisture. Store in a dry place and keep the can tightly closed until use. Open curing agent cans with caution as overpressure might exist. Even small traces of water in the mixed paint will reduce the pot life and result in film defects.

HEMPATHANE HS 55610 is for professional use only.

ISSUED BY: HEMPEL A/S - 5561010000CR001

This Product Data Sheet supersedes those previously issued.

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

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