

55102: BASE 55107: CURING AGENT 95304

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| Description: | HEMPEL'S POLYENAMEL 55102 is a two-component, high-gloss acrylic polyurethane enamel cured with aliphatic isocyanate, with good gloss and colour retention. |
| Recommended use: | As a glossy decorative topcoat in severely corrosive atmospheric environments on properly prepared metals such as aluminium, stainless steel and galvanized steel. Excellent adhesion on wood and glass-fibre reinforced polyester |
| Service temperature: | Maximum, dry exposure only: 120°C/248°F (see REMARKS overleaf) |
| Certificates/Approvals: | Complies with European Fire Standard EN 13501-1; classification B-s1, d0. Complies with EU Directive 2004/42/EC: subcategory j. |
| Availability: | Part of Group Assortment. Local availability subject to confirmation. |
| PHYSICAL CONSTANTS: | |
| Shade nos/Colours: | 10000*/ White |
| Finish: | High-gloss |
| Volume solids, %: | 52 ± 1 |
| Theoretical spreading rate: | 14.9 m ² /l [597.5 sq.ft./US gallon] - 35 micron/1.4 mils |
| Flash point: | 35 °C [95 °F] |
| Specific gravity: | 1.2 kg/litre [10 lbs/US gallon] |
| Surface-dry: | 2 hour(s) 20°C/68°F |
| Through-dry: | 6.5 hour(s) 20°C/68°F (see REMARKS overleaf) |
| Fully cured: | 7 day(s) 20°C/68°F (see REMARKS overleaf) |
| VOC content: | 435 g/l [3.6 lbs/US gallon] |
| Shelf life: | 3 years for BASE and 1 year (25°C/77°F) for CURING AGENT from time of production. <i>*Wide range of colours available via Hempel's MULTI-TINT system. This product is available in several aluminium pigmented shades with different volume solids content.</i> <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i> |
| APPLICATION DETAILS: | |
| Version, mixed product: | 55102 |
| Mixing ratio: | BASE 55107: CURING AGENT 95304 4:1 by volume |
| Application method: | Airless spray / Air spray / Brush |
| Thinner (max.vol.): | 08880 or 08080 (5%) / see REMARKS overleaf |
| Pot life: | 2 approx. hour(s) 20°C/68°F |
| Nozzle orifice: | 0.017 - 0.019 " |
| Nozzle pressure: | 75 - 100 bar [1087.5 - 1450 psi] (Airless spray data are indicative and subject to adjustment) |
| Cleaning of tools: | HEMPEL'S THINNER 08080 or 08510 |
| Indicated film thickness, dry: | 35 micron [1.4 mils] |
| Indicated film thickness, wet: | 75 micron [3 mils] |
| Overcoat interval, min: | see REMARKS overleaf |
| Overcoat interval, max: | see REMARKS overleaf |
| Safety: | Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations. |

Product Data

HEMPEL'S POLYENAMEL 55102



SURFACE PREPARATION: According to 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.

PRECEDING COAT: HEMPADUR or according to specification.

SUBSEQUENT COAT: None.

REMARKS: Airless spray: 5-7% thinning is recommended. Contact HEMPEL for more information.

VOC - EU Directive 2004/42/EC:

| Product | As supplied | 15 vol. % thinning | Limit phase II, 2010 |
|------------|-------------|--------------------|----------------------|
| 5510210000 | 435 g/l | 498 g/l | 500 g/l |

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

Colours/Colour stability: Colour stability for some shades may be effected by exposure to harsh chemical atmospheres. This does not affect the performance of the coating.
For certain colours extra coats may be necessary to obtain full opacity.
This product is available in several aluminium pigmented shades with different volume solids content.

Weathering/service temperatures: At service temperature above 100°C/212°F, slight discolouration may be expected.

Application(s): The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate.:
Conventional airspray Dilute to a suitable viscosity, depending on the equipment and temperature.
Contact HEMPEL for more information. For both kinds of spray application the best result is obtained by applying a mist coat of the product at first, and then 2-15 minutes later apply to full film thickness giving a uniform film formation. Do not exaggerate the film thickness.

Film thicknesses/thinning: THINNER 08080 is recommended in general.
The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate.
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 overcoating interval. Normal range dry is: 30-40 micron/1.2-1.6 mils .
The recommended maximum dry film thickness per layer of aluminium finish is 30-40 microns to avoid sagging. Any thickness above should be applied in two layers.

Curing agent: CURING AGENT 95304 : is sensitive to moisture.
Even small traces of water in the mixed paint will reduce the pot life and result in film defects.
Open curing agent cans with caution as overpressure might exist. Store in a dry place and keep the can tightly closed until use.

Overcoating note: A completely clean surface is mandatory to ensure intercoat adhesion, especially at long overcoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed by fresh water hosing. To check adequate quality of the surface cleaning a test patch is recommended before actual overcoating.

Maximum overcoat interval refers to exterior surfaces exposed to periodical immersion, heavy condensation, great variations in temperature, splash and/or abrasion during service life of the coating system. Under other service conditions no maximum overcoat interval.

If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. In case of overcoating with other paint materials maximum will be: 1-3 days , 20°C/68°F depending on type.

Note: **HEMPEL'S POLYENAMEL 55102 For professional use only.**

ISSUED BY: HEMPEL A/S

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This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on www.hempel.com. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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