

# Hempel's Shopprimer E 15275

## Product characteristics

### Description

Hempel's Shopprimer E 15275 is a two-component epoxy polyamide shopprimer, pigmented with zinc phosphate rust-inhibiting pigments. It is designed for automatic spray application.

### Recommended use

As a shopprimer for protection of blast cleaned steel plate and other structural steel during the storage and building period.

### Service temperature:

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

### Certificates / Approvals

- Approved as weldable pre-fabrication primer. Contact Hempel for details.
- Reaction to fire tested (as part of a coating system with approved primer and topcoat) according to EN13501-1 B-s1, d0.

## Product safety

**Flash point** 4°C [39°F]

### VOC content mixed product

Legislation	Value
EU	642 g/L [5.36 lb/US gal]
US (coatings)	642 g/L [5.36 lb/US gal]
US (regulatory)	642 g/L [5.36 lb/US gal]
China	642 g/L [5.36 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://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

15275

### Product components

Base 15274  
Curing Agent 95175

### Standard shade\* / code

Brownish red 50890

### Gloss

Flat

### Volume solids

26 ± 2%

### Specific gravity

1.2 kg/L [10 lb/US gal]

### Reference dry film thickness

20 micron [0.8 mils]

## 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.
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

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

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## Application

### Mixing ratio

Base 15274 : Curing Agent 95175  
(65 : 35 by volume)

Stir well before use.

### Thinner

Hempel's Thinner 08570

### Cleaner

Hempel's Tool Cleaner 99610

### Pot life

Product temperature	20°C [68°F]
Pot life	24 hours

### Application method

Tool	Thinning max vol.	Application parameters
Airless spray	20%	Nozzle pressure: 75 bar [1100 psi] Nozzle orifice: 0.021"
Air spray	20%	Not Applicable.
Brush	20%	Not Applicable.

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	15 micron [0.6 mils]	25 micron [1.0 mils]	20 micron [0.8 mils]
Wet film thickness	58 micron [2.3 mils]	96 micron [3.8 mils]	77 micron [3.1 mils]
Theoretical spreading rate	17 m²/L [693 sq ft/US gal]	10 m²/L [407 sq ft/US gal]	13 m²/L [530 sq ft/US gal]

### 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.
- Subsequent coat: According to Hempel's Specification.

### Drying time

Surface temperature		20°C [68°F]
Dry to handle	min	6
Fully cured	days	7

Determined for dry film thickness 20 micron [0.8 mils] at standard conditions, see Hempel's Explanatory Notes for details.

### Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		20°C [68°F]
	Atmospheric medium	
Hempadur 15571	Min Max	6 h Ext

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

### Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

### Other remarks

- Remove zinc salts or other contamination before overcoating.

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## 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.

## Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	16.9 g CO <sub>2</sub> e/m <sup>2</sup>	0.088 lb CO <sub>2</sub> e/ft <sup>2</sup>

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.
- 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](http://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 <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

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](http://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.