



## HEMPEL'S POLYENAMEL 55103

55103: BASE 55106: CURING AGENT 95370

<b>Description:</b>	HEMPEL'S POLYENAMEL is a high gloss, two component acrylic polyurethane, cured with aliphatic isocyanate. It has excellent gloss and colour retention. Resistant to salt water, wear, and marine atmosphere.
<b>Recommended use:</b>	As a finishing coat in 2 component systems on interior and exterior surfaces above water-line: wood, steel and glass fibre.
<b>Service temperature:</b>	Maximum, dry exposure only: 120°C/248°F see REMARKS overleaf
<b>Availability:</b>	Part of European Yacht assortment. Local availability subject to confirmation.
<b>PHYSICAL CONSTANTS:</b>	
Shade nos/Colours:	10000*/ White.
Finish:	High-gloss
Volume solids, %:	51 ± 1
Theoretical spreading rate:	14.6 m <sup>2</sup> /l [585.5 sq.ft./US gallon] - 35 micron/1.4 mils
Flash point:	35 °C [95 °F]
Specific gravity:	1.2 kg/litre [10.4 lbs/US gallon]
Surface dry:	2.5 approx. hour(s) 20°C/68°F
Dry to touch:	4 - 5 hour(s) at 20°C/68°F 8-10 hours at 10°/50°c
Fully cured:	7 day(s) 20°C/68°F
VOC content:	428 g/l [3.6 lbs/US gallon] <i>*other shades according to assortment list.</i>

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.*

### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>55103</b>
Mixing ratio:	BASE 55106: CURING AGENT 95370 7:1 by volume
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	Spray 08511(5-10%); Brush 08711 (Max. 5%)
Pot life:	2 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 08511 or 08711
Indicated film thickness, dry:	35 micron [1.4 mils]
Indicated film thickness, wet:	75 micron [3 mils]
Recoat interval, min:	According to specification.
Recoat interval, max:	According to specification.
<b>Safety:</b>	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.



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### SURFACE PREPARATION:

**New wood:** Wash the area to be treated with HEMPEL'S PRE-CLEAN 67602 as instructed and rinse with fresh water. Allow the wood to dry, sand bare spots, and remove dust completely. Saturate bare spots with suitable wood preservative or similar. Apply one coat of LIGHT PRIMER 45551 or YACHT POLYPRIMER 25050.

Apply one coat of the product thinned with: 5-10% HEMPEL'S THINNER. Finally apply 1-2 coats of the undiluted product.

**Previously painted wood:** Wash the area to be treated with HEMPEL'S PRE-CLEAN 67602 as instructed and rinse with fresh water. Grind the surface to a uniformly matt appearance. Remove dust and loose material. Touch up bare spots with: HEMPEL'S PRIMER UNDERCOAT 13201. Apply one coat of LIGHT PRIMER 45551 or YACHT POLYPRIMER 25050.

Apply one coat of the product thinned with: 5-10% HEMPEL'S THINNER. Finally apply 1-2 coats of the undiluted product.

**Steel:** PRE-CLEAN 67602. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Touch-up to full film thickness with LIGHT PRIMER 45551 or YACHT POLYPRIMER 25020. Apply 1-2 coats of the product. **Glass fibre:** Wash the area to be treated with HEMPEL'S PRE-CLEAN 67602 as instructed and rinse with fresh water. Allow the surface to dry. Abrade before primer application. Dust off residues. Touch-up to full film thickness with LIGHT PRIMER 45551 or YACHT POLYPRIMER 25020. Finally apply 2-3 coats of the undiluted product.

### APPLICATION CONDITIONS:

Apply only on a dry and clean surface with a temperature 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 adhesion.

The film formation may be adversely affected by light rain, high humidity and/or condensation during application and the following interval after application: 5-10% hours. at

20°C/68°F In confined spaces provide adequate ventilation during application and drying.  
16 (20°C/68°F).

Minimum temperature for curing is: -10°C/14°F

### PRECEDING COAT

According to specification. Recommended systems are: HEMPEL'S LIGHT PRIMER 45551, HEMPEL'S YACHT POLYPRIMER 25050 or suitable wood preservative.

### SUBSEQUENT COAT:

None.

### REMARKS:

#### Colours/Colour stability:

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

#### Weathering/service temperatures:

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

#### Film thicknesses/thinning:

The amount of thinner required will depend on temperatures and the application technique. THINNER 08511 is recommended by spray application and THINNER 08711 by brush.

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 dry is:

Normal range is: 20-40 micron/0.8-1.6 mils dry film thickness.

#### Curing agent:

CURING AGENT 95370: 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.

#### Note:

**HEMPEL'S POLYENAMEL 55103 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](http://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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