

<b>Description:</b>	HEMPAQUICK PRIMER 13624 is a very quick-drying zinc phosphate pigmented alkyd primer.
<b>Recommended use:</b>	As a rust preventing primer on steel, machinery parts, etc. where quick drying is needed, both as a workshop primer for temporary protection and as a general purpose primer in fast drying alkyd-based systems for protection of steel in mild to medium atmospheric corrosive environments.
<b>Service temperature:</b>	Maximum, dry exposure only: 120°C/248°F
<b>Certificates/Approvals:</b>	Tested for non-contamination of grain cargo at the Newcastle Occupational Health & Hygiene, Great Britain.
<b>Availability:</b>	Part of Group Assortment. Local availability subject to confirmation.
<b>PHYSICAL CONSTANTS:</b>	
Shade nos/Colours:	12170* / Grey.
Finish:	Flat
Volume solids, %:	47 ± 1
Theoretical spreading rate:	5.9 m <sup>2</sup> /l [236.6 sq.ft./US gallon] - 80 micron/3.2 mils
Flash point:	31 °C [87.8 °F]
Specific gravity:	1.3 kg/litre [11.2 lbs/US gallon]
Surface-dry:	30 minute(s) 20°C/68°F
Through-dry:	1 hour 20°C/68°F
VOC content:	474 g/l [3.9 lbs/US gallon]
Shelf life:	5 years (25°C/77°F) from time of production. <i>*other shades according to assortment list.</i>
	<i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
<b>APPLICATION DETAILS:</b>	
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	08080 (10%) / 08080 (15%) / 08080 (5%)
Nozzle orifice:	0.017 - 0.021 "
Nozzle pressure:	150 bar [2175 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S THINNER 08080
Indicated film thickness, dry:	80 micron [3.2 mils]
Indicated film thickness, wet:	175 micron [7 mils]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf
<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.

**SURFACE PREPARATION:** **New steel:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to minimum Sa 2 (ISO 8501-1:2007), alternatively power tool cleaning to St 3 (ISO 8501-1:2007) depending on the corrosion impact. **On machinery:** May be applied directly on steel and iron after degreasing and mechanical cleaning. **Repair and maintenance:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up bare spots to full film thickness.

**APPLICATION CONDITIONS:** Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.

**SUBSEQUENT COAT:** HEMPALIN system according to specification.

**REMARKS:**

**Film thicknesses/thinning:** 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: 40-80 micron/ 1.6-3.2 mils

**Overcoating:** Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

A specification supersedes any guideline overcoat intervals indicated in the table.

Environment	Atmospheric, medium					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPALIN	1 h	None	30 m	None	25 m	None
HEMPATEX	1 h	43 h	30 m	24 h	25 m	18 h

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

**Overcoating note:** Before overcoating after exposure in contaminated environment, clean the surface thoroughly by high pressure water cleaning and allow drying.

**Note:** **HEMPAQUICK PRIMER 13624 For professional use only.**

**ISSUED BY:** HEMPEL A/S 1362412170

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. The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue. *supplier : [manage@findotek.com](mailto:manage@findotek.com)*