



## HEMPADUR® ZINC 17340

BASE 17349 with CURING AGENT 97040

**Description:** HEMPADUR ZINC 17340 is a two-component zinc rich epoxy paint. It cures to a strong and corrosion resistant coating.

**Recommended use:**

1. As a "V.O.C. compliant" primer on steel in medium to severely corrosive environment. May be applied on zinc-shopprimed steel, where damaged spots, welds etc. have been power tool cleaned.
2. For on-line application on containers.

In compliance with SSPC-Paint 20, type 2, level 3.

**Service temperatures:** Maximum, dry exposure only: 140°C/284°F.

**Availability:** Part of Group Assortment. Local availability subject to confirmation.

### PHYSICAL CONSTANTS:

Colours/Shade nos: Red-grey/198300  
Finish: Semi-flat  
Volume solids, %: 66 ± 1  
Theoretical spreading rate: 13.2 m<sup>2</sup>/litre - 50 micron  
529 sq.ft./US gallon - 2 mils  
Flash point: 24°C/75°F  
Specific gravity: 2.3 kg/litre - 19.2 lbs/US gallon  
Surface dry: 2 (approx.) hrs at 20°C/68°F (ISO 1517)  
Dry to touch: 3 (approx.) hours at 20°C/68°F  
Fully cured: 7 days at 20°C/68°F  
V.O.C.: 325 g/litre - 2.7 lbs/US gallon

*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 17340: Base 17349 : Curing agent 97040  
4 : 1 by volume

Application method:	Airless spray	Air spray	Brush
Thinner (max.vol.):	08450 (5%)	08450 (15%)	08450 (5%)
Pot life:	2 hours (20°C/68°F)		
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	175 bar/2500 psi <i>(Airless spray data are indicative and subject to adjustment)</i>		
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610		
Indicated film thickness, dry:	50 micron/2 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

**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.



## HEMPADUR ZINC 17340

**SURFACE PREPARATION:** **New steel:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½. For temporary protection, if required, use suitable zinc shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use HEMPADUR ZINC 17340.  
**Maintenance:** Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material preferably by dry abrasive blasting. Minor areas may be power tool cleaned.

**APPLICATION : CONDITIONS** Use only where application and curing can proceed at temperatures above -10°C/14°F. At the freezing point and below be aware of ice on the surface, which will hinder the adhesion. The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.

**SUBSEQUENT COAT:** According to specification.

**REMARKS:** **Note:** If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises. 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 is 50-75 micron/2-3 mils. (The dry film thickness range does not take into account the correction factors for rough surfaces as listed in ISO 19840).

**Recoating:** Recoating intervals, 50 micron/1 mil dry film thickness for HEMPADUR ZINC 17340:

	Minimum		Maximum
Surface temperature	20°C/68°F		20°C/68°F
	Atmospheric		Atmospheric
Recoated with (Quality numbers only)	As a container coating	As a general protective coating	.
58030	30 minutes	1 hour	8 hours
46410. 46370	30 minutes	1 hour	5 hours
HEMPADUR	30 minutes	4 hours	30 days*
HEMPATHANE	30 minutes	Not relevant	3 days

\* If the coating has been subjected to direct sunlight for a short period only, the maximum recoating interval may be prolonged.

Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).

**Note:** **HEMPADUR ZINC 17340 is for professional use only.**

**ISSUED BY:** HEMPEL A/S - 1734019830CR003

***This Product Data Sheet supersedes those previously issued.  
For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.  
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