HEMPADUR PRO ZINC 17380

17380 : BASE 17389 : CURING AGENT 98382

Description: HEMPADUR PRO ZINC 17380 is a two-component, zinc rich epoxy primer.
Offers cathodic protection of local mechanical damage.

Recommended use: As a high solids, versatile, long-term primer on steel for epoxy coating systems in medium to severely corrosive environments.

Service temperature: Maximum, dry exposure only: 160°C/320°F

Certificates/Approvals: Conforms to NORSOK M-501, rev. 5, system no. 1.
In compliance with SSPC-Paint 20, type 2, level 1 and ISO 12944-5.

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

PHYSICAL CONSTANTS:

Shade nos/Colours:	10830 / Grey.
Finish:	Flat
Volume solids, %:	60 ± 1
Theoretical spreading rate:	10 m^2/l [401 sq.ft./US gallon] - 60 micron/2.4 mils
Flash point:	19 °C [66.2 °F]
Specific gravity:	2.8 kg/litre [23.5 lbs/US gallon]
Surface dry:	0.5 approx. hour(s) 20°C/68°F
Dry to touch:	1 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	340 g/l [2.8 lbs/US gallon] (According to EPA Fed Ref Method 24)

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

APPLICATION DETAILS:

Version, mixed product:	**17380**
Mixing ratio:	BASE 17389 : CURING AGENT 98382 4 : 1 by volume
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (15%) / 08450 (5%) see REMARKS overleaf
Pot life:	2 hour(s) 20°C/68°F
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 TOOL CLEANER 99610
Indicated film thickness, dry:	60 micron [2.4 mils] see REMARKS overleaf
Indicated film thickness, wet:	100 micron [4 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.

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SURFACE PREPARATION: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning.
Abrasive blasting to Sa 2½ (ISO 8501-1:2007), SSPC-SP 10/ NACE No. 2, with a sharp-edged surface profile corresponding to Rugotest No. 3, BN10a-b, Keane-Tator Comparator, 3.0 G/S, 2-3 S, or ISO Comparator, Medium (G).

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above: -10°C/14°F. The temperature of the surface must also be above these limits. The temperature of paint itself should be 15°C/59°F or above. 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: 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 is to avoid the risk of "wet corrosion" when the temperature rises.

Stirring: Before mixing with the curing agent stir the base thoroughly in order to redisperse any possible settling after storage. After mixing it is equally important to maintain stirring to keep the wet paint as a homogeneous mixture.
This is specifically important in case of a high level of thinning and/or long break in application, where the risk of settlement of zinc particles is the highest.

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: 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).

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, severe					
Surface temperature:	-10°C (14°F)		0°C (32°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	18 h	90 d	9 h	90 d	2h	30 d

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

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. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust). If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Note: **HEMPADUR PRO ZINC 17380 For professional use only.**

ISSUED BY: HEMPEL A/S
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