

17390: BASE 17399: CURING AGENT 97040

Description:	HEMPADUR ZINC 17390 is a two-component, zinc-rich epoxy primer containing 90% zinc dust in the dry film. It cures to a hard- wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage.
Recommended use:	As a "V.O.C. compliant", versatile, long-term primer on steel for epoxy, vinyl and acrylic coating systems in medium to severely corrosive environments.
Service temperature:	Maximum, dry exposure only: 160°C/320°F Maximum service temperature is depending on the subsequent coat.
Certificates/Approvals:	Conforms to the requirements to zinc content according to ISO 12944, BS 4652 and BS 5493.
Availability:	Not included in Group Assortment. Availability subject to special agreement.

PHYSICAL CONSTANTS:

Shade nos/Colours:	19840 / Grey.
Finish:	Flat
Volume solids, %:	64 ± 1
Theoretical spreading rate:	16 m ² /l [641.6 sq.ft./US gallon] - 40 micron/1.6 mils
Flash point:	24 °C [75.2 °F]
Specific gravity:	3.2 kg/litre [26.6 lbs/US gallon]
Surface-dry:	0.5 approx. hour(s) 20°C/68°F
Dry to touch:	1 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	328 g/l [2.7 lbs/US gallon]
Shelf life:	1 Year for BASE and 3 years (25°C/77°F) for CURING AGENT from time of production. <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>

APPLICATION DETAILS:

Version, mixed product:	17390
Mixing ratio:	BASE 17399: CURING AGENT 97040 8.5:1.5 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:	40 micron [1.6 mils] (see REMARKS overleaf)
Indicated film thickness, wet:	75 micron [3 mils]
Overcoat interval, min:	According to specification.
Overcoat interval, max:	According to specification.

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 with suitable detergent. Entire area to be (high pressure) fresh water cleaned in order to remove salts and other contaminants. Abrasive blasting to Sa 2½ (ISO 8501-1:2007). Surface profile corresponds to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S, 2 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.
Film thicknesses/thinning:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range is: 40-50 micron/1.6-2 mils. May be specified in dry film thicknesses down to approximately: 15 micron/0.6 mils. Additional thinning may be necessary for this purpose. Dry film thicknesses of the product may be exceptionally specified up to: 75 micron/3 mils. Due to the very high zinc content, where the mechanical strength of the zinc primer is of importance, it is generally recommended to keep film thicknesses at: 40-50 micron/1.6-2 mils. This will alter spreading rate and may influence drying time and overcoat interval. (The dry film thickness range does not take into account the correction factors for rough surfaces as listed in ISO 19840).
Overcoating note:	In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust). If the coating has been subjected to direct sunlight for a short period only, the maximum overcoating interval may be prolonged. Water immersion will primarily be relevant for systems:45141/3.
Note:	HEMPADUR ZINC 17390 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. 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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