

17940: BASE 17949: CURING AGENT 97290

Description:	HEMPADUR 17940 is a two-component polyamide adduct-cured epoxy paint. It cures to a flexible, well adhering coating. Contains aluminium.
Recommended use:	As a sealer for HEMPADUR systems on aluminium/zinc metal sprayed substrate in atmospheric exposure.
Service temperature:	Maximum, dry exposure only: 140°C/284°F
Availability:	Not included in Group Assortment. Availability subject to special agreement.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	19880 / Dark-Alu.
Finish:	Flat
Volume solids, %:	38 ± 2 (According to BS 3900 Part A 10 - see REMARKS overleaf)
Theoretical spreading rate:	15.2 m ² /l [609.5 sq.ft./US gallon] - 25 micron/1 mils
Flash point:	33 °C [91.4 °F]
Specific gravity:	1 kg/litre [8.3 lbs/US gallon]
Dry to touch:	1 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	616 g/l [5.1 lbs/US gallon]
Shelf life:	6 months for BASE and 2 years (25°C/77°F) for CURING AGENT from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage. <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>

APPLICATION DETAILS:

Version, mixed product:	17940
Mixing ratio:	BASE 17949: CURING AGENT 97290 2 : 1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (5%)
Pot life (Airless spray):	4 hour(s) 20°C/68°F
Nozzle orifice:	0.017 - 0.019 "
Nozzle pressure:	175 bar [2537.5 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	25 micron [1 mils]
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.

SURFACE PREPARATION:	It is recommended to overcoat spray-metallised surfaces as soon as possible to avoid possible contamination.
APPLICATION CONDITIONS:	Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 0°C/32°F. The temperature of the surface must also be above these limits. The temperature of the paint itself should be: 15-25°C/59-77°F. In confined spaces provide adequate ventilation during application and drying.
SUBSEQUENT COAT:	According to specification. Recommended systems are: HEMPADUR.
REMARKS:	
Application(s):	It is recommended to apply a mist coat of undiluted product, allow air to escape, and then apply a full coat of the product a few minutes later. Certain metal sprayed surfaces may be so porous that extra diluting can be necessary. Extra diluting up to: 20-30%. Except for mild climatic conditions avoid long-term exposure of zinc sprayed steel coated with a thin layer of paint only as this may create white rust under the paint. 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. Any degraded surface layer, as a result of a long exposure period, must be removed as well. Consult HEMPEL for specific advice if in doubt. To check whether the quality of the surface cleaning is adequate, a test patch may be relevant.
Volume solids, %:	The volume solids % for the product has been measured according to BS 3900 Part A 10 as required in the UK Highway Agency specifications, other methods might give slightly different results.
Note:	HEMPADUR 17940 For professional use only.
ISSUED BY:	HEMPEL A/S 1794019880

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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