

# Hempadur 17940

## Product characteristics

### 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].

## Product safety

**Flash point** 33°C [91°F]

### VOC content mixed product

Legislation	Value
EU	613 g/L [5.12 lb/US gal]
US (coatings)	613 g/L [5.12 lb/US gal]
US (regulatory)	613 g/L [5.12 lb/US gal]
China	613 g/L [5.12 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://hempel.com) or at your local Hempel website.

### Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

## Product data

### Product code

17940

### Product components

Base 17949

Curing agent 97290

### Standard shade / code

Aluminium red 19880 \*

### Volume solids

30 ± 2%

### Specific gravity

1 kg/L [8 lb/US gal]

### Reference dry film thickness

25 micron [1.0 mils]

### Aluminium shade / code

Aluminium red 19880 \*\*

### Gloss

Please consult Hempel's Guideline on aluminium pigmented coatings.

### Volume solids

30 ± 2%

### Specific gravity

1 kg/L [8 lb/US gal]

### Reference dry film thickness

25 micron [1.0 mils]

\* Slight discolouration may occur. This does not affect the performance of the coating.

\*\* Appearance of the aluminium pigmented coats will depend on application method, drying conditions, handling etc. Please see the Guideline on Aluminium pigmented coatings at [hempel.com](http://hempel.com) or at your local Hempel website.



# Hempadur 17940

## Surface preparation

### Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

### New build:

- According to Hempel's Specification.

### Maintenance and Repair

- According to Hempel's Specification.

Consult Hempel's separate Surface Preparation Guidelines for more details.

## Application

### Mixing ratio

Base 17949 : Curing agent 97290  
(2 : 1 by volume)

Stir well before use.

### Thinner

Hempel's Thinner 08450

### Pot life

Product temperature	20°C [68°F]
Pot life	4 hours

### Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 175 bar [2500 psi] Nozzle orifice: 0.017-0.019"
Brush	5%	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

### Film thickness

Specification range	Low	High	Recommended
Dry film thickness	25 micron [1.0 mils]	25 micron [1.0 mils]	25 micron [1.0 mils]
Wet film thickness	80 micron [3.5 mils]	80 micron [3.5 mils]	80 micron [3.5 mils]
Theoretical spreading rate	12 m²/L [490 sq ft/US gal]	12 m²/L [490 sq ft/US gal]	12 m²/L [490 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

### Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above 0°C [32°F] during application and curing.
- Optimal paint temperature for proper mixing, pumping and spraying is: 15-25°C [59-77°F].

## Drying and overcoating

### Product compatibility

- Previous coat: None or according to Hempel's specification.
- Subsequent coat: According to Hempel's Specification.  
Recommended product is: Hempadur

### Drying time

Surface temperature	20°C [68°F]
Surface dry	min 60

Determined for dry film thickness 25 micron [1.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

### Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.



# Hempadur 17940

## Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- Metallised surfaces should be overcoated before exposure to open air conditions.
- The surface must be dry and clean prior to application.

## Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

## Storage

### Shelf life

Ambient temperature	25°C [77°F]	35°C [95°F]
Base	6 months	-
Curing agent	24 months	16 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

### Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.

## Additional documents

Additional information is available at the Hempel website [hempel.com](http://hempel.com) or at your local Hempel website:

- Explanatory Notes explaining the fields in this Product Data Sheet.
- Surface Preparation Guidelines.
- Application Guidelines for different application methods.
- General Application Guidelines

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at [www.hempel.com](http://www.hempel.com) (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from [www.hempel.com](http://www.hempel.com).

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.