Hempadur Zinc 17360

Product characteristics

Description
Hempadur Zinc 17360 is a two-component, zinc rich epoxy primer. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage.
Complies with EU Directive 2004/42/EC, The Paints Directive on the limitation of volatile organic compounds: subcategory j.

Recommended use
Hempadur Zinc 17360 is recommended as a VOC compliant, versatile, long-term primer on steel for epoxy, vinyl and acrylic coating systems in medium to severely corrosive environments.
The product is in compliance with SSPC-Paint 20, type 2, level 2 and ISO 12944-5.

Service temperature:
- Maximum, dry exposure only: 160°C [320°F].

Product safety

Flash point 24°C [75°F]

VOC content mixed product

Legislation	Value	15% thinning, by volume	Limit value, phase II (2010)[a]
EU	307 g/L [2.56 lb/US gal]	389 g/L [3.25 lb/US gal]	500 g/L [4.17 lb/US gal]
US (coatings)	307 g/L [2.56 lb/US gal]	-	-
US (regulatory)	307 g/L [2.56 lb/US gal]	-	-
China	307 g/L [2.56 lb/US gal]	-	-

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. [a]EU Directive 2004/42/CE. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

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
17360

Product components
Base 17369
Curing Agent 97040

Standard shade / code
Grey 19830 *

Gloss
Flat

Volume solids
65 ± 2%

Specific gravity
2.8 kg/L [23 lb/US gal]

Reference dry film thickness
50 micron [2.0 mils]

* Epoxy coatings may discolour and chalk when exposed to UV light. This does not affect the performance of the coating.

Hempadur Zinc 17360

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:
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

Maintenance and Repair
- Minor areas may be hand or power tool cleaned instead of abrasive blasting.
- Remove dust, blast media and loose materials.

Roughness
- Surface profile Medium (G) (ISO 8503-2).

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

Application

Mixing ratio
Base 17369 : Curing Agent 97040
(4 : 1 by volume)

Products containing floating or settling particles/pigments need to be continuosly stirred during application. This is especially important in case of heavy thinning.

Thinner
Hempel's Thinner 08450

Cleaner
Hempel's Tool Cleaner 99610

Pot life

Product temperature	0°C [32°F]	20°C [68°F]	30°C [86°F]
Pot life	4 hours	2 hours	1 hour

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 150 bar [2200 psi] Nozzle orifice: 0.017-0.021"

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	40 micron [1.6 mils]	80 micron [3.1 mils]	50 micron [2.0 mils]
Wet film thickness	60 micron [2.5 mils]	125 micron [5 mils]	75 micron [3 mils]
Theoretical spreading rate	16 m²/L [650 sq ft/US gal]	8.1 m²/L [330 sq ft/US gal]	13 m²/L [530 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.

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 -10°C [14°F] during application and curing.
- Temperature of product must be above 15°C [59°F] during application.

Relative Humidity:
- Relative humidity must be below 85% during application.

Hempadur Zinc 17360

Drying and overcoating

Product compatibility

- Previous coat: None.
- Subsequent coat: According to Hempel's Specification.

Drying time

Surface temperature		20°C [68°F]
Surface dry	min	15
Hard dry	min	90
Fully cured	days	7

Determined for dry film thickness 50 micron [2.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		-10°C [14°F]	0°C [32°F]	20°C [68°F]	30°C [86°F]
Atmospheric severe					
Hempaprime Multi 500	Min	36 h	18 h	4 h	3 h
	Max	90 d	90 d	30 d	22 d
Hempathane HS 55610	Min	36 h	18 h	4 h	3 h
	Max	27 d	13 d	72 h	54 h

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions

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

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be clean before overcoating.
- Remove zinc salts or other contamination before overcoating.

Other remarks

- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	12 months
Curing Agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

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.

Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	22.4 g CO_2e/m^2	0.116 lb CO_2e/ft^2

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

Hempadur Zinc 17360

Additional documents

Additional information is available at the Hempel website
https://www.hempel.com/service-and-support/technical-guidelines
or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- 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 (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 www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

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.

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.