

Description:	HEMPALIN PRIMER 12050 is a relatively quick-drying alkyd primer containing zinc phosphate.
Recommended use:	General purpose primer for HEMPALIN systems for protection of steel in mild to medium atmospheric corrosive environments.
Service temperature:	Maximum, dry exposure only: 120°C/248°F
Certificates/Approvals:	Approved as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on www.Hempel.com for further details. Complies with EU Directive 2004/42/EC: subcategory i.
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	40760* / Green
Finish:	Flat
Volume solids, %:	49 ± 1
Theoretical spreading rate:	12.3 m ² /l [493.2 sq.ft./US gallon] - 40 micron/1.6 mils
Flash point:	38 °C [100.4 °F]
Specific gravity:	1.3 kg/litre [10.7 lbs/US gallon]
Surface-dry:	45 minute(s) 20°C/68°F
Through-dry:	4.5 hour(s) 20°C/68°F
VOC content:	404 g/l [3.4 lbs/US gallon]
Shelf life:	5 years (25°C/77°F) from time of production. <i>*other shades according to assortment list.</i>
<i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>	
APPLICATION DETAILS:	
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	08230 (5%) / 08230 (5%) / 08230 (5%)
Nozzle orifice:	0.018 "
Nozzle pressure:	150 bar [2175 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S THINNER 08230
Indicated film thickness, dry:	40 micron [1.6 mils]
Indicated film thickness, wet:	75 micron [3 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.

SURFACE PREPARATION:

New steel: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to Sa 2 (ISO 8501-1:2007) is recommended. For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use: HEMPALIN PRIMER 12050.

Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up bare spots to full film thickness.

APPLICATION CONDITIONS:

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:

HEMPALIN system according to specification.

REMARKS:**VOC - EU Directive 2004/42/EC:**

Product	As supplied	5 vol. % thinning	Limit phase II, 2010
1205040760	404 g/l	426 g/l	500 g/l

For VOC of other shades, please refer to Safety Data Sheet.

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: 30-50 micron/1.2-2 mils.

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, medium					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPALIN	16 h	5½ d	8 h	3 d	6 h	54 h

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

Note:

HEMPALIN PRIMER 12050 For professional use only.

ISSUED BY:

HEMPEL A/S

1205040760

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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