

Hempadur Zinc 17420

Product characteristics

Description

Hempadur Zinc 17420 is a two component zinc epoxy paint. It cures to a strong and corrosion resistant coating.

Recommended use

As a long term zinc primer for steel, in corrosive environments. May be applied on zinc shop primed steel, where damaged spots, welds etc. have been power tool cleaned.

Service temperature:

- Maximum, dry exposure only: 140°C [284°F].

Product safety

Flash point 30°C [86°F]

VOC content mixed product

Legislation	Value
EU	320 g/L [2.67 lb/US gal]
US (coatings)	320 g/L [2.67 lb/US gal]
US (regulatory)	320 g/L [2.67 lb/US gal]
China	320 g/L [2.67 lb/US gal]

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

17420

Product components

Base 17429
Curing agent 97040

Standard shade / code

Grey 19840

Gloss

Flat

Volume solids

62 ± 2%

Specific gravity

1.9 kg/L [16 lb/US gal]

Reference dry film thickness

50 micron [2.0 mils]

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).
- All damage of shopprimer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting.
- 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.

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Roughness

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

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

Application

Mixing ratio

Base 17429 : Curing agent 97040
(by weight)

Products containing floating or settling particles/pigments need to be continuously 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	20°C [68°F]
Pot life	2 hours

Application method

Tool	Application parameters
Airless spray	Nozzle pressure: 220 bar [3200 psi] Nozzle orifice: 0.017-0.021"
Brush	Not Applicable.
Air spray	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	40 micron [1.6 mils]	75 micron [3.0 mils]	50 micron [2.0 mils]
Wet film thickness	60 micron [2.5 mils]	120 micron [5 mils]	80 micron [3 mils]
Theoretical spreading rate	16 m ² /L [650 sq ft/US gal]	8.3 m ² /L [340 sq ft/US gal]	12 m ² /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

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

Drying and overcoating

Product compatibility

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

Drying time

Surface temperature	-
Fully cured	days 7

Determined for dry film thickness 50 micron [2.0 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.

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.

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Storage

Shelf life

Ambient temperature	25°C [77°F]	35°C [95°F]
Base	12 months	9 months
Curing agent	36 months	24 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.

Additional documents

Additional information is available at the Hempel website 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.

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.