

# HEMPALIN\* PRIMER 1205<sub>0</sub>

<b>Description:</b>	HEMPALIN PRIMER 1205 is a quick-drying, zinc phosphate primer, based on long oil alkyd and urethane alkyd.
<b>Recommended use:</b>	General purpose primer for HEMPALIN systems on exterior and interior steel in mildly to moderately corrosive environment. Not suited for permanent immersion or in association with impressed current cathodic protection.
<b>Service temperatures:</b>	Maximum, dry: 100°C/212°F.
<b>Approvals:</b>	Approved as a low flame spread material by Danish, British, German, Japanese, Belgian, Italian and Norwegian authorities.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos.:	Green/40760	Red/50410
Finish:	Flat	Flat
Volume solids:	49%	49%
Theoretical spreading rate:	12.3 m <sup>2</sup> /litre - 40 micron 491 sq.ft./US gallon - 1.6 mils	12.3 m <sup>2</sup> /litre - 40 micron 491 sq.ft./US gallon - 1.6mils
Flash point:	38°C/100°F	38°C/100°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon	1.3 kg/litre - 10.8 lbs/USgallon
Dry to touch:	2-4 hours at 20°C/68°F	2-4 hours at 20°C/68°F
V.O.C.:	405 g/litre - 3.4 lbs/US gallon	409 g/litre - 3.4 lbs/US gallon

*The physical constants are subject to normal manufacturing tolerances.  
Further reference is made to "Explanatory Notes" in the Hempel Book.*

## APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	0808 (5%)	0808 (5%)	0823 (5%)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 0808		
Indicated film thickness, dry:	40 micron/1.6 mil		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

## 2. HEMPALIN PRIMER 12050

**SURFACE PREPARATION:** **New steel:** Abrasive blasting to minimum Sa 2. For temporary protection, if required, use a suitable shopprimer. 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 1205.

**Maintenance:** Remove oil and grease, etc. with suitable detergent. Remove salt 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 to full film thickness.

**APPLICATION CONDITIONS:** As dictated by normal good painting practice.  
In confined spaces provide adequate ventilation during application and drying.

**SUBSEQUENT COAT:** HEMPALIN system according to specification.

**REMARKS:**  
**Film thicknesses:** 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 recoating interval. Normal range dry is 30-50 micron/1.2-2 mils.

**Recoating:** Recoating intervals related to later conditions of exposure:  
(40 micron/1.6 mils dry film thickness of HEMPALIN PRIMER 1205)

	Minimum		Maximum	
Steel temperature	20°C/68°F		20°C/68°F	
Recoated with (Quality Numbers only)	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
HEMPALIN, except 5324	5 hrs	8 hrs	none	3 days
5324	2 days	2 days	none	7 days

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before recoating after exposure in contaminated environment, clean surface thoroughly with (high pressure) fresh water hosing and allow to dry.

**Note:** **HEMPALIN PRIMER 1205 is for professional use only.**

**SAFETY:** Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Material Safety Data Sheets and follow all local or national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. 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. The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise.

Product data are subject to change without notice and become void five years from the date of issue.

Issued by HEMPEL'S MARINE PAINTS A/S.

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