

# HEMPADUR\* ZINC 1534<sub>1</sub>/ HEMPADUR\* ZINC 1534<sub>3</sub>

1534<sub>1</sub>: High temperatures: CURING AGENT 95740  
1534<sub>3</sub>: Low to medium temperatures: CURING AGENT 95570

<b>Description:</b>	HEMPADUR ZINC 1534 is a two-component zinc epoxy paint. It cures to a strong and corrosion resistant coating.
<b>Recommended use:</b>	<ol style="list-style-type: none"><li>As a long-term primer on steel in medium to severely corrosive environment. May be applied on zinc-shopprimed steel, where damaged spots, welds etc. have been power tool cleaned.</li><li>For on-line application on containers.</li></ol> <p>CURING AGENT 95740 polyamide is typically for use in tropical and subtropical climates. CURING AGENT 95570, polyamide adduct, facilitates curing at temperatures down to -10°C/14°F, but is also very suited for shop-coat application.</p>
<b>Service temperatures:</b>	Maximum, dry: 140°C/284°F.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Version; mixed product:	<b>1534<sub>1</sub></b>	<b>1534<sub>3</sub></b>
Colours/Shade nos:	Red-grey/19830	Red-grey/19830
Finish:	Semi-flat	Semi-flat
Volume solids:	48%	55%
Theoretical spreading rate:	12 m <sup>2</sup> /litre - 40 micron 481 sq.ft./US gallon - 1.6 mils	13.8 m <sup>2</sup> /litre - 40 micron 551 sq.ft./US gallon - 1.6 mils
Flash point:	30°C/86°F	30°C/86°F
Specific gravity:	1.7 kg/litre - 14.2 lbs/US gallon	1.7 kg/litre - 14.2 lbs/US gallon
Surface dry:	2 (approx.) hr at 20°C (ISO 1517)	½ (approx.) hr at 20°C (ISO 1517)
Dry to touch:	3 (approx.) hours at 20°C/68°F	1 (approx.) hour at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
V.O.C.:	467 g/litre - 3.9 lbs/US gallon	411 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:

	<b>1534<sub>1</sub></b>	<b>1534<sub>3</sub></b>
Mixing ratio:	Base 1534 <sub>9</sub> : Curing agent 95740 3 : 1 by volume	Base 1534 <sub>9</sub> : Curing agent 95570 3 : 1 by volume
Application method:	Airless spray    Air spray    Brush	
Thinner (max.vol.):	0845 (5%)    0845 (15%)    0845 (5%)	
Pot life:	8 hours (20°C/68°F) (1534 <sub>1</sub> ) 8 hours (20°C/68°F) (1534 <sub>1</sub> )	4 hours (20°C/68°F) (1534 <sub>3</sub> ) (airless) 6 hours (20°C/68°F) (1534 <sub>3</sub> ) (brush)
Nozzle orifice:	.017"-.021"	
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	HEMPEL'S TOOL CLEANER 9961	
Indicated film thickness, dry:	40 micron/1.6 mils (See REMARKS overleaf)	
Indicated film thickness, wet:	75 micron/3 mils	
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS	
Recoat interval, max:	As per separate APPLICATION INSTRUCTIONS	

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## 2. HEMPADUR ZINC 15341/15343

SURFACE PREPARATION:	<p><b>New steel:</b> Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2 ½, ISO 8501-1: 1988.</p> <p>For temporary protection, if required, use suitable zinc 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 HEMPADUR ZINC 1534.</p> <p><b>Maintenance:</b> 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 preferably by dry abrasive blasting. Minor areas may be power tool cleaned.</p>
APPLICATION : CONDITIONS	<p>Use only where application and curing can proceed at temperatures above -10°C/14°F (CURING AGENT 95570) and above +10°C/50°F (CURING AGENT 95740).</p> <p>At the freezing point and below be aware of ice on the surface, which will hinder the adhesion. The temperature of the paint itself should be 15°C/60°F or above to secure proper application properties. In confined spaces provide adequate ventilation during application and drying. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.</p>
PRECEDING COAT:	None, or according to specification.
SUBSEQUENT COAT:	HEMPADUR or HEMPATEX as per specification.
REMARKS:	
Note:	<p><b>Note:</b> If used as anticorrosive protection under insulation of high temperature equipment it is very important that NO moisture can penetrate during slow-down periods. This to avoid risk of "wet corrosion" when the temperature rises.</p> <p>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 is 30-50 micron 1.2-2 mils..</p>
Recoating:	<p>Recoating intervals related to later conditions of exposure: Consult separate APPLICATION INSTRUCTIONS.</p> <p>Before recoating after exposure in contaminated environment, clean the surface thoroughly by (high pressure) fresh water hosing and allow to dry.</p> <p>If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.</p> <p>A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).</p>
Thinning:	Use of THINNER 0857 will give a slightly faster flash-off than with THINNER 0845, but with a greater risk of dry-spray, when conventional air spray is used.
Note:	<b>HEMPADUR ZINC 1534 is for professional use only.</b>
SAFETY:	<p>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.</p>

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