

HEMPADUR* ZINC 15360/ HEMPADUR* ZINC 15363

High temperatures: 15360 with CURING AGENT 95740
Low to medium temperatures: 15363 with CURING AGENT 95360

Description: HEMPADUR ZINC 1536 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.

Recommended use:

1. As a versatile, long-term primer on steel for epoxy, vinyl and acrylic coating systems in moderately to severely corrosive environments.
2. For on-line application on containers.

CURING AGENT 95740, polyamide, is typically for use in tropical and subtropical climates.
CURING AGENT 95360, polyamide adduct, facilitates curing at temperatures down to -10°C/14°F, but is also very suitable for shop-coat application.

Service temperatures: Maximum, dry: 160°C/320°F, however depending on the subsequent coat.

Approvals: Approved as a welding primer by Lloyd's Register of Shipping.

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

	15360	15363
Version; mixed product:	Red-grey/19830	Red-grey/19830
Colours/Shade nos:	Semi-flat	Semi-flat
Finish:	49%	51%
Volume solids:	12.3 m ² /litre - 40 micron	12.8 m ² /litre - 40 micron
Theoretical spreading rate:	491 sq.ft./US gallon - 1.6 mils	511 sq.ft./US gallon - 1.6 mils
Flash point:	30°C/86°F	25°C/77°F
Specific gravity:	2.4 kg/litre - 20.0 lbs/US gallon	2.4 kg/litre - 20.0 lbs/US gallon
Surface dry:	30 minutes at 20°C/68°F (ISO 1517)	20 minutes at 20°C/68°F (ISO 1517)
Dry to touch:	2 (approx.) hours at 20°C/68°F	1½ (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F	7 days at 20°C/68°F
V.O.C.:	451 g/litre - 3.8 lbs/US gallon	433 g/litre - 3.6 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:

	15360	15363
Mixing ratio:	Base 15369 : Curing agent 95740 4 : 1 by volume	Base 15369 : Curing agent 95360 4 : 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) (15360) 8 hours (20°C/68°F) (15360)	4 hours (20°C/68°F) (15363) (airless) 6 hours (20°C/68°F) (15363) (brush)
Nozzle orifice:	.017"-.021"	
Nozzle pressure:	150 bar/2200 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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SURFACE PREPARATION:	Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½, SSPC-SP-10, with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G).
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 10°C/50°F when using curing agent 95740, and above -10°C/14°F when using curing agent 95360. The temperature of the surface must also be above these limits, respectively. At the freezing point and below be aware of the risk of ice on the surface which will hinder the adhesion. The temperature of the paint itself should be 15°C/59°F or above. 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:	According to specification.
REMARKS:	Note: 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.
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 amount of thinning necessary, drying time, and recoating interval. Normal range is 15-50 micron/0.6-2.0 mils.
Recoating:	Recoating intervals related to later conditions of exposure: Consult separate APPLICATION INSTRUCTIONS. 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 the surface thoroughly by (high pressure) fresh water hosing and allow to dry. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).
Note:	HEMPADUR ZINC 1536 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.
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Issued by HEMPEL'S MARINE PAINTS A/S.

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