

HEMPEL'S ZINC PRIMER 16490

Description: HEMPEL'S ZINC PRIMER 1649 is a one-component, high molecular weight, quick drying, phenoxy coating with a high content of zinc.

Recommended use:

1. As a protective primer on steel in severely corrosive environment.
2. For repair of GALVOSIL and other zinc rich coatings.
3. For repair of galvanized steel.

Service temperatures: maximum, dry: 120°C/248°F, however, depending on the subsequent coat.

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Metal grey/19840
Finish:	Flat
Volume solids:	34%
Theoretical spreading rate:	9.7 m ² /litre - 35 micron 390 sq.ft./US gallon - 1.4 mils
Flash point:	7°C/45°F
Specific gravity:	2.0 kg/litre - 16.7 lbs/US gallon
Surface dry:	15 (approx.) minutes at 20°C/68°F (ISO 1517)
Dry to touch:	30 (approx.) minutes at 20°C/68°F
V.O.C.:	593 g/litre - 4.9 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	Brush
Thinner (max. vol.):	0845 or 0871 (5%)	0845 (5%)
Nozzle orifice:	.019"-.021"	
Nozzle pressure:	200 bar/2900 psi <i>(Airless spray data are indicative and subject to adjustment)</i>	
Cleaning of tools:	THINNER 0845 or HEMPEL'S TOOL CLEANER 9961	
Indicated film thickness, dry:	35 micron/1.4 mils	
Indicated film thickness, wet:	100 micron/4 mils	
Recoat interval, min:	30 minutes (20°C/68°F)	
Recoat interval, max:	None <i>(See REMARKS overleaf)</i>	

Issued: September 1996

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SURFACE	New steel: Abrasive blasting to minimum Sa 2½, SSPC-SP-10 with a surface profile corresponding
PREPARATION:	to Rugotest No. 3, N9a to N10, preferably BN9a to BN10, Keane-Tator Comparator, 2.0 G/S or ISO Comparator, Medium (G). Repair of galvanized steel or zinc-rich coating: Remove oil and grease, etc. with suitable detergent. Remove salts and others contaminants by (high pressure) fresh water cleaning. Remove rust and loose material by abrasive blasting or power tool cleaning (avoid burnishing the surface). Dust off residues.
APPLICATION CONDITIONS:	The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. Tolerates low temperature application which, however, will increase drying time. At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	Recommended are HEMPADUR or HEMPATEX Systems according to specification.
REMARKS:	Note: Due to a risk of corrosion from possible moisture penetration, many experts advise against the use of zinc primers behind high temperature insulation.
Film thicknesses:	May be specified in another filmthickness than indicated depending on purpose and area of use. Normal range is 25-35 micron/1.0-1.4 mils.
Recoating:	If the coating has been exposed to the atmosphere for some time, the surface should be thoroughly hosed down and scrubbed with a stiff brush to remove "white rust" (zinc corrosion products) in addition to the usual cleaning for dirt, oil, grease, etc. Allow surface to dry before recoating. When overcoated, the entire paint system must be through dry and fully cured before full mechanical strength is obtained. Care should be taken to avoid water contamination in the cans to prevent gelling or gassing.
Note:	HEMPEL'S ZINC PRIMER 1649 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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September 1996 - 1649019840CO006