

# HEMPADUR\* 17240

CURING AGENT 97430

<b>Description:</b>	HEMPADUR 1724 is a two-component polyamide adduct-cured epoxy primer especially for use on surfaces exposed to severe abrasion.
<b>Recommended use:</b>	As a blast primer for heavy duty epoxy systems according to specification. Especially suited at low application temperatures, above -10°C/14°F.
<b>Service temperatures:</b>	Maximum, dry: 140°C/284°F.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Red/56880
Finish:	Semi-gloss
Volume solids:	45%
Theoretical spreading rate:	11.3 m <sup>2</sup> /litre - 40 micron 451 sq.ft./US gallon - 1.6 mils
Flash point:	26°C/79°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Dry to touch:	9 (approx.) hours at 5°C/41°F
Fully cured:	20 days at 5°C/41°F
V.O.C.:	475 g/litre - 3.9 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:

Mixing ratio for 17240:	Base 17249 : Curing agent 97430 3 : 1 by volume
Application method:	Airless spray                      Air spray
Thinner (max.vol.):	0845 (5%)                      0845 (15%)
Pot life:	2 hours (20°C/68°F)
Nozzle orifice:	.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
Indicated film thickness, wet:	100 micron/4 mils
Recoat interval, min:	See REMARKS overleaf
Recoat interval, max:	See REMARKS overleaf

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## 2. HEMPADUR 17240

**SURFACE PREPARATION:** **New steel:** Abrasive blasting to Sa 2½ - 3 depending on area of use. Minimum surface profile corresponding to Rugotest No. 3, BN11a, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G) - or as per the specification for the subsequent coat(s). Oil and grease must be removed with suitable detergent, salts and other contaminants by high pressure fresh water cleaning prior to blasting. After blasting, clean the surface carefully from abrasives and dust.

**Maintenance:** On old ships' bottoms and similar surfaces, excessive amounts of salt residues in pittings may call for wet abrasive blasting followed by dry abrasive blasting. Alternatively, dry abrasive blasting, high pressure fresh water cleaning, drying, and finally, dry abrasive blasting again.

**APPLICATION:** Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above -10°C/14°F.

The temperature of the paint itself should preferably be between 15°C/59°F and 25°C/77°F. In confined spaces provide adequate ventilation during application and drying.

**PRECEDING COAT:** None.

**SUBSEQUENT COAT:** HEMPADUR or HEMPATANE 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 HEMPADUR 1724)

	Minimum		Maximum	
Surface temperature	5°C/41°F		5°C/41°F	
Overcoated with	Atmospheric		Atmospheric	
	Severe	Water immersion	Severe	Water immersion
	HEMPADUR	12 hours	24 hours	60 days

The stated maximum recoating interval implies the following to secure good adhesion and the best mechanical properties:

- The coating has been applied in a dry film thickness as near as possible to the specified 40 micron/1.6 mils.
- The film formation has been of good quality and without any dry spray.
- The drying and curing conditions have been according to APPLICATION CONDITIONS (see above) until full cure has been obtained.
- No kind of surface contamination exists, except loose dust, abrasive, **loose** dry spray, which is possible to remove by vacuum cleaning (tanks) / hosing down (exterior hull).  
The surface **MUST** be completely clean before recoating.
- The coating has only been exposed to short periods of strong, direct sunlight (ultra-violet light).

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 by (high pressure) fresh water hosing and allow to dry.

**Note:** **HEMPADUR 1724 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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