

HEMPADUR* ZINC 17360

CURING AGENT 97040

Description:	HEMPADUR ZINC 1736 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:	As a "V.O.C.-compliant", versatile, long-term primer on steel for epoxy, vinyl and acrylic coating systems in medium to severely corrosive environments.
Service temperatures:	Maximum, dry: 160°C/320°F, however, depending on the subsequent coat.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red-grey/19830
Finish:	Flat
Volume solids:	64%
Theoretical spreading rate:	12.8 m ² /litre - 50 micron 513 sq.ft./S gallon - 2 mils
Flash point:	24°C/75°F
Specific gravity:	2.8 kg/litre - 23.4 lbs/US gallon
Surface dry:	½ (approx.) hour at 20°C/68°F (ISO 1517)
Dry to touch:	1 (approx.) hour at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	332 g/litre - 2.8 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 17360:	Base 17369 : Curing agent 97040 4 : 1 by volume
Application method:	Airless spray Air spray Brush
Thinner (max.vol.):	0845 (5%) 0845 (15%) 0845 (5%) (See REMARKS overleaf)
Pot life:	2 hours (20°C/68°F)
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:	50 micron/2 mils (See REMARKS overleaf)
Indicated film thickness, wet:	75 micron/3 mils
Recoat interval, min:	See REMARKS overleaf
Recoat interval, max:	See REMARKS overleaf

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SURFACE PREPARATION: Remove oil and grease thoroughly with suitable detergent. Remove salt and other contaminants by high pressure fresh water cleaning.
Abrasive blasting to Sa 2½, SSPC-SP10 with a sharp-edged surface profile corresponding to Rugotest No. 3, BN9a, Keane-Tator Comparator, 2.0 G/S, 2 S, or ISO Comparator, Medium (G).

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above -10°C/15°F. The temperature of the surface must also be above this limit. 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: As listed below in accordance with 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 film thickness than indicated depending on purpose and area of use. Most typical range is 40-50 micron/1.6-2 mils, but thicknesses down to 15 micron/0.6 mils (extra thinning) and up to 75 micron/3 mils may be possible. This will alter spreading rate and may influence amount of thinning necessary, drying time, and recoating interval.

Recoating: Recoating intervals, 50 micron dry film thickness for HEMPADUR ZINC 1736:

	Minimum			Maximum		
Surface temperature	20°C/68°F			20°C/68°F		
	Atmospheric			Atmospheric		
Recoated with (Quality numbers only)	Medium	Severe	Water immersion	Medium	Severe	Water immersion
5803	30 minutes	1 hour	Not relevant	12 hours	8 hours	Not relevant
4641, 4637	30 minutes	1 hours	Not relevant	8 hours	5 hours	Not relevant
4633	30 minutes	1 hour	1 hour	12 hours	8 hours	8 hours
5521	2 hours	4 hours	Not relevant	None	3 days*	Not relevant
4520, 4523, 4563**	2 hours	4 hours	4 hours	None	30 days*	30 days*

* If the coating has been subjected to direct sunlight for a short period only, the maximum recoating interval may be prolonged.

** Water immersion will primarily be relevant for 4520 systems.

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Notes: 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).

HEMPADUR ZINC 1736 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.

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