



HEMPADUR ZINC 17360

BASE 17369 with CURING AGENT 97040

- Description:** HEMPADUR ZINC 17360 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. In compliance with SSPC-Paint 20, type 2, level 2 and ISO 12944-5.
- Service temperatures:** Maximum, dry exposure only: 160°C/320°F (see REMARKS overleaf).
- Certificates/Approvals:** Complies with EU Directive 2004/42/EC, subcategory j (see REMARKS overleaf).
- Availability:** Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Red-grey/19830
Finish:	Flat
Volume solids, %:	65 ± 1
Theoretical spreading rate:	13.0 m ² /litre - 50 micron 521 sq.ft./US gallon - 2 mils
Flash point:	24°C/75°F
Specific gravity:	2.7 kg/litre - 22.5 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.:	345 g/litre - 2.9 lbs/US gallon

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

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.):	08450 (5%)	08450 (15%)	08450 (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 99610		
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		

- 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. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



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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 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:

VOC - EU directive 2004/42/EC:
VOC:

	As supplied	15 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	345	410	550	500

For VOC of other shades, please refer to Safety Data Sheet.

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.

Weathering/ service temperatures: The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

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 80 micron/3.2 mils may be possible. This will alter spreading rate and may influence amount of thinning necessary, drying time, and recoating interval.
(The dry film thickness range does not take into account the correction factors for rough surfaces as listed in ISO 19840).

Stirring: Before mixing with the curing agent stir the base thoroughly in order to redisperse any possible settling after storage. After mixing it is equally important to maintain stirring to keep the wet paint as a homogeneous mixture.
This is specifically important in case of a high level of thinning and/or long break in application, where the risk of settlement of zinc particles is the highest.

Recoating: Recoating intervals, 50 micron dry film thickness for HEMPADUR ZINC 17360:

Surface temperature	Minimum			Maximum		
	20°C/68°F			20°C/68°F		
Recoated with (Quality numbers only)	Atmospheric		Water immersion**	Atmospheric		Water immersion**
	Medium	Severe		Medium	Severe	
58030	30 minutes	1 hour	Not relevant	12 hours	8 hours	Not relevant
46410. 46370	30 minutes	1 hour	Not relevant	8 hours	5 hours	Not relevant
46330	30 minutes	1 hour	Not relevant	12 hours	8 hours	Not relevant
17630	2 hours	4 hours	4 hours	None	30 days*	30 days*
45880	2 hours	4 hours	Not relevant	None	30 days*	Not relevant

* Depending on actual local conditions, extended maximum recoating intervals may apply. Please contact HEMPEL for further advice.

** Water immersion service is only recommended if HEMPADUR ZINC 17360 is applied in maximum 30-40 micron/1.2-1.6 mils and recoated with an epoxy coating system in 250-300 micron/10-12 mils.

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

Note: Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow drying. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).

HEMPADUR ZINC 17360 is for professional use only.

ISSUED BY: HEMPEL A/S - 1736019830C0008

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.

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