



# Product Data

## HEMPALIN® PRIMER 12050

<b>Description:</b>	HEMPALIN PRIMER 12050 is a relatively quick-drying, zinc phosphate primer, based on long oil alkyd and urethane alkyd.
<b>Recommended use:</b>	General purpose primer for HEMPALIN systems for protection of steel in mild to medium atmospheric corrosive environments.
<b>Service temperatures:</b>	Maximum, dry exposure only: 120°C/248°F.
<b>Certificates/Approvals:</b>	Approved as a low flame spread material by Danish, French, Spanish and Singaporean authorities according to IMO resolution MSC 61 (67). Has a Danish, French, Spanish, Singaporean, Malaysian and Indonesian EC-type Examination Certificate. Complies with EU Directive 2004/42/EC, subcategory i. Please see REMARKS overleaf.
<b>Availability:</b>	Part of Group Assortment. Local availability subject to confirmation.

### PHYSICAL CONSTANTS:

Colours/Shade nos.:	Green/40760 - Red/50410
Finish:	Flat
Volume solids, %:	49 ± 1
Theoretical spreading rate:	12.3 m <sup>2</sup> /litre - 40 micron 491 sq.ft./US gallon - 1.6 mils
Flash point:	38°C/100°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Dry to touch:	2-4 hours at 20°C/68°F
V.O.C.:	415 g/litre - 3.5 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:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max.vol.):	08230 (5%)	08230 (5%)	08230 (5%)
Nozzle orifice:	.018"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08230		
Indicated film thickness, dry:	40 micron/1.6 mil		
Indicated film thickness, wet:	75 micron/3 mils		
Recoat interval, min:	See REMARKS overleaf		
Recoat interval, max:	See REMARKS overleaf		

<b>Safety:</b>	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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## HEMPALIN PRIMER 12050

**SURFACE PREPARATION:** **New steel:** Abrasive blasting to minimum Sa 2. For temporary protection, if required, use a suitable shopprimer. Damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use HEMPALIN PRIMER 12050.

**Maintenance:** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.

**APPLICATION CONDITIONS:** As dictated by normal good painting practice. In confined spaces provide adequate ventilation during application and drying.

**SUBSEQUENT COAT:** HEMPALIN system according to specification.

### REMARKS:

VOC - EU directive 2004/42/EC:

	As supplied	5 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	415	430	600	500

VOC:

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

Some of the **certificates** are issued under the former quality number 1205.

**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 HEMPALIN PRIMER 12050)

	Minimum		Maximum	
Steel temperature	20°C/68°F		20°C/68°F	
Recoated with (Quality Numbers only)	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
HEMPALIN, except 53240	5 hrs	8 hrs	none	3 days
53240	2 days	2 days	none	7 days

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

**Note:** **HEMPALIN PRIMER 12050 is for professional use only.**

**ISSUED BY:** HEMPEL A/S - 1205040760C0016

***This Product Data Sheet supersedes those previously issued.***

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

***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.***

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***Product data are subject to change without notice and become void five years from the date of issue.***