HEMPADUR ZINC 17340

17340 : BASE 17349 : CURING AGENT 97040

Description: HEMPADUR ZINC 17340 is a two-component zinc rich epoxy paint. It cures to a strong and corrosion resistant coating.

Recommended use: As a "VOC compliant" primer on steel in medium to severely corrosive environment. May be applied on zinc-shopprimed steel, where damaged spots, welds etc. have been power tool cleaned.

For on-line application on containers.

In compliance with SSPC-Paint 20, type 2, level 3.

Service temperature: Maximum, dry exposure only: 160°C/320°F

Certificates/Approvals:

Complies with EU Directive 2004/42/EC: subcategory j.

Availability: Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	19830 / Reddish grey
Finish:	Semi-flat
Volume solids, %:	66 ± 1
Theoretical spreading rate:	13.2 m^2/l [529.3 sq.ft./US gallon] - 50 micron/2 mils
Flash point:	24 °C [75.2 °F]
Specific gravity:	2.3 kg/litre [19.2 lbs/US gallon]
Surface dry:	2 approx. hour(s) 20°C/68°F
Dry to touch:	3 hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	324 g/l [2.7 lbs/US gallon]

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.

APPLICATION DETAILS:

Version, mixed product:	**17340**
Mixing ratio:	BASE 17349 : CURING AGENT 97040 4 : 1 by volume
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (15%) / 08450 (5%)
Pot life:	2 hour(s) (20°C/68°F)
Nozzle orifice:	0.017 - 0.021 "
Nozzle pressure:	175 bar [2537.5 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:	According to specification.
Recoat interval, max:	According to specification.

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations.

HEMPADUR ZINC 17340

SURFACE PREPARATION:

New steel: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use suitable zinc shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use: HEMPADUR ZINC 17340.
Maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove all rust and loose material preferably by dry abrasive blasting. Minor areas may be power tool cleaned.

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above: -10°C/14°F. At the freezing point and below be aware of the risk of ice on the surface, which will hinder adhesion. The temperature of paint itself should be 15°C/59°F or above. In confined spaces provide adequate ventilation during application and drying.

SUBSEQUENT COAT:

According to specification.

REMARKS:

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.

VOC - EU Directive 2004/42/EC:

Product	As supplied	15 vol. % thinning	Limit phase II, 2010
1734019830	324 g/l	404 g/l	500 g/l

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

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.

Application(s)

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust). If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Film thicknesses/thinning:

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: 50-75 micron/2-3 mils
(The dry film thickness range does not take into account the correction factors for rough surfaces as listed in ISO 19840).

Note:

HEMPADUR ZINC 17340 For professional use only.

ISSUED BY:

HEMPEL A/S 1734019830