



HEMPADUR ZINC 15360

BASE 15369 with CURING AGENT 95740

- Description:** HEMPADUR ZINC 15360 is a two-component polyamide cured zinc-rich epoxy primer. It cures to a hard wearing and highly weather-resistant coating. Offers cathodic protection of local mechanical damage.
- Recommended use:** For on-line application on containers. Can be used as a zinc-rich epoxy primer for other purposes according to separate painting specification.
- Service temperatures:** Maximum, dry exposure only: 160°C/320°F, however depending on the subsequent coat.
- Certificates/Approvals:** Approved as a welding primer by Lloyd's Register of Shipping.
Complies with SSPC-Paint 20, Level 2, in respect to zinc content.
Complies with ISO 12944-5, as zinc-rich primer.
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:	Semi-flat
Volume solids, %:	50 ± 1
Theoretical spreading rate:	12.5 m ² /litre - 40 micron 501 sq.ft./US gallon - 1.6 mils
Flash point:	30°C/86°F
Specific gravity:	2.3 kg/litre - 19.2 lbs/US gallon
Surface dry:	30 minutes at 20°C/68°F (ISO 1517)
Dry to touch:	2 (app.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	460 g/litre - 3.8 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 15360:	Base 15369 : Curing agent 95740 4 : 1 by volume
Application method:	Airless spray Air spray Brush
Thinner (max.vol.):	08450 (30%) 08450 (50%) 08450 (5%)
Pot life:	For on-line container production thinning according to specification 8 hours (20°C/68°F)
Nozzle orifice:	.017"-.021"
Nozzle pressure:	150 bar/2200 psi <i>(Airless spray data are indicative and subject to adjustment)</i>
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	40 micron/1.6 mils (See REMARKS overleaf)
Indicated film thickness, wet:	75 micron/3 mils
Recoat interval, min:	As per separate APPLICATION INSTRUCTIONS
Recoat interval, max:	As per separate APPLICATION INSTRUCTIONS

- 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, etc. 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 or ISO Comparator, Medium (G).

APPLICATION CONDITIONS: Use only where application and curing can proceed at temperatures above 10°C/50°F The temperature of the surface must also be above these limits, respectively. The temperature of 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: According to specification.

REMARKS:

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

	As supplied	30 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	460	550	550	500

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

Certificate has been issued under the quality number 1536.

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.

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 amount of thinning necessary, drying time, and recoating interval. Normal range is 15-50 micron/0.6-2.0 mils. (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 related to later conditions of exposure: Consult separate APPLICATION INSTRUCTIONS.

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 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).

Note: **HEMPADUR ZINC 15360 is for professional use only.**

ISSUED BY: HEMPEL A/S - 1536019830C0006

This Product Data Sheet supersedes those previously issued.

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

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