



HEMPADUR ZINC 15360

15360 : BASE 15369 : 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 temperature:	Maximum, dry exposure only: 160°C/320°F Maximum service temperature is depending on the subsequent coat.
Certificates/Approvals:	Approved as a welding primer by Lloyd's Register of Shipping. In compliance with SSPC-Paint 20, type 2, level 2 and ISO 12944-5.
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	19830 / Reddish grey
Finish:	Semi-flat
Volume solids, %:	50 ± 1
Theoretical spreading rate:	12.5 m ² /l [501.2 sq.ft./US gallon] - 40 micron/1.6 mils
Flash point:	25 °C [77 °F]
Specific gravity:	2.3 kg/litre [19 lbs/US gallon]
Surface dry:	0.5 approx. hour(s) 20°C/68°F
Dry to touch:	2 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	461 g/l [3.8 lbs/US gallon]
Shelf life:	1 year for BASE and 3 years for CURING AGENT (stored in closed container) from time of production. Depending on storage conditions. Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above: 25°C/77°F. Do not store above the following temperature: 40°C/105°F

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

APPLICATION DETAILS:

Version, mixed product:	15360
Mixing ratio:	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%) For on-line container production thinning according to specification
Pot life:	8 hour(s) 20°C/68°F
Nozzle orifice:	0.017 - 0.021 "
Nozzle pressure:	150 bar [2175 psi] (Airless spray data are indicative and subject to adjustment)
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]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf
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 15360

SURFACE PREPARATION:

Maintenance: 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) with a sharp-edged surface profile corresponding to Rugotest No. 3, BN10a-b, 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/50°F.The temperature of the surface must also be above these limits.

The temperature of 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:

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 is to avoid the risk of "wet corrosion" when the temperature rises.

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.

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 overcoating interval. Normal range dry is: 15-50 micron/0.6-2 mils

(The dry film thickness range does not take into account the correction factors for rough surfaces as listed in ISO 19840).

Overcoating:

Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

A specification supersedes any guideline overcoat intervals indicated in the table.

Environment	Atmospheric, medium					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPATEX	40 m	40 h	15 m	16 h	10 m	8 h
HEMPADUR	5 h	None	2 h	None	1 h	None
HEMPATHANE	5 h	25 d	2 h	10 d	1 h	5 d

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

Overcoating note:

Overcoating intervals related to later conditions of exposure: According to separate APPLICATION INSTRUCTIONS

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

Before overcoating 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 For professional use only.

ISSUED BY:

HEMPEL A/S
1536019830

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on www.hempel.com. 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.

The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.

HEMPEL

Product Data Sheet

supplier : manage@findotek.com