

17410: BASE 17419: CURING AGENT 98410

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| Description: | HEMPADUR FAST DRY 17410 is a two-component, high build epoxy paint which combines a relatively high volume solids content with a short drying time. Contains zinc phosphate. |
| Recommended use: | As a primer in mild to medium atmospheric environments. As an intermediate or finishing coat in epoxy systems in medium to severely corrosive atmospheric environments. |
| Service temperature: | Maximum, dry exposure only: 140°C/284°F |
| Certificates/Approvals: | |
| Availability: | Part of Group Assortment. Local availability subject to confirmation. |

PHYSICAL CONSTANTS:

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| Shade nos/Colours: | 11480* / Grey. (see REMARKS overleaf) |
| Finish: | Semi-gloss |
| Volume solids, %: | 74 ± 1 |
| Theoretical spreading rate: | 7.4 m ² /l [296.7 sq.ft./US gallon] - 100 micron/4 mils |
| Flash point: | 26 °C [78.8 °F] |
| Specific gravity: | 1.5 kg/litre [12.9 lbs/US gallon] |
| Surface-dry: | 45 minute(s) 20°C/68°F |
| Through-dry: | 2.5 hour(s) 20°C/68°F |
| Fully cured: | 7 day(s) 20°C/68°F |
| VOC content: | 238 g/l [2 lbs/US gallon] |
| Shelf life: | 3 years for BASE and 1 year (25°C/77°F) for CURING AGENT from time of production. <i>*other shades according to assortment list.</i> |

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

APPLICATION DETAILS:

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| Version, mixed product: | 17410 |
| Mixing ratio: | BASE 17419: CURING AGENT 98410 4 : 1 by volume |
| Thinner (max.vol.): | HEMPEL'S THINNER 08450 <5% depending on purpose (see REMARKS overleaf) |
| Pot life: | 1.5 hour(s) 20°C/68°F |
| Nozzle orifice: | 0.019 - 0.021 " |
| Nozzle pressure: | 225 bar [3262.5 psi] (Airless spray data are indicative and subject to adjustment) |
| Cleaning of tools: | HEMPEL'S TOOL CLEANER 99610 |
| Indicated film thickness, dry: | 100 micron [4 mils] (see REMARKS overleaf) |
| Indicated film thickness, wet: | 135 micron [5.4 mils] |
| Overcoat interval, min: | see REMARKS overleaf |
| Overcoat interval, max: | see REMARKS overleaf |

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| 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. |
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| SURFACE PREPARATION: | <p>New steel: Abrasive blasting to Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use a suitable 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 FAST DRY 17410.</p> <p>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 by wet or dry abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness. After wet abrasive blasting hose down the surface with fresh water and allow drying.</p> |
| APPLICATION CONDITIONS: | <p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: -10°C/14°F. The temperature of the paint itself should be: 15-25°C/59-77°F.</p> <p>In confined spaces provide adequate ventilation during application and drying. Thinning may be necessary in the case of very long spray hoses and/or paint temperatures below: 15°C/59°F. This will cause lower film build and longer drying time.</p> |
| PRECEDING COAT: | <p>According to specification. Recommended systems are: HEMPADUR ZINC 17360, HEMPEL'S GALVOSIL 15700.</p> <p>It is important that the surface is completely clean to ensure the adhesion. Any oil, grease, etc. to be removed by suitable detergent.</p> |
| SUBSEQUENT COAT: | <p>None, or as per specification. Recommended systems are: HEMPATHANE, HEMPADUR.</p> |
| REMARKS: | |
| Colours/Colour stability: | <p>Has a tendency to yellow after application. This will have no influence on the performance.</p> |
| Weathering/service temperatures: | <p>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.</p> |
| Application(s): | <p>Irregular surfaces: Special care should be taken in relation to irregular surfaces (welding seams, undercuts etc.) as application with an excessive film thickness may result in cracking especially on such areas. Excessive film thickness per coat is typically more than: 300 micron/12 mils.</p> <p>Application onto zinc silicate primed surfaces: Can be used on top of Zinc silicate by use of the flash coat technique.</p> <p>Depending on actual conditions of application, such as temperature, porosity of substrate, method of spray, a sealer coat (thinned up to 30%) can be applied as an alternative method to reduce popping, followed by application of the full coat.</p> |
| Film thicknesses/thinning: | <p>Recommended dry film thickness: 80-125 micron/3.2-5 mils. Excessive film thickness must be avoided. Selection of proper thinner is related to application conditions. Recommended systems are: HEMPEL'S THINNER 08450. HEMPEL'S THINNER 08700 may be used alternatively depending on local conditions.</p> |
| Shades: | <p>The product is also available in a Micaceous Iron Oxide (MIO) pigmented shade (Shade no. 12430 – reddish grey).</p> |
| Overcoating: | <p>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.</p> <p>Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.</p> |

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

| Environment | Atmospheric, medium | | | | | |
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| | -10°C (14°F) | | 0°C (32°F) | | 20°C (68°F) | |
| | Min | Max | Min | Max | Min | Max |
| HEMPADUR | 18 h | Ext. | 9 h | Ext. | 2 h | Ext. |
| HEMPATHANE | 18 h | 90 d | 9 h | 45 d | 2 h | 10 d |

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

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| Overcoating note: | <p>In case of general maintenance involving epoxy systems of high total dry film thickness, the minimum overcoating interval may advantageously be doubled up.</p> <p>For mild atmospheric exposure overcoating with HEMPADUR and HEMPATHANE qualities has no maximum. For other qualities please contact HEMPEL.</p> <p>A completely clean surface is mandatory to ensure intercoat adhesion, especially at long overcoating intervals. Any dirt, oil, grease, and other foreign matter must be removed with suitable detergent followed by (high pressure) fresh water cleaning. Salts to be removed by fresh water hosing.</p> <p>Any degraded surface layer, as a result of a long exposure period, must be removed as well.</p> <p>HEMPADUR FAST DRY 17410 For professional use only.</p> |
| Note: | |

ISSUED BY: HEMPEL A/S 1741011480

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.

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