HEMPADUR SPEED-DRY ZP 600

4541A

HEMPADUR SPEED-DRY ZP 600 : BASE 4541N : CURING AGENT 9843A

Description: HEMPADUR SPEED-DRY ZP 600 is a self-priming, two-component high build epoxy paint containing zinc phosphate.

Recommended use: As a fast curing primer or intermediate coat in mild to severely corrosive environment.
As a topcoat where the usual cosmetic performance of epoxy coatings is acceptable.
As a single coat direct to metal in mild corrosive environment.

Service temperatures: Maximum, dry exposure only: 140°C/284°F

Availability: Not included in Group assortment. Availability subject to special agreement.

PHYSICAL CONSTANTS:

Colours/Shade nos.:	Grey / 17380*
Finish:	Flat
Volume solids, %:	71 ± 1
Theoretical spreading rate:	7.1 m²/litre [289.3 sq.ft/US gallon] - 100 micron/4 mils
Flash point:	25°C [77°F]
Specific gravity:	1.5 kg/litre [12.8 lbs/US gallon]
Dry to touch:	2 (approx.) hours at 20°C/68°F
Fully cured:	7 day(s) at 20°C/68°F
VOC content:	280 g/litre [2.3 lbs/US gallon]

*other shades according to assortment list.

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

APPLICATION DETAILS:

Version, mixed product	**HEMPADUR SPEED-DRY ZP 600** BASE 4541N : CURING AGENT 9843A
Mixing ratio:	5 : 1 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	08450 (5%) / 08450 (5%)
Pot life:	1 ½ hours at 20°C/68°F
Nozzle orifice:	.019"-.021"
Nozzle pressure:	250 bar [3625 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:	150 micron/6 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 Material Safety Data Sheets and follow all local or national safety regulations.

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 minimum Sa 2 (ISO 8501-1:1988) with a surface profile corresponding to Rugotest No. 3 BN 10, Keane-Tator Comparator 3.0 G/S or ISO Comparator, rough Medium (G). After blasting, clean the surface carefully from abrasives and dust.

Repair and 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 wet or dry abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. After wet abrasive blasting hose down the surface with fresh water and allow drying. Touch up bare spots with: specified HEMPADUR paint.

APPLICATION CONDITIONS:

Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only when application and curing can proceed at temperatures above 0°C/32°F. The temperature of the paint itself should be above 15-30°C/59-86°F to secure proper application properties. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT:

None, or as per specification.

SUBSEQUENT COAT:

None, or as per specification.

REMARKS:

Colours/Colour stability:

Epoxy coatings have a natural tendency to chalk and change colour in outdoor exposure. This does not affect the performance of these coatings.

Film thickness:

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 times and overcoating intervals. Normal range dry is 75-200 micron/3-8 mils. It is recommended to use heavy airless spray equipment with a pump transmission rate of 60:1 (approximately), and a theoretical output of min. 12 litres per minute. Avoid application of excessive film thickness.

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 interval indicated in the table.

Environment	Atmospheric, medium					
Surface temperature:	0°C (32°F)		10°C (50°F)		20°C (68°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	9 h	90 d	4 h	60 d	2 h	30 d
HEMPATHANE	9 h	90 d	4 h	60 d	2 h	30 d

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

Note:

HEMPADUR SPEED-DRY ZP 600 is for professional use only.

ISSUED BY:

HEMPEL A/S – 4541A10000

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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