

Description: HEMPEL'S FAST DRY PRIMER 120SG is a single component, urethane-modified alkyd based, quick-drying primer.

Recommended use: General-purpose primer or intermediate for the protection of steel in mild to medium atmospheric corrosive environments.

Service temperatures: Maximum, dry exposure only 120°C / 248°F

Availability: Not included in Group Assortment

Physical constants:

Colours/shade Nos.: Red (50630) / Grey (11480)
Finish: Flat
Volume solids, %: 51 ± 1
Theoretical spreading rate: 10.5 m²/litre – 50 micron / 2.0 mils
421 . sq.ft. / US gallon – 2.0 mils
Flash point: 28°C [84°F]
Specific gravity: 1.4 kg/litre
Surface-dry: 1.0 Hr. at 20°C/68°F
Through-dry: 2.0 Hr. at 20°C/68°F
VOC content: 413 g/litre
Shelf life: 24 months

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

Application details:

Application method: Airless spray / Air spray /Brush
Thinner (max. vol.): 08080 (5%) / 08080 (15%) / 08080 (5%)
Nozzle orifice: 0.018" - 0.021"
Nozzle pressure: 150 bar [2175 psi]
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: HEMPEL'S THINNER 08080
Indicated film thickness, dry: 50 micron/2.0 mils *(see REMARKS overleaf)*
Indicated film thickness, wet: 100 micron/4.0 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:** Oil and grease should be removed in accordance to SSPC-SP1-solvent cleaning. The product is also designed for application to surface prepared to St2 (ISO 8501-1:1988) or SSPC-SP2.
On machinery: May be applied directly on steel and iron after degreasing and mechanical cleaning. Loosely adhering rust and paints to be prepared to minimum St2. Touch up to full firm thickness.
Repair of damaged areas: Remove oil and grease in accordance with SSPC-SP1-solvent cleaning. Loosely adhering rust and paints to be prepared to minimum St2. Touch up to full firm thickness.

Application conditions: 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.

Preceding coat: None

Subsequent coat: HEMPAL'S FAST DRY ENAMEL 538SG or according to specification.

Film thicknesses/thinning: (Optional) 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 DFT range is 40-80 micron / 1.6 – 3.2.
Depending on prevailing application conditions, Thinner 08080 can be replaced with Thinner 08230.

Remarks: Shades / Colours with the codes 1V610 and 4V710 contain Zinc phosphate.

Overcoating intervals: (Optional) 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.
HEMPEL'S FAST DRY ENAMEL 538SG	10 Hr.	18 days	5 Hr.	10 days	4 Hr.	8 days.

Note: **HEMPEL'S FAST DRY PRIMER 120SG is for professional use only.**

ISSUED BY: R & D Singapore – 120SG50630SG001LDF

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on 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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