



## HEMPADUR ZINC 15341

15341: BASE 15349: CURING AGENT 95740

|                                |  |
|--------------------------------|--|
| <b>Description:</b>            | HEMPADUR ZINC 15341 is a two-component polyamide cured zinc epoxy paint. It cures to a strong and corrosion resistant coating.             |
| <b>Recommended use:</b>        | For on-line application on containers. May be used as a zinc epoxy primer for other purposes according to separate painting specification. |
| <b>Service temperature:</b>    | Maximum, dry exposure only: 140°C/284°F  |
| <b>Certificates/Approvals:</b> | In compliance with SSPC-Paint 20, type 2, level 3.   |
| <b>Availability:</b>           | Not included in Group Assortment. Availability subject to special agreement.   |

### PHYSICAL CONSTANTS:

|                             |  |
|-----------------------------|--|
| Shade nos/Colours:          | 19830/ Red-grey  |
| Finish:                     | Semi-flat  |
| Volume solids, %:           | 46 ± 1   |
| Theoretical spreading rate: | 11.5 m <sup>2</sup> /l [461.2 sq.ft./US gallon] - 40 micron/1.6 mils |
| Flash point:                | 30 °C [86 °F]  |
| Specific gravity:           | 1.8 kg/litre [15.1 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:                | 462 g/l [3.8 lbs/US gallon]  |

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

### APPLICATION DETAILS:

|                                |   |
|--------------------------------|---|
| <b>Version, mixed product:</b> | <b>15341</b>  |
| Mixing ratio:                  | BASE 15349: CURING AGENT 95740<br>3:1 by volume   |
| Application method:            | Airless spray / Air spray / Brush   |
| Thinner (max.vol.):            | 08450 (5%)/ 08450 (15%)/ 08450 (5%)   |
| Pot life (Airless spray):      | For on-line container production thinning according to specification<br>8 approx. hour(s) 20°C/68°F |
| Pot life (Brush):              | 8 approx. hour(s) 20°C/68°F   |
| Nozzle orifice:                | 0.017 - 0.021 "   |
| Nozzle pressure:               | 175 bar [2537.5 psi]<br>(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.

**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 Sa 2½ (ISO 8501-1:2007). For temporary protection, if required, use suitable zinc 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 ZINC 15341.  
**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 abrasive blasting or power tool cleaning.

**APPLICATION CONDITIONS:** Use only where application and drying can proceed at temperatures above: 10°C/50°F. 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.

**PRECEDING COAT:** None, or as per specification.  
**SUBSEQUENT COAT:** According to specification. Recommended systems are: HEMPADUR or HEMPATEX  
**REMARKS:**

# HEMPEL

## Product Data Sheet

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**HEMPADUR ZINC 15341**

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.

Application(s):

**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.

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: 30-50 micron/1.2-2 mils.

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

Use of THINNER 08570 will give a slightly faster flash-off than with THINNER 08450, but with a greater risk of dry-spray.

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  |
| HEMPADUR    | 5 h                 | None | 2 h         | None | 1 h         | None |
| HEMPATEX    | 40 m                | 40 h | 15 m        | 16 h | 10 m        | 8 h  |
| HEMPATHANE  | 5 h                 | 25 d | 2 h         | 10 d | 1 h         | 5 d  |
| Environment | Immersion           |      |             |      |             |      |
| HEMPADUR    | 15 h                | 75 d | 6 h         | 30 d | 3 h         | 15 d |

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

Overcoating intervals:

Overcoating intervals related to later conditions of exposure: (Consult the separate APPLICATION INSTRUCTIONS)

Before overcoating after exposure in contaminated environment, clean the surface thoroughly by high pressure water cleaning and allow drying. If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. 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. In addition, scrubbing with a stiff brush may be necessary to remove zinc corrosion products (white rust).

Note:

**HEMPADUR ZINC 15341 For professional use only.**

ISSUED BY:

HEMPEL A/S  
1534119830

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on [www.hempel.com](http://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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