Hempadur Fast Dry 17410

Product characteristics

Description
Hempadur Fast Dry 17410 is an epoxy primer, intermediate, which combines high volume solids with a short drying time. It contains zinc phosphate for better corrosion protection.

Recommended use
Hempadur Fast Dry 17410 is suitable for onshore corrosion protection of new-build steel constructions where fast to handle and short overcoating times are required, such as steel for factory buildings, stadiums, exhibition halls, airports, power plants, refineries, chemical and petrochemical plants.

Service temperature:
- Maximum, dry exposure only: 140°C [284°F].
- Minimum, recommended by Hempel for dry exposure: -50°C [-58°F].

Certificates / Approvals
- Third-party verified, product-specific Environmental Product Declaration (Type III EPD, ISO 14025, EN 15804)
- Certified to APAS 2971

Features
- High volume solids.
- Fast drying.
- Can contribute to points for LEED projects (Low-emitting materials, Environmental Product Declarations).

Product safety

Flash point 27°C [81°F]

VOC content mixed product

Legislation	Value
EU	248 g/L [2.07 lb/US gal]
US (coatings)	248 g/L [2.07 lb/US gal]
US (regulatory)	248 g/L [2.07 lb/US gal]
China	248 g/L [2.07 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

Handling
Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code: 17410

Product components: Base 17419 | Curing Agent 98410

Standard shade* / code: Pebble grey / Light grey 11320 **

Gloss: Semi-gloss

Volume solids: 74 ± 2%

Specific gravity: 1.6 kg/L [13 lb/US gal]

Reference dry film thickness: 100 micron [4.0 mils]

Micaceous iron oxide (MIO) shade / code: MIO Reddish grey / Metallic grey 12430

Gloss: Semi-gloss

Volume solids: 74 ± 2%

Specific gravity: 1.6 kg/L [13 lb/US gal]

Reference dry film thickness: 100 micron [4.0 mils]

Surface preparation

Cleanliness
- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

* Other shades are available, please contact your local Hempel representative.
** Slight discolouration may occur. This does not affect the performance of the coating.

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New build:
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC) / NACE No.2.
- Remove dust, blast media and loose materials.
- All damage of shopprimer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting.

Maintenance and Repair
- Abrasive blasting to min. Sa 2 (ISO 8501-1) / SP 6 (SSPC) / NACE No. 3.
- Remove dust, blast media and loose materials.
- Flash rust degree of maximum FR M (ISO 8501-4).
- Water jetting to Wa 2½ (ISO 8501-4).
- Minor areas can be cleaned by power tool to St 3 provided the surface is roughened and not polished.

Roughness
- Surface profile Medium (G) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratio
Base 17419 : Curing Agent 98410
(4 : 1 by volume)

Stir well before use.

Thinner
Hempel's Thinner 08450

Cleaner
Hempel's Tool Cleaner 99610

Pot life

Product temperature	20°C [68°F]	15°C [59°F]	25°C [77°F]
Pot life	1½ hours	2 hours	1 hour

Application method

Tool	Application parameters	Thinning max vol.
Airless spray	Nozzle pressure: 225 bar [3300 psi] Nozzle orifice: 0.019-0.021"	5%

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Wet film thickness	94 micron [3.8 mils]	168 micron [6.7 mils]	135 micron [5.4 mils]
Dry film thickness	70 micron [2.8 mils]	125 micron [5.0 mils]	100 micron [4.0 mils]
Theoretical spreading rate	11 m²/L [448 sq ft/US gal]	5.9 m²/L [240 sq ft/US gal]	7.4 m²/L [302 sq ft/US gal]

Overthickness must be closely controlled and never locally exceed 250 micron [10 mils] DFT. On irregular surfaces it is recommended to employ special care in avoiding over application. For best performance, avoid excessive film thickness. Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval.

Application conditions
- Optimal paint temperature for proper mixing, pumping and spraying is: 15-25 °C [59-77°F].
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above -10°C [14°F] during application and curing.

Drying and overcoating

Product compatibility
- Previous coat: None or according to Hempel's specification.
- Subsequent coat: None or according to Hempel's specification.

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Drying time

Surface temperature		-10°C [14°F]	0°C [32°F]	10°C [50°F]	20°C [68°F]
Touch dry	hours	6	2½	1¼	½
Surface dry	hours	8	3½	1½	¾
Hard dry	hours	15	8	4½	2½
Through dry	hours	-	-	-	2½
Fully cured	days	-	-	-	7

Determined for dry film thickness 100 micron [4.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Overcoating times are indicative for products of the same generic chemistry when applied at the recommended DFT.
Consult Hempel's specification for more information.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	36 months
Curing Agent	12 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. The shelf life printed on product labels is based on regional climate conditions. For advice, please consult Hempel.

Storage conditions

- The product must be stored in accordance with Safety Data Sheet, label and local regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	6.7 g CO_2e/m²	0.035 lb CO_2e/ft²

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

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Additional documents

Additional information is available at the Knowledge Center:
https://www.hempel.com/knowledge-center
. The documents below can be found in the Technical Guidelines section:
https://www.hempel.com/knowledge-center/technical-guidelines
or at the Hempel website.

- Explanatory Notes for Product Data Sheet.
- Application methods.
- Substrates.
- Surface Preparation.
- Application Instruction for this product.
- Repair & maintenance.
- Inspection & quality control.

This Product Data Sheet ("**PDS**") relates to the supplied product ("**Product**") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "**Additional documents**"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.