

Hempatex Primer

Product characteristics

Description

Hempatex Primer 19161 is a paint based on a special resin for temporary corrosion protection of high temperature equipment.

Recommended use

As a temporary corrosion protection during storage and fabrication of high temperature equipment such as pipes, heating coils and hot ventilation channels.

When heated, the paint decomposes slowly under moderate release of gases.

19161 can offer temporary protection in highly corrosive environment like C5 according to ISO 12944.

Certificates / Approvals

- Meets the requirements of DAST- Guideline 006.

Product safety

Flash point 32°C [90°F]

VOC content

Legislation	Value
EU	467 g/L [3.90 lb/US gal]
US (coatings)	467 g/L [3.90 lb/US gal]
US (regulatory)	467 g/L [3.90 lb/US gal]
China	467 g/L [3.90 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.

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

19161

Aluminium shade / code

Aluminium brown 50670 *

Gloss

Please consult Hempel's Guideline on aluminium pigmented coatings.

Volume solids

49 ± 2%

Specific gravity

1.5 kg/L [12 lb/US gal]

Reference dry film thickness

60 micron [2.4 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.

New build:

- Abrasive blasting to min. Sa 1 (ISO 8501-1) / SP 7 (SSPC).
- Clean thoroughly by hand or power tool to St 3 (ISO 8501-1) / SP 3 (SSPC). Avoid polishing.
- Remove dust, blast media and loose materials.

Maintenance and Repair

- Spot abrasive blasting to min. Sa 1 (ISO 8501-1) / SP 7 (SSPC).
- Minor areas can be cleaned by power tool to St 2 provided the surface is roughened and not polished.
- Water jetting to min. Wa 2 (ISO 8501-4).
- Flash rust degree of maximum FR M (ISO 8501-4).
- Remove dust, blast media and loose materials.

Hempatex Primer

Roughness

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

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

Application

Mixing ratio

Stir well before use.

Thinner

Hempel's Thinner 08080

Cleaner

Hempel's Tool Cleaner 99610
Hempel's Thinner 08080

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 130 bar [1900 psi] Nozzle orifice: 0.013-0.019"
Air spray	15%	Not Applicable.
Brush		Not Applicable.
Roller		Not Applicable.

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
Dry film thickness	40 micron [1.6 mils]	150 micron [5.9 mils]	60 micron [2.4 mils]
Wet film thickness	80 micron [3 mils]	310 micron [12 mils]	120 micron [5 mils]
Theoretical spreading rate	12 m ² /L [490 sq ft/US gal]	3.3 m ² /L [130 sq ft/US gal]	8.2 m ² /L [330 sq ft/US gal]

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. For best performance, avoid excessive film thickness.

Application conditions

- 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 0°C [32°F] during application and curing.

Relative Humidity:

- Relative humidity must be below 80% during curing.
- Relative humidity must be below 80% during application.

Drying and overcoating

Product compatibility

- Previous coat: None.
- Subsequent coat: According to Hempel's Specification.

Drying time

Surface temperature		20°C [68°F]
Surface dry	min	30
Through dry	min	60

Determined for dry film thickness 60 micron [2.4 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Hempatex Primer

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name	10°C [50°F]		20°C [68°F]		30°C [86°F]	
	Min	Max	Min	Max	Min	Max
Atmospheric medium						
Hempatex Primer	7 h	Ext	4 h	Ext	3 h	Ext

Overcoating times are indicative for products of the same generic chemistry. 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

- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Product	36 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. For advice, please consult Hempel.

Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	6.9 g CO ₂ e/m ²	0.036 lb CO ₂ e/ft ²

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.

Hempatex Primer

Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- General Application Guidelines

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.