

# Hempadur Speed-Dry ZP 600

## Product characteristics

### 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 medium 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 medium corrosive environment.

### Service temperature:

- Maximum, dry exposure only: 140°C [284°F].

## Product safety

**Flash point** 25°C [77°F]

### VOC content mixed product

Legislation	Value
EU	282 g/L [2.35 lb/US gal]
US (coatings)	282 g/L [2.35 lb/US gal]
US (regulatory)	282 g/L [2.35 lb/US gal]
China	282 g/L [2.35 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://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

4541A

### Product components

Base 4541N  
Curing Agent 9843A

### Standard shade\* / code

Grey 18620 \*\*

### Gloss

Flat

### Volume solids

71 ± 2%

### Specific gravity

1.5 kg/L [13 lb/US gal]

### Reference dry film thickness

100 micron [3.9 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 2 (ISO 8501-1) / SP 6 (SSPC).
- Remove dust, blast media and loose materials.

### Maintenance and Repair

- Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC).
- Minor areas can be cleaned by power tool to St 3 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.

\* Epoxy coatings have an inherent tendency of chalking, fading and discolouring. This does not affect the performance of the coating

\*\* Colour stability may be affected by exposure to harsh chemical and/or high temperatures.

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## Roughness

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

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

## Application

### Mixing ratio

Base 4541N : Curing Agent 9843A  
(5 : 1 by volume)

Stir well before use.

### Thinner

Hempel's Thinner 08450

### Cleaner

Hempel's Tool Cleaner 99610

### Pot life

<b>Product temperature</b>	<b>20°C</b> [68°F]
Pot life	60 min

### Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 250 bar [3600 psi] Nozzle orifice: 0.019-0.021"
Brush	5%	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Product requires heavy duty spray equipment; spray hoses shall be as short as possible. 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	75 micron [3.0 mils]	200 micron [7.9 mils]	100 micron [3.9 mils]
Wet film thickness	110 micron [4 mils]	290 micron [11 mils]	150 micron [6 mils]
Theoretical spreading rate	9.4 m <sup>2</sup> /L [380 sq ft/US gal]	3.5 m <sup>2</sup> /L [140 sq ft/US gal]	7.1 m <sup>2</sup> /L [290 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

- Surface temperature must be above 0°C [32°F] during application and curing.
- Optimal spraying properties are obtained at paint temperatures of 15-30°C [59-86°F]. Beyond these temperatures additional thinning may be necessary.
- 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.

## Drying and overcoating

### Product compatibility

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

### Drying time

<b>Surface temperature</b>	<b>20°C</b> [68°F]
Hard dry	min 120

Determined for dry film thickness 100 micron [3.9 mils] at standard conditions, see Hempel's Explanatory Notes for details.

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## Overcoating

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

Quality name		0°C [32°F]	10°C [50°F]	20°C [68°F]
Atmospheric medium				
Hempadur Speed-Dry ZP 600	Min	9 h	4 h	2 h
	Max	90 d	60 d	30 d
Hempathane HS 55610	Min	9 h	4 h	2 h
	Max	90 d	60 d	30 d

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

- 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.
- Epoxy coatings have an inherent tendency of chalking, fading and discolouring. This does not affect the performance of the coating

## Storage

### Shelf life

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

## Additional documents

### Additional documents

- 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](http://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 <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

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](http://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.