



HEMPEL'S SHOPPRIMER ZS 15820

15820: BASE 15829: HEMPEL'S LIQUID 99751

Description: HEMPEL'S SHOPPRIMER ZS 15820 is a two-component solvent-borne zinc ethyl silicate shopprimer, designed for automatic spray application. Especially suited, where optimum welding (MIG/MAG) and gas-cutting properties are of importance. Offers corrosion protection also at heat-affected areas.

Recommended use: For short to medium-term protection of abrasive blast-cleaned steel plates and other structural steel during the storage, fabrication, and construction periods.

Certificates/Approvals: Complying with IMO MSC.215(82) as shop primer for ballast tank coating systems. Approved as a welding primer by Lloyd's Register of Shipping. Certified by major classification societies. (see REMARKS overleaf). Contact your local Hempel representative for more info and specific certificates.

Availability: Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours: 19840*/ Grey.
Finish: Flat
Volume solids, %: 28 ± 1
Theoretical spreading rate: 18.7 m²/l [749.9 sq.ft./US gallon] - 15 micron/0.6 mils
Flash point: 22 °C [71.6 °F]
Specific gravity: 1.3 kg/litre [10.6 lbs/US gallon]
Dry to handle: 4 - 5 minute(s) 20°C/68°F
Fully cured: 4 day(s) (20°C/68°F, 75% RH)
VOC content: 652 g/l [5.4 lbs/US gallon]
Shelf life: 1 Year (25°C/77°F) from time of production.
Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F or below 5°C/40°F.
Shelf life is exceeded if the liquid is gelled or if the mixed product forms gels before application.
**other shades according to assortment list.*

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

APPLICATION DETAILS:

Version, mixed product: 15820
Mixing ratio: BASE 15829: HEMPEL'S LIQUID 99751
2 : 3 by volume
Application method: Airless spray / Air spray / Brush (touch up)
Thinner (max.vol.): 08570
see REMARKS overleaf
Pot life: 24 hour(s) 20°C/68°F (Closed container, constant stirring) see REMARKS overleaf
Nozzle orifice: 0.019 - 0.023 "
Nozzle pressure: 80 bar [1160 psi]
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: HEMPEL'S THINNER 08570
Indicated film thickness, dry: 15 micron [0.6 mils] see REMARKS overleaf
Indicated film thickness, wet: Not relevant
Recoat interval, min: According to specification.
Recoat interval, max: According to specification.

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.



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SURFACE PREPARATION:	Remove oil and grease with suitable detergent. Abrasive blasting to minimum Sa 2½ (ISO 8501-1:1988) with a surface profile equivalent to Rugotest No. 3, min. N9a, Keane-Tator Comparator, 2 mils segments or ISO Comparator Medium (G,S). For special purposes grit blasting is necessary.
APPLICATION CONDITIONS:	The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. Minimum steel temperature: 0°C/32°F. Maximum steel temperature approximately: 55°C/131°F. Minimum temperature for curing is: 0°C/32°F. Minimum relative humidity: 50%. Relative humidity preferably above: 65%. See separate APPLICATION INSTRUCTIONS
SUBSEQUENT COAT:	According to specification.
REMARKS:	
Application(s)	For steel to be used for ballast tanks, IMO Resolution MSC.215(82) requires that the contamination with water soluble salts measured according to ISO 8502-9 must not exceed a conductivity equivalent to 50 mg/m ² sodium chloride. The dust quantity rating assessed according to ISO 8502-3 must not exceed rating "1" for dust size classes "3", "4" or "5". If shelf life is exceeded, it is usually possible to use the zinc paste (BASE), if any settling can be remixed. The liquid may be used provided it shows no signs of turbidity, but pot life will be very much shortened, see application(s). In any case, possible surpassing of storage time will be of 1-2 months maximum (20°C/68°F) for the liquid. The pot life may be gradually reduced to 8 hours (20°C/68°F) as the liquid approaches the end of its shelf life, assuming that it is stored under favourable conditions.
Film thicknesses/thinning:	For this shopprimer, the indicated dry film thickness means the thickness measured on a smooth test panel and when the shopprimer is being applied to abrasive blasted substrate with a roughness of approximately: Rz 60 micron. A higher roughness may require upwards adjustment of the dry film thickness and correspondingly reduce the theoretical spreading rate. Actual specified dry film thickness may depend on welding requirements, exposure conditions and required protection time. Dry film thickness range with suitable thinning is: 10-25 micron/ 0.4-1 mils. The product should be applied in a uniform film thickness. Avoid dry spray and exaggerated film thickness. Depending on requested protective lifetime the dry film thickness may be varied. As specified on a blasted surface, dry film thickness may vary: Minimum: 10 micron/0.4 mils. Maximum: 20 micron/0.8 mils
Curing agent:	Curing time is prolonged at relative humidity below: 75%.
Recoating intervals:	No maximum recoat interval for adhesion, but dictated by gradual breakdown and damage during exposure and fabrication. Regarding treatment before recoating, please consult APPLICATION INSTRUCTIONS.
Note:	HEMPEL'S SHOPPRIMER ZS 15820 For professional use only.
ISSUED BY:	HEMPEL A/S

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This Product Data Sheet supersedes those previously issued.

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