

# Hempadur Avantguard 860

## Product characteristics

### Description

Hempadur Avantguard 860 is an activated zinc-rich epoxy primer in compliance with the requirements of Level 1, type II in SSPC Paint-20, 2019 and ISO 12944 Part 5, 2018. The product is in full compliance with ASTM D520 type II and EU Directive 2004/42/EC, The Paints Directive on the limitation of volatile organic compounds: subcategory j.

### Recommended use

Hempadur Avantguard 860 is recommended as a general purpose for long-term protection of steel exposed to high to extreme corrosive environments (ISO 12944 Part 2). Suitable for offshore environment protection. The product is a fast curing alternative to the use of zinc rich silicates in atmospheric anticorrosion protections for temperatures below 160°C [320°F].

### Service temperature:

- Maximum, dry exposure only: 160°C [320°F].

### Certificates / Approvals

- Meets requirements to ISO 12944 when used as part of a predefined paint system. Part 6 C5, Part 9 CX.
- Meets requirements to NORSOK M-501 when used as part of a predefined paint system. Edition 6, system no. 1.

### Features

- Reduces the effect of corrosion and provides outstanding galvanic protection.
- Dries fast and has short minimum overcoating intervals.
- Excellent mechanical strength, also in cyclic temperatures, with improved tolerance to high film thickness through high flexibility and self-healing effect.
- Superior tolerance to high relative humidity during application.
- Cures down to -10°C [14°F].

## Product safety

**Flash point** 26°C [79°F]

### VOC content mixed product

Legislation	Value
EU	302 g/L [2.52 lb/US gal]
US (coatings)	352 g/L [2.94 lb/US gal]
US (regulatory)	352 g/L [2.94 lb/US gal]
China	352 g/L [2.94 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.

### 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

17990

### Product components

Base 17999  
Curing Agent 98384

### Standard shade / code

Grey 19840

### Gloss

Flat

### Volume solids

66 ± 2%

### Specific gravity

2.5 kg/L [21 lb/US gal]

### Reference dry film thickness

60 micron [2.4 mils]

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## 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 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

### Roughness

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

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

## Application

### Mixing ratio

Base 17999 : Curing Agent 98384  
(8.5 : 1.5 by volume)

Products containing floating or settling particles/pigments need to be continuously stirred during application. This is especially important in case of heavy thinning.

### Thinner

Hempel's Thinner 08450

### Cleaner

Hempel's Tool Cleaner 99610

### Pot life

Product temperature	0°C [32°F]	20°C [68°F]	40°C [104°F]
Pot life	7 hours	6 hours	5 hours

## Application method

Tool	Thinning max vol.	Application parameters
Airless spray	10%	Nozzle pressure: 220 bar [3200 psi] Nozzle orifice: 0.017-0.021"

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]	100 micron [3.9 mils]	60 micron [2.4 mils]
Wet film thickness	60 micron [2.5 mils]	150 micron [6 mils]	90 micron [3.5 mils]
Theoretical spreading rate	16 m <sup>2</sup> /L [650 sq ft/US gal]	6.6 m <sup>2</sup> /L [270 sq ft/US gal]	11 m <sup>2</sup> /L [450 sq ft/US gal]

Overthickness should be closely controlled and never locally exceed 200 micron [7.9 mils] DFT. On irregular surfaces it is recommended to employ special care in avoiding over application.

## Application conditions

- Temperature of product must be above 15°C [59°F] during application.
- 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.
- Surface temperature must be below 40°C [104°F] during application and curing.

## Relative Humidity:

- Relative humidity must be below 95% during curing.
- Relative humidity must be below 95% during application.

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## Drying and overcoating

### Product compatibility

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

### Drying time

Surface temperature		-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
Touch dry	hours	2½	1	¼	¼
Hard dry	hours	9	4½	1	¼

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

### Overcoating

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

Quality name		-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
Atmospheric medium					
Hempaprime Multi 500	Min	3 h	90 min	45 min	25 min
	Max	Ext*	Ext	Ext	Ext
Atmospheric severe					
Hempaprime Multi 500	Min	3 h	90 min	45 min	25 min
	Max	90 d	90 d	30 d	7 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.
- Remove zinc salts or other contamination before overcoating.
- 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]
Base	12 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.

### Storage conditions

- Product must be stored according to local legislation, at maximum 40 °C [104°F], without direct sunlight and protected from rain and snow.

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## 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.
- 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](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.