

### 35870 : BASE 35879 : CURING AGENT 98870

<b>Description:</b>	HEMPADUR MULTI-STRENGTH GF 35870 is an amine-adduct cured epoxy coating - the product is reinforced with Glassflakes. It is a hard, impact and abrasion resistant coating with good resistance to sea water and splashes from petrol and related products. Suitable for early water exposure and will continue to cure under water.
<b>Recommended use:</b>	As a self-primed, high build coating primarily for areas subject to abrasion and/or to a highly corrosive environment. E.g. splash zones, jetty pilings and working decks.
<b>Service temperature:</b>	Maximum, dry exposure only: 140°C/284°F In water (no temperature gradient): 60°C/140°F Maximum peak temperature in water is 80°C/176°F.
<b>Certificates/Approvals:</b>	Recognized Abrasion Resistant Ice Coating by Lloyds Register. Tested for non-contamination of grain cargo at the Newcastle Occupational Health & Hygiene, Great Britain.
<b>Availability:</b>	Part of Group Assortment. Local availability subject to confirmation.

#### PHYSICAL CONSTANTS:

Shade nos/Colours:	19990 / Black.
Finish:	Glossy
Volume solids, %:	87 ± 1
Theoretical spreading rate:	2.5 m <sup>2</sup> /l [100.2 sq.ft./US gallon] - 350 micron/14 mils
Flash point:	35 °C [95 °F]
Specific gravity:	1.3 kg/litre [11.1 lbs/US gallon]
Surface-dry:	4 approx. hour(s) 20°C/68°F
Dry to touch:	6 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	200 g/l [1.7 lbs/US gallon]
Shelf life:	2 years for BASE and 3 years (25°C/77°F) for CURING AGENT from time of production.

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

#### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>35870</b>
Mixing ratio:	BASE 35879 : CURING AGENT 98870 3 : 1 by volume
Application method:	Airless spray
Thinner (max.vol.):	08450 (5%)
Pot life:	1 hour(s) 20°C/68°F
Nozzle orifice:	0.023 - 0.027 " Reversible
Nozzle pressure:	250 bar [3625 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	350 micron [14 mils]
Indicated film thickness, wet:	400 micron [16 mils]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf

<b>Safety:</b>	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:	<p><b>New steel:</b> Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to near white metal Sa 2½ with a surface profile corresponding to Rugotest No. 3, BN10, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G). After blasting, clean the surface carefully from abrasives and dust.</p> <p><b>Maintenance:</b> Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove all rust and loose material by wet or dry abrasive blasting or power tool cleaning. Feather edges to sound and intact areas. After wet abrasive blasting hose down the surface with fresh water and allow drying.</p> <p>Touch up bare spots to full film thickness when the surface has become visually dry.</p>
APPLICATION CONDITIONS:	Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. May be applied and will cure at temperatures down to 5°C/41°F. The temperature of the paint itself should be above: 15°C/59°F. The best result is obtained at: 20-30°C/68-86°F. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None. If a blast primer is required, use: HEMPADUR 15590.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Certificates/Approvals:	The recognition as Abrasion Resistant Ice Coating by Lloyds Register applies to the product as well as production site – at present the certificate is valid only for paint material produced at the following Hempel factories: Hempel Paints Poland, Buk and Kunshan, China.
Colours/Colour stability:	Light shades will have a tendency to yellow when exposed to sunshine and darken when exposed to heat.
Weathering/service temperatures:	The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.
Application(s):	The product may be immersed after 4 hours of initial curing at 20°C/68°F. Curing will proceed under water. Early immersion may result in some discolouration. This does not affect the protective properties of the product.
Application equipment:	<p>Standard airless heavy-duty spray equipment:                      Recommended pump ratio: minimum 45:1                      Pump output: 12 litres/minute (theoretical)                      Spray hoses: max 15 metres/50 feet, 3/8" internal diameter, max 3 metres/10 feet, 1/4" internal diameter</p> <p>If longer spray hoses are necessary it is possible to add up to : 50 meters / 150 feet.                      The high output capacity of the pump must be obtained. The ratio must be raised to :60:1.                      Bigger spray nozzles will also call for increased pump size. A reversible nozzle is recommended.                      Surge tank filter and tip filter should be removed.</p>
Film thicknesses/thinning:	May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and overcoating interval. Normal range dry is: 350-500 micron/14-20 mils
Overcoating:	Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

A specification supersedes any guideline overcoat intervals indicated in the table.

Environment	Atmospheric, medium					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
HEMPADUR	15 h	150 d	6 h	60 d	3 h	30 d
HEMPATHANE	10 h	25 d	4 h	10 d	2 h	5 d
Environment	Immersion					
HEMPADUR	40 h	75 d	16 h	30 d	8 h	15 d

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

Note: **HEMPADUR MULTI-STRENGTH GF 35870 For professional use only.**  
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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](http://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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 Product data are subject to change without notice and become void five years from the date of issue.