

35560 : BASE 35569 : CURING AGENT 98560

Description:	HEMPADUR 35560 is a solvent-free, two-component, high-build, polyamine adduct cured epoxy paint, which cures to a coating with good resistance to fresh water.
Recommended use:	As a lining in potable water tanks and pipelines. 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 and bridge pilings and decks.
Features:	Excellent anticorrosive properties. Solvent free. Benzyl alcohol free.
Service temperature:	Maximum, dry exposure only: 140°C/284°F In fresh water (directly on steel): 45°C/113°F. (no temperature gradient)
Certificates/Approvals:	Conforms to NORSOK M-501, edition 6, system nos. 7A and 7B. Approved by WRAS for potable water up to 35°C/95°F. Certified by NSF International to NSF/ANSI standard 61- Drinking Water System Components - Health Effects. Please consult http://info.nsf.org/Certified/PwsComponents/ , Certified Products & Systems for detailed information. Tested according to section 175.300 of the Code of Federal Regulations Title 21 - Liquid and Dry Foodstuff. Consult Hempel for details. Approved by Folkehelseinstituttet, Norway, for use in tanks for potable water offshore.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	20320 / Cream
Finish:	Glossy
Volume solids, %:	100
Theoretical spreading rate:	5 m ² /l [200.5 sq.ft./US gallon] - 200 micron/8 mils
Flash point:	100 °C [212 °F]
Specific gravity:	1.4 kg/litre [11.3 lbs/US gallon]
Surface-dry:	12 approx. hour(s) 20°C/68°F
Through-dry:	16 approx. hour(s) 20°C/68°F
Dry to touch:	10 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	0 g/l [0 lbs/US gallon]
Shelf life:	3 years for BASE and 1 year (25°C/77°F) for CURING AGENT from time of production. Mechanical stirring may be necessary before usage. <i>*other shades according to assortment list.</i>

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

APPLICATION DETAILS:

Version, mixed product:	35560
Mixing ratio:	BASE 35569 : CURING AGENT 98560 6.8 : 2 by volume
Application method:	Airless spray / Brush
Thinner (max.vol.):	Do not dilute.
Pot life:	1.5 hour(s) 20°C/68°F 45 minutes (35°C/95°F)
Nozzle orifice:	0.019 - 0.025 "
Nozzle pressure:	220 bar [3190 psi] minimum. (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	200 micron [8 mils]
Indicated film thickness, wet:	200 micron [8 mils]
Overcoat interval, min:	see REMARKS overleaf
Overcoat interval, max:	see REMARKS overleaf

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: **New steel:** 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 (ISO 8501-1:2007) with a surface profile corresponding to Rugotest No. 3, BN10a, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating.
Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again.
Concrete: Remove slip agent and other possible contaminants by emulsion washing followed by high pressure hosing with fresh water. Remove scum layer and loose matter to a hard, rough and uniform surface, preferably by abrasive blasting, possibly by other mechanical treatment or acid etching. Seal surface with suitable sealer, as per relevant painting specification.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above:10°C/50°F. The temperature of the paint itself should be above:15°C/59°F. In-can temperature of the paint should preferably be below 30°C/86°F.
Curing requires a relative humidity of: maximum 85%. For low temperatures (10-15°C/50-59°F), then the maximum relative humidity is: 65%. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: None, or as per specification.
If a blast primer/hold-coat is required use: HEMPADUR 15590 (According to separate APPLICATION INSTRUCTIONS)

SUBSEQUENT COAT: None.

REMARKS:

Certificates/Approvals: NSF certification applies to the product as well as production site – at present this NSF certificate is valid only for paint material produced at following Hempel factories in: Hempel Paints Poland, Buk For shades 20320 / 50900 - 10 days curing at 20°C/68°F .
For shade 10000 - 14 days curing at 20°C/68°F.

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.

Induction time: At a paint temperature of 20°C/68°F the paint may advantageously be prereacted 10 minutes before spray application (20 minutes at 15°C/59°F).

Application(s): Disinfection by for instance chlorination can be very aggressive towards the coating and separate instructions are available.

Film thicknesses/thinning: May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate. Normal range for tanks: 200-400 micron/8-16 mils.
May be specified in film thicknesses up to 600 µm for controlled applications, e.g. on pipelines. Contact HEMPEL for more information.

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	Immersion					
	10°C (50°F)		20°C (68°F)		30°C (86°F)	
	Min	Max	Min	Max	Min	Max
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 35560 For professional use only.**

ISSUED BY: HEMPEL A/S 3556020320

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.
The Products are supplied and all technical assistance is given subject to HEMPEL's GENERAL CONDITIONS OF SALES, DELIVERY AND SERVICE, unless otherwise expressly agreed in writing. The Manufacturer and Seller disclaim, and Buyer and/or User waive all claims involving, any liability, including but not limited to negligence, except as expressed in said GENERAL CONDITIONS for all results, injury or direct or consequential losses or damages arising from the use of the Products as recommended above, on the overleaf or otherwise. Product data are subject to change without notice and become void five years from the date of issue.