

35530 : BASE 35539 : CURING AGENT 95530

Description: HEMPADUR MULTI-STRENGTH 35530 is a solvent-free, two-component, high-build, polyamine cured epoxy paint, which cures to a coating with good resistance to fresh water, sea water, crude oil, and to abrasion.
Applicable in thick coats by standard heavy duty airless spray equipment.
Harmless to grain cargo.

Recommended use: As a heavy duty coating on steel exposed to abrasion where solvent-free materials are required. Full colour retention will be of secondary importance.
If solvent containing paints are accepted, HEMPADUR MULTI-STRENGTH 45751 substitutes.
As a lining in potable water tanks and pipelines. Please see Certificates/Approvals.
For application in warm climates. Please see APPLICATION CONDITIONS overleaf.

Service temperature: Maximum, dry exposure only: 140°C/284°F.
In water (no temperature gradient): 35°C/95°F

Certificates/Approvals: Approved by WRAS for potable water up to 23°C/73°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.
Complies with EU Directive 2004/42/EC: subcategory j.

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

PHYSICAL CONSTANTS:

Shade nos/Colours: 10500* / Grey.
Finish: Semi-gloss
Volume solids, %: 100
Theoretical spreading rate: 3.3 m²/l [132.3 sq.ft./US gallon] - 300 micron/12 mils
Flash point: 100 °C [212 °F]
Specific gravity: 1.3 kg/litre [11.2 lbs/US gallon]
Surface-dry: 6 hour(s) 20°C/68°F
Through-dry: 15 hour(s) 20°C/68°F
Fully cured: 7 day(s) 20°C/68°F
VOC content: 9 g/l [0.1 lbs/US gallon]

**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: **35530**
Mixing ratio: BASE 35539 : CURING AGENT 95530
3 : 1 by volume
Stir CURING AGENT before adding it to the BASE.
Application method: Airless spray / Brush
Thinner (max.vol.): Do not dilute. (Consult the separate APPLICATION INSTRUCTIONS)
Pot life: 1 approx. hour(s) 20°C/68°F (Consult the separate APPLICATION INSTRUCTIONS)
Nozzle orifice: 0.019 - 0.031 "
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: 300 micron [12 mils] see REMARKS overleaf
Indicated film thickness, wet: 300 micron [12 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.

SURFACE PREPARATION:	<p>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.</p> <p>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.</p> <p>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.</p>
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 paint itself should be 15°C/59°F or above. In-can temperature of the paint should preferably be below 25°C/77°F. Curing requires a relative humidity of: maximum 85%. For application in warm climates, HEMPADUR MULTI-STRENGTH 45751 may preferably replace HEMPADUR MULTI-STRENGTH 35530 as a heavy duty coating. For potable water tanks and pipes please check local product assortment.
PRECEDING COAT:	None, or as per specification. Recommended systems are: HEMPADUR SEALER 05990 or HEMPADUR 15590 (According to separate APPLICATION INSTRUCTIONS)
SUBSEQUENT COAT:	None, or as per specification. Recommended systems are: HEMPADUR or HEMPATHANE
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 (USA) Inc., Conroe. The WRAS approval is valid once the final coating has cured for at least the following number of days: 7 days (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.
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 and may influence drying time and overcoating interval. Normal range dry is: 200-300 micron/8-12 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	40 h	12½ d	16 h	5 d	8 h	2½ d
Environment	Immersion					
HEMPADUR	40 h	12½ d	16 h	5 d	8 h	2½ d

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

Overcoating note:	Stir the individual BASE and CURING AGENT thoroughly before mixing and again after mixing until a uniformly coloured mixture is obtained. If colour stability is requested for exposure to sunshine, it is recommended to topcoat with eg HEMPATHANE TOPCOAT 55210. Potable water tanks: See APPLICATION INSTRUCTIONS, as to time before taking into use and post treatment of coated surfaces to be in contact with potable water.
Note:	HEMPADUR MULTI-STRENGTH 35530 For professional use only.
ISSUED BY:	HEMPEL A/S 3553010500

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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