

HEMPADUR* FILLER 35250

CURING AGENT 95250

Description: HEMPADUR FILLER 3525 is a two-component, solvent-free, epoxy filler, which - when fully cured - is resistant to water, aliphatic hydrocarbons, and related products. Can be applied in thick coats up to approximately 5 mm without runs or sags.

Recommended use:

1. As a filler for metals, hardwood, and other rigid materials.
On large surfaces especially suited for smooth filling.
2. For filling of minor pinholes in weldings not later exposed to strong chemicals.

Service temperatures:

	Dry:	In water (no temperature gradient):
Maximum:	140°C/284°F	35°C/95°F

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Light grey/19810
Finish:	Semi-gloss
Volume solids:	100%
Flash point:	92°C/198°F
Specific gravity:	1.6 kg/litre - 13.4 lbs/US gallon
Dry to touch:	8 (approx.) hours at 20°C/68°F
Fully cured:	5 (approx.) days at 20°C/68°F
V.O.C.:	10 g/litre - 0.1 lbs/US gallon

*The physical constants are subject to normal manufacturing tolerances.
Further reference is made to "Explanatory Notes" in the Hempel Book.*

APPLICATION DETAILS:

Mixing ratio for 35250:	Base 35259 : Curing agent 95250 1 : 1 by volume
Application method:	Putty knife, or similar.
Thinner (max.vol.):	Do not dilute
Pot life:	1 hour (20°C/68°F)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 9961
Recoat interval, min:	8 hours (20°C/68°F)
Recoat interval, max:	24 hours (20°C/68°F) (See REMARKS overleaf)

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SURFACE PREPARATION:	Metal: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting, power tool cleaning or sanding, depending on material and condition of the surface. Pitted steel should be blast cleaned and/or ground with high speed burrs. Round off sharp edges. Finally clean the area with HEMPEL'S THINNER 0845. Priming after abrasive blast cleaning can be done with a thin layer of e.g. HEMPADUR 1559.
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 5°C/41°F. The temperature of the substrate should also be above this limit. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	Can be recoated with HEMPALIN, HEMPATEX or HEMPADUR qualities according to specification. High-gloss finishes such as HEMPATHANE TOPCOAT, should not be applied directly on top of HEMPADUR FILLER 3525. An intermediate coat e.g. HEMPADUR HI-BUILD 4520 is recommended.
REMARKS:	Mix and stir the two components thoroughly until an even light grey colour is achieved, whereafter the filler is ready for use. Do not mix more than is necessary for use within the pot life. If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. May be sanded after 16 hours (20°C/68°F).
Note:	HEMPADUR FILLER 3525 is for professional use only.
SAFETY:	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Material Safety Data Sheets and follow all local or national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

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Product data are subject to change without notice and become void five years from the date of issue.

Issued by HEMPEL'S MARINE PAINTS A/S.

*This is a corporate trademark of the Hempel Group.

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