

# HEMPADUR\* 35450

CURING AGENT 97400

<b>Description:</b>	HEMPADUR 3545 is a two-component, amine adduct cured epoxy paint with a very high solids content. It cures to a coating resistant to water, aliphatic and aromatic hydrocarbons, and leaded and unleaded gasolines containing alcohol and ether additives.
<b>Recommended use:</b>	As a tank lining for oil and gasoline storage tanks and similar.
<b>Service temperatures:</b> Maximum:	Dry: 140°C/284°F In water (no temperature gradient across the paint film): 35°C/95°F
<b>Approvals, certificates:</b>	Approved according to the Danish Ministry of Environmental Protection's departmental order no. 386 as coating for oil and gasoline storage tanks and according to the Swedish National Testing and Research Institute, Technical Instruction TA 14-01, point 6, edition no. 2: Coating for Tanks for Flammable Liquids.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Yellow/20630 - Pink/50920
Finish:	Glossy
Volume solids:	97%
Theoretical spreading rate:	3.9 m <sup>2</sup> /litre - 250 micron 156 sq.ft/US gallon - 10 mils
Flash point:	63°C/145°F
Specific gravity:	1.6 kg/litre - 13.4 lbs/US gallon
Surface dry:	7 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	12 (approx.) hours at 20°C/68°F
Fully cured:	10 days at 20°C/68°F
V.O.C.:	42 g/litre - 0.35 lbs/US gallon
Shelf life:	1 year from time of production. Depending on storage conditions, mechanical stirring may be necessary before usage.

*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 35450:	Base 35459 : Curing agent 97400 3 : 1 by volume
Application method:	Airless spray (heated) Brush (See REMARKS overleaf)
Thinner:	None None
Pot life:	30 minutes (20°C&68°F) (see separate APPLICATION INSTRUCTIONS)
Nozzle orifice:	.019"-.023"
Nozzle pressure:	250 bar/3600 psi (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 9961
Indicated film thickness, dry:	250 micron/10 mils
Indicated film thickness, wet:	275 micron/11 mils
Recoating interval, min:	16 hours (20°C/68°F) (See REMARKS overleaf)
Recoating interval, max:	7 days (20°C/68°F)

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## 2. HEMPADUR 35450

SURFACE PREPARATION:	<p><b>New steel:</b> Oil and grease must be removed with suitable detergent, salts and other contaminants by high pressure fresh water hosing prior to blasting. Abrasive blasting to Sa 2½-3, SSPC-SP-10-5, with a surface profile equivalent to Rugotest No. 3, BN10a, Keane-Tator comparator, min. 3.0 G/S, or ISO Comparator rough MEDIUM (G). After blasting clean the surface carefully from abrasives and dust by vacuum cleaning.</p> <p><b>Pit-corroded steel:</b> See below and separate APPLICATION INSTRUCTIONS.</p>
APPLICATION CONDITIONS:	<p>Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the surface must also be above 10°C/50°F. The temperature of the paint itself should be above 20-25°C/68-77°F for proper mixing and pumping. On the output side of the airless spray equipment material heating is used (see REMARKS below).</p> <p>Apply only on a dry and clean surface with a temperature at least 3°C/5°F above the dew point to avoid condensation. Relative humidity max 80%, preferably 40-60%. In confined spaces provide adequate ventilation during application and drying.</p>
PRECEEDING COAT:	None, or as per specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Application:	<p>May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence the drying time. Normal range is 250-300 micron/10-12 mils.</p> <p>Mix BASE and CURING AGENT thoroughly until a uniformly coloured mixture is obtained.</p>
Hot airless spray:	<p>It is recommended to use heavy duty airless spray equipment that can supply a nozzle pressure of minimum 250 bar and a high volume output (minimum 12 litres per minute).</p> <p>On the output side of the pump an electrically heated, explosion proof, high pressure, material heater is fitted. The heating capacity must be 2-2.5 kW. The thermostat is set at 40°C/104°F.</p> <p>Spray hoses: max 30 metres/100 feet, 3/8" internal diameter. 5 metres/17 feet, 1/4" internal diameter.</p>
Pit corroded surfaces:	<p>In case of extensive pit corrosion (old tank bottoms) it is advisable to apply the first coat by brush. The coating must be worked well into the pits facilitating a good wetting of the steel and closing the porosities. The following coat(s) can be applied by brush as well as by airless spray (as per above) securing full covering of the uneven/rough surface.</p>
Recoating:	Contact HEMPEL if the maximum recoating interval is exceeded.
Curing:	Do not put tanks into service until the paint system is completely cured.
Note:	<b>HEMPADUR 3545 is for professional use only.</b>
SAFETY:	<p>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.</p>

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. 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.

Issued by HEMPEL'S MARINE PAINTS A/S.

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