

# HEMPADUR\* MULTI-STRENGTH \* 35530

CURING AGENT 95530

## Description:

HEMPADUR MULTI-STRENGTH 3553 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:

1. 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 4575 substitutes.
2. As a lining in potable water tanks.

For application in warm climates. Please see APPLICATION CONDITIONS overleaf.

## Service temperatures:

	Dry:	In fresh water (directly on steel):
Maximum:	140°C/284°F	35°C/95°F (no temperature gradient)
See REMARKS overleaf.		

## Approvals, certificates:

Approved by Lloyd's Register of Shipping as a provisionally recognized corrosion control coating. Tested for non-contamination of grain cargo at the Newcastle Occupational Health Agency, Great Britain.

Approved by Water Research Centre, Great Britain, for potable water.

## Availability:

Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/10500 - Red/51320
Finish:	Semi-gloss
Volume solids:	100%
Theoretical spreading rate:	3.3 m <sup>2</sup> /litre - 300 micron 134 sq.ft./US gallon - 12 mils
Flash point:	> 100°C/212°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	12 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	24 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	0 g/litre - 0 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 35530:	Base 35539 : Curing agent 95530 3 : 1 by volume Stir CURING AGENT before adding it to the BASE.
Application method:	Airless spray      Brush (touch up) (Consult the separate APPLICATION INSTRUCTIONS)
Thinner (max.vol.):	Do not dilute (Consult the separate APPLICATION INSTRUCTIONS)
Pot life:	1 hour (20°C/68°F) (Consult the separate APPLICATION INSTRUCTIONS)
Nozzle orifice:	.019" - .031"
Nozzle pressure:	min. 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:	300 micron/12 mils (See REMARKS overleaf)
Indicated film thickness, wet:	300 micron/12 mils
Recoat interval, min:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS
Recoat interval, max:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS

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## 2. HEMPADUR MULTI-STRENGTH 35530

### SURFACE

**When used as a heavy duty coating or in potable water tanks:**

### PREPARATION:

Abrasive blasting to min. Sa 2½. Surface profile corresponding to Rugotest No. 3, BN 11, Keane-Tator Comparator, 5.5 G/S, or ISO Comparator Coarse (G). Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasives and dust. On 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, alternatively hydrojetting followed by abrasive blasting.

**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, eg HEMPADUR SEALER 0597 (furthermore, please see Product Data Sheet for 0597).

### APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above 10°C/50°F. The temperature of the paint itself must be above 15°C/59°F for proper application. In-can temperature of the paint should preferably be below 25°C/77°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 85%.

For application in warm climates, HEMPADUR 3573 (potable water tanks), HEMPADUR MULTI-STRENGTH 4575 may preferably replace HEMPADUR MULTI-STRENGTH 3553.

### PRECEDING COAT:

None, HEMPADUR SEALER 0597, HEMPADUR 1559 or according to specification.

### SUBSEQUENT COAT:

None, HEMPADUR, HEMPATHANE or HEMPANYL qualities as per specification.

### REMARKS:

#### Weathering:

A tendency to chalk in outdoor exposure does not detract from the protective properties.

#### Service

#### temperatures:

Even though the service temperature is kept below the specified maximum, it should be noted that the higher the temperature, the more sensitive the paint will be to mechanical and/or chemical exposure. Combined thermal/mechanical and/or chemical exposure may therefore increase the risk of damage.

#### Film thicknesses:

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 recoating interval. Normal range dry is 200-300 micron/8-12 mils.

#### Recoating:

Recoating intervals related to later conditions of exposure:

(300 micron/12 mils dry film thickness of HEMPADUR MULTI-STRENGTH 3553)

	Minimum		Maximum	
Surface temperature	20°C/68°F		20°C/68°F	
	Atmospheric	Water immersion	Atmospheric	Water immersion
Recoated with	Severe		Severe	
HEMPADUR	24 hours	24 hours	5 days	5 days
HEMPATHANE	12 hours	Not relevant	24 hours	Not relevant

Mix and stir the two components until an even colour is achieved, whereafter the paint is ready for use. If improved colour stability is requested for exposure to sunshine, it is recommended to topcoat with e.g. HEMPATHANE TOPCOAT 5521.

**Potable water tanks:** Do not put tanks into service before the coating is properly cured. When cured but before taking tank into use for potable water, fill twice with water, each time for a period of not less than 24 hours, and finally flush with fresh water. Alternatively hose down with warm fresh water (max. 50°C/122°F). Such cleaning may be subject to local/individual specification or regulation.

#### Note:

**HEMPADUR MULTI-STRENGTH 3553 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.

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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