

HEMPEL'S POLYESTER GF 35920/ HEMPEL'S POLYESTER GF 35923

High temperatures: HARDENER 99020
Low to medium temperatures: HARDENER 99420

Description:	HEMPEL'S POLYESTER GF 3592 is a high solid, two-component heavy duty lining system based on isophthalic polyester acrylic copolymer reinforced with glass flakes. Applicable in thick coats by standard heavy duty airless spray equipment.		
Recommended use:	<div><div><div>1.</div><div>As rust preventing coating for areas exposed to high abrasion and impact.</div></div><div><div>2.</div><div>As rust preventing coating for areas requiring short interval between application and seawater immersion - 6 hours at 20°C/68°F is required.</div></div></div> <div>Indicative temperature range of application and curing: 35923/99420: between 0°C/32°F and 10°C/50°F. 35920/99020: above 10°C/50°F. Please see APPLICATION CONDITIONS overleaf.</div>		
Service temperatures:	Dry:	In water (temperature gradient across paint film, max 35°C/63°F):	
Maximum:	140°C/284°F	80°C/176°F	
Availability:	Subject to confirmation.		

PHYSICAL CONSTANTS:

Finish:	Flat
Colours/Shade nos:	Off-white/11630 - Yellow/20820
Volume solids:	90% (See REMARKS overleaf)
Theoretical spreading rate:	1.4 m²/litre - 650 micron 56 sq.ft./US gallon - 26 mils
Flash point:	26°C/79°F
Specific gravity:	1.2 kg/litre - 10.2 lbs/US gallon
Dry to touch:	4 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	35 g/litre- 0.3 lbs/US gallon
Shelf life:	6 months from time of production (25°C/77°F) Shelf life is dependent on storage temperature. Shelf life is reduced at storage temperatures above 25°C/77°F. Do not store above 40°C/104°F.

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

APPLICATION DETAILS:

	35920	35923
Mixing ratio:	Base 35929 : Hardener 99020 97.5 : 1.5 by volume	Base 35929 : Hardener 99420 97.5 : 2.5 by volume
Application method:	Airless spray Brush/roller (See separate Application instructions)	Airless spray Brush/roller (See separate Application instructions)
Thinner:	Do not dilute (See separate Application instructions)	Do not dilute (See separate Application instructions)
Pot life:	45 minutes (20°C/68°F) (See separate Application instructions)	45 minutes (20°C/68°F) (See separate Application instructions)
Nozzle orifice:	.030"-.060" (Reversible)	
Nozzle pressure:	min 275 bar/4000 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	Styrene and methyl ethyl ketone (See separate Application instructions)	
Indicated film thickness, dry:	650 micron/26 mils	
Indicated film thickness, wet:	725 micron/29 mils	
Recoating interval, min:	with itself: 2 hours (20°C/68°F); others: 16 hours (20°C/68°F)	
Recoating interval, max:	3 days (20°C/68°F)	

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SURFACE PREPARATION:	<p>New steel: Abrasive blasting to min. Sa 2½ according to ISO 8501-1: 1988, SSPC-SP-10. Minimum 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 by 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.</p> <p>Maintenance: On old exposed areas excessive amounts of soluble salt residues (in pittings) may call for jet cleaning or wet abrasive blasting followed by dry abrasive blasting. Alternatively dry abrasive blasting, high pressure fresh water hosing, drying and finally, dry abrasive blasting again.</p>
APPLICATION CONDITIONS:	<p>Use only when application and curing can proceed at temperatures above 0°C/32°F. Between 0°C/32°F to 10°C/50°F use HARDENER 99420, above 10°C/50°F use HARDENER 99020. The in-can temperature of the polyester material should be between 15°C/59°F and 25°C/77°F to facilitate proper application properties.</p> <p>Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max. 85%.</p>
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None, or solvent-based coatings as per specification.
REMARKS:	
Colours:	Colour 20820 is identical to RAL 1006.
Film thicknesses:	May be specified in another film thickness than indicated depending on purpose and area of use. Normal range dry is 650-750 micron/26-30 mils. Absolute minimum is 500 micron/20 mils. Maximum not more than 1250 micron/50 mils.
Volume solids:	Theoretically, the products contains 100% solid. By practical spray application, however, one of the reactive components added in surplus will be lost as volatile in an amount of 0.035 kg per litre. Furthermore, the curing process is accompanied by a contraction of approximately 6%. These two factors result in a volume solids of 90% and a spreading rate of 1.4 m²/l at 650 micron. By extremely unfavourable application conditions, higher losses may result in a "theoretical" spreading rate of approximately 1.2 m²/l at 650 micron. The curing is, however, not affected by the higher loss.
Note:	HEMPEL'S POLYESTER GF 3592 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.
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