



# Product Data

## HEMPADUR MULTI-STRENGTH GF 35870

BASE 35879 with CURING AGENT 98870

**Description:** HEMPADUR MULTI-STRENGTH GF 35870 is an amine-adduct cured epoxy coating - the product is reinforced with Glassflakes. It is a hard, impact and abrasion resistant coating with good resistance to sea water, mineral oils, aliphatic hydrocarbons and splashes from petrol and related products.

**Recommended use:** As a self-primed, high build coating primarily for areas subject to abrasion and/or to a highly corrosive environment. E.g. splash zones, jetty pilings and working decks. Can be used as interior lining for crude oil and fuel oil storage tanks.

**Service temperatures:** Dry exposure only: In water (no temperature gradient):  
Maximum: 140°C/284°F 60°C/140°F (See REMARKS overleaf)

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

### PHYSICAL CONSTANTS:

Colours/Shade nos: Black/19990  
Finish: Glossy  
Volume solids, %: 87 ± 1  
Theoretical spreading rate: 2.5 m<sup>2</sup>/litre - 350 microns  
100 sq.ft./US gallon - 14 mils  
Flash point: 35°C/95°F  
Specific gravity: 1.3 kg/litre  
10.8 lbs/US gallon  
Surface dry: 4 (approx.) hours at 20°C/68°F  
Dry to touch: 6 (approx.) hours at 20°C/68°F  
Fully cured: 7 days at 20°C/68°F  
V.O.C.: 180 g/litre - 1.5 lbs/US gallon

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.*

### APPLICATION DETAILS:

Mixing ratio for 35870: Base 35879 : Curing agent 98870  
3 : 1 by volume  
Application method: Airless spray  
Thinner (max.vol.): 08450 (5%)  
Pot life: 1 hour (20°C/68°F)  
Nozzle orifice: .023"-.027" (Reversible)  
Nozzle pressure: 250 bar/3600 psi  
(Airless spray data are indicative and subject to adjustment)  
Cleaning of tools: HEMPEL'S TOOL CLEANER 99610  
Indicated film thickness, dry: 350 micron/14 mils  
Indicated film thickness, wet: 400 micron/16 mils  
Recoat interval, min: See REMARKS overleaf  
Recoat interval, max: See REMARKS overleaf

**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. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



## HEMPADUR MULTI-STRENGTH GF 35870

**SURFACE PREPARATION:** **New steel (dry conditions):** Abrasive blasting to Sa 2½, (ISO 8501-1:2007) with a surface profile equivalent to Rugotest No. 3 BN 10, Keane-Tator Comparator 3.0 G/S or ISO Comparator, ROUGH MEDIUM (G).

Remove any oil, grease and other contaminants by detergent and salts by high fresh water hosing prior to abrasive blasting.

**Maintenance:** Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by wet or dry abrasive blasting or for minor areas power tool cleaning. Feather edges to sound and intact areas. After wet abrasive blasting hose down the surface by hot water rinsing ("steam cleaning"). Touch up bare spots to full film thickness when the surface has become visually dry.

**APPLICATION CONDITIONS:** HEMPADUR MULTI-STRENGTH GF 35870 may be applied and will cure at temperatures down to 5°C/41°F. The temperature of the paint itself should be above 15°C/59°F. The best result is obtained at 20-30°C/68-86°F. In confined spaces provide adequate ventilation.

**PRECEDING COAT:** None. If a blast primer is required use HEMPADUR 15590.

**SUBSEQUENT COAT:** None or according to specification.

**REMARKS:**  
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.  
Colour: Light shades will have a tendency to yellow when exposed to sunshine and darken when exposed to heat.  
Service temperatures: Maximum peak temperature in water is 80°C/176°F.

**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 350-500 micron/14-20 mils.

**Application equipment:** Standard airless heavy-duty spray equipment:  
Pump ratio: min 45:1 (see Note below)  
Pump output: min 12 litres/minute (theoretical)  
Spray hoses: max 15 metres/50 feet, 3/8" internal diameter  
max 3 metres/10 feet, 1/4" internal diameter

**Note:** If longer spray hoses are necessary, up to 50 metres/150 feet hose (½" internal diameter) can be added. The pump ratio must be raised to 60:1 or more, however, the high output capacity of the pump must be maintained. Bigger spray nozzles will also call for increased pump size. A **reversible nozzle** is recommended.

**Filter:** Surge tank filter and tip filter should be removed.

**Recoating:** Recoating intervals related to later conditions of exposure at 20°C/68°F : (350 micron/14 mils dry film thickness of HEMPADUR MULTI-STRENGTH GF 35870).

Recoated with	Minimum			Maximum		
	Atmospheric		Immersion	Atmospheric		
	Medium	Severe		Medium	Severe	Immersion
HEMPATHANE	4 hours	6 hours	NR	10 Days	3 Days	NR
HEMPADUR	6 hours	8 hours	16 hours	60 Days	30 Days	30 Days

If the maximum recoat interval is exceeded, roughening of the surface is necessary to ensure adhesion.

**Note:** **HEMPADUR MULTI-STRENGTH GF 35870 is for professional use only.**

**ISSUED BY:** HEMPEL A/S - 3587019990CR002

**This Product Data Sheet supersedes those previously issued.**

**For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.**

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