



Product Data

HEMPEL'S POLYESTER GF 35920

BASE 35929 with HARDENER 99020

Description: HEMPEL'S POLYESTER GF 35920 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:

1. As rust preventing coating for areas exposed to high abrasion and impact.
2. As rust preventing coating for areas requiring short interval between application and seawater immersion - 6 hours at 20°C/68°F is required.

Service temperatures: Dry exposure only: In water (maximum temperature gradient 35°C/63°F):
Maximum: 140°C/284°F 80°C/176°F

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

PHYSICAL CONSTANTS:

Finish: Flat
Colours/Shade nos: Off-white/11630 - Yellow/20820 (RAL 1006)
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 (25°C/77°F) from time of production.
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 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: Base 35929 : Hardener 99020
97.5 : 1.5 by volume
Application method: Airless spray Brush/roller (See separate Application instructions)
Thinner: Do not dilute (See separate Application instructions)
Pot life: 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)

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.



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SURFACE PREPARATION:	<p>New steel: Abrasive blasting to min. Sa 2½.</p> <p>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 water 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> <p>Galvanized, Zinc primed steel etc.: Metallic zinc inhibits the curing process - the product is not compatible with galvanized steel or other zinc coated substrates. Steel primed with zinc dust containing pre-fabrication primers must be re-blasted to min. Sa 2½-3 to remove all traces of zinc.</p>
APPLICATION CONDITIONS:	<p>Use only when application and curing can proceed at temperatures above 10°C/50°F. 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%. In confined spaces provide adequate ventilation during application and curing.</p>
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None, or solvent-based coatings as per specification.
REMARKS:	
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 approx 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 35920 is for professional use only.
ISSUED BY:	HEMPEL A/S - 3592011630

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.