



## HEMPEL'S POLYESTER GF 35920

35920 : BASE 35929 : CURING AGENT 99020

<b>Description:</b>	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.
<b>Recommended use:</b>	As rust preventing coating for areas exposed to high abrasion and impact. As rust preventing coating for areas requiring short interval between application and seawater immersion - 6 hours at 20°C/68°F is required.
<b>Service temperature:</b>	Maximum, dry exposure only: 140°C/284°F In water (maximum temperature gradient 35°C/63°F): 80°C/176°F Part of Group Assortment. Local availability subject to confirmation.
<b>Availability:</b>	

### PHYSICAL CONSTANTS:

Shade nos/Colours:	11630* / Off-white.
Finish:	Flat
Volume solids, %:	90 see REMARKS overleaf
Theoretical spreading rate:	1.4 m <sup>2</sup> /l [56.1 sq.ft./US gallon] to 650 micron/26 mils
Flash point:	26 °C [78.8 °F]
Specific gravity:	1.1 kg/litre [9.2 lbs/US gallon]
Dry to touch:	4 approx. hour(s) 20°C/68°F
Fully cured:	7 day(s) 20°C/68°F
VOC content:	446 g/l [3.7 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. <i>*other shades according to assortment list.</i>

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.*

### APPLICATION DETAILS:

<b>Version, mixed product:</b>	<b>35920</b>
Mixing ratio:	BASE 35929 : CURING AGENT 99020 98.5 : 1.5 by volume
Application method:	Airless spray / Brush/Roller According to separate APPLICATION INSTRUCTIONS
Thinner (max.vol.):	Do not dilute. According to separate APPLICATION INSTRUCTIONS
Pot life:	45 minute(s) 20°C/68°F According to separate APPLICATION INSTRUCTIONS
Nozzle orifice:	0.03 to 0.06 " Reversible
Nozzle pressure:	275 bar [3987.5 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	Styrene, methyl ethyl ketone. According to separate APPLICATION INSTRUCTIONS
Indicated film thickness, dry:	650 micron [26 mils]
Indicated film thickness, wet:	725 micron [29 mils]
Recoat interval, min:	According to separate APPLICATION INSTRUCTIONS
Recoat interval, max:	According to separate APPLICATION INSTRUCTIONS
<b>Safety:</b>	Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations.



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### SURFACE PREPARATION:

**New steel:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to near white metal Sa 2½ (ISO 8501-1:2007) with a surface profile corresponding to Rugotest No. 3, BN10a, Keane-Tator Comparator 3.0 G/S, or ISO Comparator Rough Medium (G). After blasting, clean the surface carefully from abrasives and dust.

**Repair and maintenance:** Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosting, drying, and finally dry abrasive blasting again.

**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.

### APPLICATION CONDITIONS:

Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 10°C/50°F. Maximum relative humidity: 85%. In-can temperature of the paint should preferably be below 25°C/77°F and above 15°C/59°F. In confined spaces provide adequate ventilation during application and drying. See separate APPLICATION INSTRUCTIONS

### PRECEDING COAT

None.

### SUBSEQUENT COAT:

None, or as per specification. Recommended systems are: Solvent borne coating

### REMARKS:

### Film thicknesses/thinning:

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: 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. Depending on the application and curing conditions some of the volatile reactants may evaporate. Furthermore, the curing process is accompanied by a contraction.

These two factors result in a "theoretical" volume solids of 90% and a spreading rate of 1.4 m<sup>2</sup>/l at 650 micron (56 sq.ft./US gallon).

By unfavourable application conditions, higher losses may result in a practical spreading rate of approximately 1.2 m<sup>2</sup>/l at 650 micron (49 sq.ft./US gallon). The curing is, however, not affected by a higher loss.

### Note:

**HEMPEL'S POLYESTER GF 35920 For professional use only.**

### ISSUED BY:

HEMPEL A/S

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This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on [www.hempel.com](http://www.hempel.com). 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.

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