Hempel's Epoxy Filler 35250

Product characteristics

Description
Hempel's Epoxy Filler 35250 is a solvent-free, epoxy filler, which when fully cured - is resistant to water, aliphatic hydrocarbons, and related products. Can be applied in thick coats up to approximately 5 mm without runs or sags.

Recommended use
Hempel's Epoxy Filler 35250 is recommended as a filler for metals, hardwood, and other rigid materials.
Also recommended for filling of pinholes in welding seems and similar irregularities in steel work not later exposed to strong chemicals.

Service temperature:
- Maximum, dry exposure only: 140°C [284°F].
- Maximum, in water (no temperature gradient): 35°C [95°F].

Product safety

Flash point 130°C [266°F]

VOC content mixed product

Legislation	Value
EU	26 g/L [0.22 lb/US gal]
US (coatings)	26 g/L [0.22 lb/US gal]
US (regulatory)	26 g/L [0.22 lb/US gal]
China	26 g/L [0.22 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website.

Handling
Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code
35250

Product components
Base 35259
Curing Agent 95250

Standard shade / code
Light grey 19810 *

Gloss
Semi-gloss

Volume solids
99 ± 2%

Specific gravity
1.6 kg/L [13 lb/US gal]

Reference dry film thickness
1000 micron [40 mils]

* Slight discolouration may occur. This does not affect the performance of the coating.

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Surface preparation

Cleanliness
- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

New build:
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Clean thoroughly by hand or power tool to St 3 (ISO 8501-1) / SP 3 (SSPC). Avoid polishing.
- Remove dust, blast media and loose materials.

Maintenance and Repair
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Clean thoroughly by hand or power tool to St 3 (ISO 8501-1) / SP 3 (SSPC). Avoid polishing.
- Remove dust, blast media and loose materials.

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratio
Base 35259 : Curing Agent 95250
(1 : 1 by volume)

In general, thinning is not recommended. Stir well before use.

Cleaner
Hempel's Tool Cleaner 99610

Pot life

Product temperature	20°C [68°F]
Pot life	60 min

Application method

Tool	Application parameters
Putty knife	Not Applicable.

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	500 micron [20 mils]	5000 micron [200 mils]	1000 micron [40 mils]
Wet film thickness	507 micron [20 mils]	5069 micron [203 mils]	1014 micron [41 mils]
Theoretical spreading rate	2 m²/L [81 sq ft/US gal]	0.2 m²/L [8 sq ft/US gal]	1 m²/L [41 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

Application conditions
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above 5°C [41°F] during application and curing.

Drying and overcoating

Product compatibility
- Previous coat: None or according to Hempel's specification. Recommended products are: Hempadur
- Subsequent coat: According to Hempel's Specification. Recommended products are: Hempalin, Hempadur, Hempatex

Drying time

Surface temperature		20°C [68°F]
Surface dry	hours	8
Fully cured	days	5

Determined for dry film thickness 1000 micron [40 mils] at standard conditions, see Hempel's Explanatory Notes for details.

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Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		20°C [68°F]
	Atmospheric medium	
Hempel's Epoxy Filler 35250	Min	8 h
	Max	24 h

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	24 months
Curing Agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	6.6 g CO_2e/m^2	0.034 lb CO_2e/ft^2

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

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Additional documents

Additional information is available at the Hempel website https://www.hempel.com/service-and-support/technical-guidelines or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- General Application Guidelines

This Product Data Sheet ("**PDS**") relates to the supplied product ("**Product**") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "**Additional documents**"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.