

35740: BASE 35749 with CURING AGENT 98040

For product description refer to product data sheet 35740

- Scope:** These Application Instructions cover surface preparation, application equipment and application details for HEMPADUR EM 35740 when used on previously coated steel.
- Surface preparation:** **Small areas, less than approx. one square meter:**
Remove oil and grease with suitable detergent or solvent from the area to be repaired including areas of intact coating to be overcoated. Remove salt and other contaminants by plenty of fresh water or preferably by (high pressure) fresh water cleaning.
Remove corrosion products by suitable means such as chipping, wire brushing, or disc sanding depending on the condition of the surface.
Pitted steel should be grinded or burred with high speed burrs. Burrs to be removed and sharp edges to be rounded.
The final degree of cleaning must be St 3 and the surface preparation must have left the surface with a distinct anchor pattern.
Adjacent areas with intact coating should be roughened and feathered to achieve adhesion.
Remove all dust and debris from the prepared area.
- Larger areas or where several small repair areas are collected:**
For larger areas the removal of all defect coating and corrosion products may be carried out by water jetting. Corrosion products in way of black iron oxide may require additional grinding or abrasive blast cleaning.
The degree of cleaning after water jetting shall be minimum Wa 2½ (ISO 8501-4:2006). Adjacent areas of intact coating must appear with a roughened surface after the water jetting.
Burrs to be removed and sharp edges to be rounded.
- Be aware, that HEMPADUR EM 35740 can be applied on damp surfaces, which mean that it will not be necessary to wait for the surface to dry, before the paint application can take place, only wiping with clean cloth to remove excess moisture is needed.
- Application conditions:** For achieving the best result HEMPADUR EM 35740 is to be used only where application and curing can proceed at steel temperatures above 10°C/50°F.
- The paint can be applied on a properly prepared dry, damp or moist surface, even at a steel temperature below the dew point.
The following definitions of a damp, moist and wet surface prevail:
- Damp surfaces:** Water is not readily detectable, but the temperature of the surface is below the dew point.
Moist surfaces: pools of water and droplets have been removed, but there is a noticeable film of water.
Wet surfaces: Droplets or pools of water are present.
- Application procedure:** The first coat of must be applied immediately after surface preparation to avoid rerusting.
- No solvent must be added to the base, curing agent or to the mixed product.
- To benefit from the product's moist surface wettability, it must only be applied by brush. Roller application will neither provide the water displacing effect, nor the specified dry film thickness per coat. Use intensive brushing and stippling in order to work the coating into the surface and displace any film of water. Avoid smoothing the applied paint excessively as this may reduce the film thickness
- The minimum total dry film thickness should be 300µm/12 mil. This is best achieved by a simple step application process (wet on wet) which is particularly advantageous when more areas are repaired:
- 1) Apply and complete the first coat in one area
 - 2) Leave the applied paint for approximately ½ hour for an initial curing
 - 3) During this period other areas can now be prepared or paint applied
 - 4) Return to the first applied area and make a second application. The first coat will still be wet or tacky, which allows to apply the second coat in a thick, coherent film to achieve the specified dry film thickness.
- A wet film thickness gauge is recommended for control of the correct applied wet film thickness.

35740: BASE 35749 with CURING AGENT 98040

- Subsequent coat:** Normally not relevant in water ballast tanks, but can be over coated with HEMPADUR and HEMPATANE qualities according to specification.
- Remarks:** Mix and stir the two components thoroughly until an even colour is achieved, where after the paint is ready for use.
- The pot life of the mixed paint is approx. 1 hour at 20 °C/68 °F and is approx. 30 minutes at 30°C/86°F. The product should not be used after the pot life has expired.
- Exposure to sea water:** The applied coating resists exposure to sea water after approximately 8 hours at 20°C/68°F.
- Note:** HEMPADUR EM 35740 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. 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.
- Issued by:** HEMPEL A/S - 35740

These Application Instructions supersede those previously issued.

For explanations, definitions and scope see "Explanatory Notes" available on 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. 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. Product data are subject to change without notice and become void five years from the date of issue.