

### 35760: BASE 35769 with CURING AGENT 98760

For product description refer to product data sheet 35760

**Scope:** These Application Instructions cover surface preparation, application equipment and application details for HEMPADUR 35760.  
When used in conjunction with fibre glass please consult Application Instructions for Fibre matts for guidelines and recommendations.

**Before any job in a tank initiates, it is important that the tank is certified to be “gas free”.**

**Surface preparation:** **New steel:**  
Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½-3, ISO 8501-1:1988 and a roughness profile corresponding to Rugotest No. 3, BN 10a (Ra=12.5 micron), ISO Comparator Medium (G), Keane-Tator Comperator 3.0 G/S. After blasting, clean the surface carefully from abrasives and dust.

**Pit-corroded surfaces (tank bottoms):**

Remove oil and grease with suitable detergent.  
Blasting to Sa 2, ISO 8501-1: 1988. Pittings on tank bottoms are often omega-shaped (typically in the case of chloride-induced corrosion) for which reason the following procedure is recommended:

After rough cleaning for dust and abrasives, the tank surfaces are to be thoroughly high pressure fresh water hosed. Let the water remain in the tank so that all pit corroded areas are covered by approx 5 cm/2" of water.

After 24 hours the water is removed by wet vacuum cleaning and the tank is dried.  
If needed, i.e. if there is still salt contamination to be found in the pits, the washing treatment has to be repeated. After cleaning, the surfaces are blasted to Sa 2½-3, ISO 8501-1: 1988, with a surface roughness profile corresponding to Rugotest No. 3, BN 10a. After blasting clean the surface carefully for abrasives and dust. Special care must be taken when cleaning the tank bottom.

Other degrees of cleaning including wet methods like ultra-high-pressure-water-jetting (UHPWJ) and blasting with mixtures of grit and water may be relevant according to Hempel-specification.

**Application equipment:** HEMPADUR 35760, being a solvent free, high viscosity material, requires special measures to be taken at application.

**Recommended airless spray equipment:**

Pump ratio:	Min. 45:1 (See Note below)
Pump output:	12 litres/minute (theoretical)
Input pressure:	Min. 6 bar/90 psi
Spray hoses:	Max. 15 metres/50 feet, 3/8" internal diameter Max. 3 metres/10 feet, 1/4" internal diameter
Regular surfaces:	
Nozzle size:	0,019"-0,031"
Fan angle:	40°-60°
Complicated surfaces and application in low dry film thickness (250-400 micron):	
Nozzle size:	0,019"-0,023"
Fan angle:	40°

**Note:** Avoid the use of a suction hose. Use an interchangeable pipe, which makes it possible to remove cured paint. If longer spray hoses are necessary the pump ratio must be raised to 60:1 or more, yet the high output capacity of the pump must be maintained.

Airless spray data are indicative and subject to adjustment.

**Mixing:** Stir the CURING AGENT 98760 well before mixing with BASE 35769. Continue the mixing until a complete uniform colour is achieved.

**Paint temperature:**

In order to obtain the best application properties, the temperature of the paint must when mixed be 20-25°C/68-77°F. If the temperature of the paint exceeds 25°C/77°F it should be stored in cooled places (see pot life below).

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**Pit-corroded surfaces:**

In case of extensive pit corrosion (old tank bottoms) it is advisable to apply the first coat by brush. The coating must be worked well into all pits facilitating a good wetting of the steel and closing the porosities. The following coat(s) can be applied by brush as well as by airless spray (as per above) securing full covering of the uneven/rough surface.

**Pot life:**

When measured under standard conditions the pot life is 40 minutes at 20°C/68°F.

- Irrespective of equipment, use the paint immediately after mixing. At a normal application speed the 20 litres/5 US gallons are used in approx. 10 minutes.
- Keep an eye on the paint temperature frequently for instance by touching the can with your hand. If it feels more than hand warm, discard the paint and flush the equipment immediately irrespective of type of spray equipment.

**Stripe coating:**

Edges, corners, uneven (manual) welds, and places difficult to cover properly by spray application should be stripe coated (touched up) either before or after the spray application. One or two stripe coats will usually be necessary, but depending on actual conditions.

**Extra film thickness:**

Extra thickness - extra coat(s) - may be necessary in case of severely pitted and/or where very high degrees of antiabrasive properties are needed.

**Recoating interval:**

Within a maximum of 80% Relative Humidity the following recoating intervals apply:

Steel temperature	10°C/50°F	15°C/59°F	20°C/68°F	25°C/77°F	30°C/86°F	40°C/104°F
HEMPADUR 35760						
Min	40 hours	27 hours	16 hours	11 hours	8 hours	5 hours
Max	60 days	45 days	30 days	23 days	15 days	7 days

HEMPADUR 35760 should not be exposed to sunshine, water/condensation or any contamination before recoating. If necessary the surface is cleaned by vacuuming before recoating.

**Curing table:**

The following curing times apply:

Steel temperature (°C/°F)	10/50	15/59	20/68	25/77	30/86	35/95	40/104
Fully cured	12 days	8 days	5 days	4 days	3 days	2½ days	2 days

**Note:** The above given temperatures are mean temperatures. Curing temperatures, however, should never be lower than 10°C/50°F.

**Filling of tanks:**

Tanks should generally not be taken into use before HEMPADUR 35760 is fully cured (see above).

**Ventilation during application:**

Ventilation is not required for drying/curing of the coating, but some ventilation is recommended in order to remove e.g. spray-dust from application.

**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 - 35760

These Application Instructions supersede 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. 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.