



HEMPEL'S EPOXY FILLER 35251

35251: BASE 35259: CURING AGENT 95250

Description:	HEMPADUR FILLER 35251 is a two-component, solvent-free, epoxy filler, which when fully cured - is resistant to water, aliphatic hydrocarbons, and related products.
Recommended use:	<ol style="list-style-type: none">1. As a filler for metals, hardwood, ferro-cement, glass fibre and other rigid materials. On large surfaces especially suited for smooth filling.2. For filling of minor pinholes in weldings, cavities in ship propellers, keels and similar.3. Repair of osmosis damage in glass fibre reinforced polyester hulls.
Availability:	Part of European Yacht assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	19810 / Light grey
Finish:	Semi-gloss
Volume solids, %:	100
Flash point:	70 °C [158 °F]
Specific gravity:	1.6 kg/litre [13.3 lbs/US gallon]
Dry to touch:	8 approx. hour(s) 20°C/68°F / 18 approx. hour (s) 10°C/50°F
	Dry to sand after: 16 approx. hour(s) 20°C/68°F / 36 approx. hour(s) 10°C/50°F
Fully cured:	5 day(s) (approx.) 20°C/68°F 12 days (approx.) 10°C/50°F
VOC content:	10 g/l [0.1 lbs/US gallon] <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
APPLICATION DETAILS:	
Version, mixed product:	35251
Mixing ratio:	BASE 35259: CURING AGENT 95250 1 : 1 by volume
Application method:	Putty knife, or similar.
Thinner (max.vol.):	Do not dilute.
Pot life:	1 hour(s) at 20°C/68°F 2 hour(s) at 10°C/50°F
Cleaning of tools:	HEMPEL'S DEGREASER 99611 or HEMPEL'S THINNER 08451
Safety:	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:

Fibre glass: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Allow the surface to dry.
Metal: Remove oil and grease, etc. with suitable detergent (HEMPEL'S PRE-CLEAN 67602). Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting, power tool cleaning or sanding, depending on material and condition of the surface. Pitted steel should be blast cleaned and/or ground with high speed burrs. Round off sharp edges. Finally clean the area with HEMPEL'S THINNER 08451. Priming after abrasive blast cleaning can be done with a thin layer of eg HEMPEL'S LIGHT PRIMER 45551.

Ferro-cement: Please see data sheet for: HEMPEL'S SEALER 05991

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: 5°C/41°F. The temperature of the surface must also be above these limits.

SUBSEQUENT COAT:

According to specification. Recommended systems are: HEMPEL'S LIGHT PRIMER 45551. High-gloss finishes should not be applied directly on top.

REMARKS:

Application(s)

Mix and stir the two components thoroughly until an even light grey colour is achieved, where after the filler is ready for use.

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

May be sanded after 16 hours (20°C/68°F). Do not mix more than is necessary for use within the pot life.

Final smoothing shall take place while it is still possible to make finger prints in the filler and it is still tacky.

Recoating intervals: for HEMPEL'S LIGHT PRIMER 45551 max. 30 days at 20°C/68°F - 60 days at 10°C/50°F.

Note:

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The information given in the Product Data Sheet is intended for commercial use.

ISSUED BY:

HEMPEL A/S

3525119810

This Product Data Sheet supersedes 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.

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