

Product Data

HEMPEL'S COAL TAR EPOXY MASTIC 35670

35670: BASE 35679: CURING AGENT 98670

Description:	HEMPEL'S COAL TAR EPOXY MASTIC 35670 is a high solids, high-build polyamide cured coal tar epoxy coating with excellent resistance to sea water, crude oil, various soil chemicals and soil stress.				
Recommended use:	As a long-life protective coating on steel and concrete in severe corrosive environment, e.g., on submerged surfaces, crude oil and slop tanks, ballast tanks, splash zones, sewage systems, etc. Excellent resistance to chemical attack encountered on both steel and concrete including buried pipes.				
Service temperature:	Maximum, dry exposure only: 90°C/194°F In water (no temperature gradient): 40°C/105°F Other liquids: Contact HEMPEL				
Certificates/Approvals:	The product complies with ARAMCO Engineering Standard APCS-3. see REMARKS overleaf				
Availability:	Not included in Group Assortment. Availability subject to special agreement.				
PHYSICAL CONSTANTS:					
Shade nos/Colours:	19990*/ Black.				
Finish:	Semi-gloss				
Volume solids, %:	92 ± 1				
Theoretical spreading rate:	4.6 m²/l [184.5 sq.ft./US gallon] - 200 micron/8 mils				
Flash point:	23 °C [73.4 °F]				
Specific gravity:	1.5 kg/litre [12.2 lbs/US gallon]				
Dry to touch:	8 - 10 approx. hour(s) 20°C/68°F				
Fully cured:	7 day(s) , 20°C/68°F				

APPLICATION DETAILS:

VOC content:

Version, mixed product: Mixing ratio:

Application method: Thinner (max.vol.): Pot life: Nozzle orifice: Nozzle pressure:

Cleaning of tools: Indicated film thickness, dry: Indicated film thickness, wet: Overcoat interval, min: Overcoat interval, max:

Safety:

35670

127 g/l [1.1 lbs/US gallon]

*other shades according to assortment list.

BASE 35679: CURING AGENT 98670 4:1 by volume Airless spray / Brush/Roller 08450 (5%) / 08450 (15%) 8 approx. hour(s) 20°C/68°F 0.021 - 0.023 " 250 bar [3625 psi] (Airless spray data are indicative and subject to adjustment) HEMPEL'S TOOL CLEANER 99610 200 - 300 micron [8 - 12 mils] 225 - 325 micron [9 - 13 mils] see REMARKS overleaf see REMARKS overleaf Handle with care. Before and during use, observe all safety labels on packagir

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

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 (ISC 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). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating. Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning (minor areas) or by abrasive blasting. Feather edges to sound and intact areas Dust off residues. Touch up to full film thickness. Concrete: Remove slip agent and other possible contaminants by emulsion washing followed by high pressure hosing with fresh water. Remove scum layer and loose matter to a hard, rough and uniform surface, preferably by abrasive blasting, possibly by other mechanical treatment or acid etching. Seal surface with suitable sealer, as per relevant painting specification. 								
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. The temperature of the surface and that of the paint itself must also be above this limit. The optimal paint temperature for proper mixing, pumping and spraying is 20-25°C/68-77°F. In confined spaces provide adequate ventilation during application and drying.								
PRECEDING COAT:	Concrete: HEMPADUR SEALER 05990. Steel: None, or as per specification.								
SUBSEQUENT COAT: REMARKS:	None, or as per specification. see REMARKS overleaf								
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 overcoating interval. Normal range dry is: 200-350 micron/8-14 mils								
Overcoating:	Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.								
	A specification supersedes any guideline overcoat intervals indicated in the table.								
	Environment	Atmospheric, medium							
	Surface temperature:	10°C (50°F) 20			C (68°F) 30°C (86°F)				
		Min	Max	Min	Max	Min	Max		
	HEMPADUR	60 h	17½ d	24 h	7 d	12 h	3½ d		
	Environment	Immersion							
	HEMPADUR	60 h	17½ d	24 h	7 d	12 h	3½ d		
Overcoating intervals:	For overcoating, HEMPATEX hours at a surface temperature	HI-BUILD 4 e of 20°C/6	NR = Not Rec 6330 can be 8°F.	ommended, Ext. e used. It is t	= Extended, m = to be applied	minute(s), h = hc I within maxi	our(s), d = day(s) imum 16		
Note:	HEMPEL'S COAL TAR EPOXY MASTIC 35670 Bleeding may occur into subsequent coat. This effect is cosmetic only and has no influence on the protective properties. For professional use only.								
ISSUED BY:	HEMPEL A/S 3567019990								

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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