

## HEMPEL EPOXY FILLER

MIXED PRODUCT 35250

BASE 35259

CURING AGENT 95250

**Description:** HEMPEL EPOXY FILLER is a two component, solvent free epoxy filler which, when fully cured, is resistant to water, aliphatic hydrocarbons and related products.

**Recommended use:**

1. As a filler for metals, hardwood, ferrocement, glass fibre and other rigid materials. On large surfaces especially suited for smooth filling.
2. For filling of minor pinholes in weldings, cavities in propellers, keels and similar.
3. Repair of osmosis damage in glass fibre reinforced polyester hulls.

**Availability:** Subject to confirmation.

### PHYSICAL CONSTANTS:

Colours/Shade nos: Light grey/19810  
Finish: Semigloss  
Solids content: 100%  
Flash point: 92°C/198°F  
Specific gravity: 1.6 kg/litre - 13.4 lbs/US gallon  
Dry to touch: 8 (app) hours at 20°C/68°F  
18 (app) hours at 10°C/50°F  
Dry to sand: 16 (app) hours at 20°C/68°F  
36 (app) hours at 10°C/50°F  
Fully cured: 5 days at 20°C/68°F - 12 days at 10°C/50°F

*The physical constants stated are nominal data according to the BLAKES Group's approved formulas. They are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes" in the BLAKES PAINT MANUAL. The theoretical spreading rate has been calculated on the basis of a 100% solids volume.*

### APPLICATION DETAILS:

Mixing ratio for 35250: 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 (20°C/68°F) - 2 hours (10°C/50°F)  
Cleaning of tools: BLAKES DEGREASER or BLAKES THINNERS No 5  
Recoat interval, min: 8 hours (20°C/68°F)  
18 hours (10°C/50°F)  
Recoat interval, max: 24 hours (20°C/68°F) (See REMARKS overleaf)  
54 hours (10°C/50°F) (See REMARKS overleaf)

**Safety:** Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BLAKES PAINTS 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.

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## 2. HEMPEL EPOXY FILLER

SURFACE PREPARATION:	<b>Metal:</b> Remove oil and grease, etc. with BLAKES SURFACE CLEANER. 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 BLAKES THINNER No 5. Priming can be done with a thin layer of eg BLAKES EPOXY PRIMER UNDERCOAT.
APPLICATION CONDITIONS:	Use only where application and curing can proceed at temperatures above 5°C/41°F. The temperature of the substrate should also be above this limit. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation.
SUBSEQUENT COAT:	Can be overcoated with BLAKES EPOXY PRIMER UNDERCOAT or according to specification. High-gloss finishes such as BLAKES POLYGLOSS should not be applied directly on top of HEMPEL EPOXY FILLER.
REMARKS:	Mix and stir the two components (base light red, curing agent green) thoroughly until an even light grey colour is achieved where-after the filler is ready for use. 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. If the maximum recoat interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. When recoating with BLAKES EPOXY PRIMER UNDERCOAT, maximum recoating intervals are 30 days at 20°C/68°F - 60 days at 10°C/50°F.
NOTE:	<b>The information given in the Product Data Sheet is intended for professional use.</b>
ISSUED:	June 2004 - 3525019810CO006 BLAKES PAINTS

***This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets.***

***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 BLAKES PAINTS 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.***