

35251: BASE 35259: CURING AGENT 95250

Description: HEMPEL'S EPOXY FILLER 35251 is a two-component, solvent-free, epoxy filler. Especially suited for the repair of cracks, fissures and small imperfections.

Recommended use: Suitable on glass fibre, hardwood, steel and other rigid materials. For interior and exterior use above and below the waterline.

Features:

1. On 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 hulls.

Availability: Part of European Yacht assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours: 19810 / Light grey
Finish: Flat
Volume solids, %: 100
Theoretical spreading rate: 1 m²/l [40.1 sq.ft./US gallon] - 1 mm /40 mils
Flash point: 70 °C [158 °F]
Specific gravity: 1.6 kg/litre [13.2 lbs/US gallon]
Dry to touch: 8 hour(s) 20°C/68°F
18 hour(s) 10°C/50°F
Dry to sand: 16 hour(s) 20°C/68°F
36 hour(s) 10°C/50°F
Fully cured: 5 day(s) 20°C/68°F
12 days 10°C/50°F
VOC content: 10 g/l [0.1 lbs/US gallon]
Shelf life: 3 years 25°C/77°F

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

APPLICATION DETAILS:

Version, mixed product: **35251**
Mixing ratio: BASE 35259: CURING AGENT 95250
1 : 1 by volume. Immediately before use, mix equal parts of each of the two components until a uniform colour is obtained. Avoid air bubbles in the mixture.
Application method: Spatula
Thinner (max.vol.): **Do not dilute.**
Pot life: 1 hour 20°C/68°F
2 hour(s) 10°C/50°F
Cleaning of tools: HEMPEL'S DEGREASER 99611 or HEMPEL'S THINNER 845 (No 5) 08451
Overcoat interval, min: 8 hour(s) 20°C/68°F
18 hour(s) 10°C/50°F
Overcoat interval, max: 24 hour(s) 20°C/68°F
54 hour(s) 10°C/50°F

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.

Product Data

HEMPEL'S EPOXY FILLER 35251



SURFACE PREPARATION:	Preparation: Always ensure all surfaces are clean, oil free and dry. Clean the surface and remove possible oil and grease with a suitable detergent and sand with dry abrasive paper. Uncoated surface: Sand and remove all dust. Prime with 1-2 coats of specified HEMPEL'S PRIMER. Previously coated surface: Abrade, clean and dry the surface.
PRODUCT APPLICATION:	Method: The product can be applied up to a thickness of 5 mm onto defect, fair, spot prime repaired area when dry before overcoating with 2 coats of specified HEMPEL'S PRIMER. Use a single component primer if overcoating with a single pack topcoat. Fair the product whilst it is still possible to make finger prints in the filler and it is still tacky. Topcoat finishes should not be applied directly on top of the product.
APPLICATION CONDITIONS :	The surface must be completely clean and dry at the time of application and its temperature must be above the dew point to avoid condensation. The moisture content in the wood should not exceed: 16%. Do not apply in direct sunlight. In confined spaces provide adequate ventilation during application and drying.
RECOMMENDED DETERGENT :	HEMPEL'S PRE-CLEAN 67602
PRECEDING COAT:	HEMPEL'S LIGHT PRIMER 45551 or HEMPEL'S PRIMER UNDERCOAT 13201
SUBSEQUENT COAT:	HEMPEL'S LIGHT PRIMER 45551 or HEMPEL'S PRIMER UNDERCOAT 13201
REMARKS:	Overcoating intervals: HEMPEL'S LIGHT PRIMER 45551 Min 4 hours 20°C/68°F and 8 hours 10°C/50°F Max 30 days 20°C/68°F and 60 days 10°C/50°F HEMPEL'S PRIMER UNDERCOAT 13201: Min 4 hours 20°C/68°F and 6 hours 10°C/50°F Max 3 days 20°C/68°F and 6 days 10°C/50°F
Stirring:	Stir product well before use.
Storage Conditions:	Exposure to air and temperature variances should be avoided. Avoid direct sunlight. Keep containers tightly sealed. Store at temperatures: 5°C/41°F - 35°C/95°F.
Curing agent:	Sensitive to moisture. Even small traces of water in the mixed paint will reduce the pot life and result in film defects. Open curing agent cans with caution as overpressure might exist. Do not fix lid on cans containing mixed product. Store in a cool place.
Overcoating:	If the maximum overcoating interval is exceeded, clean with fresh water and allow to dry. Light abrade and remove all dust prior to repainting. If surface has been contaminated by oils and pollutants, thoroughly remove with suitable detergent, rinse with fresh water and allow to dry. Light abrade and remove all dust prior to repainting.
Note:	HEMPEL'S EPOXY FILLER 35251
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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