



Product Data

HEMPEL'S EPOXY 35480

BASE 35489 with CURING AGENT 95680

- Description:** HEMPEL'S EPOXY 35480 is a two-component, modified, high-solids epoxy specially formulated as a lining in hopper cars. It forms a tough, abrasion-resistant coating with exceptional flexibility and chemical resistance.
- Recommended use:** As a lining system for dry bulk service up to 120°C/248°F.
- Service temperature:** Maximum, dry: 120°C/248°F
- Note:** Higher service temperatures will gradually reduce the mechanical strength of the paint. A combined mechanical/thermal exposure may cause mechanical damage.
- Approvals, certificates:** Complies with Section 175.300 of U.S. Federal Regulations in respect to carriage of dry foodstuffs.
- Availability:** For sale in North America only.

PHYSICAL CONSTANTS:

Color/Shade No.:	Off white/01950, Blue/A3030
Finish:	Semi-gloss
Volume solids, %:	63 ± 1
Theoretical spreading rate:	4.2 m ² /liter - 150 microns 171 sq. ft/US gallon - 6 mils
Flash point:	16°C/60°F
Specific gravity:	1.2 kg/liter - 10.3 lbs./US gallon
Surface dry:	4 (approx.) hours at 20°C/68°F
Dry to touch:	6 hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	318 g/litre - 2.6 lbs/US gallon (US EPA Method 24) 353 g/litre - 2.9 lbs/US gallon

The physical constants are subject to normal manufacturing tolerances. Further reference is made to "Explanatory Notes" in The HEMPEL Book.

APPLICATION DETAILS:

Mixing ratio for 35480:	Base 35489 : Curing agent 95680 1 : 1 by volume
Application method:	Airless spray Brush (touch-up) Plural component spray (see Remarks overleaf)
Thinner (max. vol.):	08450 (15% max) 08450 (10% max) 08450 (7.5% max)
Pot life:	6 hours (20°C/68°F)
Nozzle orifice:	.017"-.019"
Nozzle pressure:	200 bar/2900 psi (Airless spray data and amount of thinning are indicative and subject to adjustment depending on ambient conditions and equipment set-up)
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	150 microns/6 mils
Indicated film thickness, wet:	250 microns/10 mils
Overcoating interval, min:	8 hours (20°C/68°F)
Overcoating interval, max:	7 days (20°C/68°F)

- 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.



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SURFACE PREPARATION:	Remove oil, grease, etc. with suitable detergent. Remove salt and other contaminants by high-pressure fresh water cleaning. Abrasive blasting to Sa 2 1/2, SSPC-SP-10. Minimum surface profile according to Keane Tator Comparator 2.0 G/S.
APPLICATION CONDITIONS:	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. Apply only on a clean and dry surface with a temperature above the dew point to avoid condensation. In confined spaces, provide adequate ventilation during application and drying.
PRECEDING COAT:	None.
SUBSEQUENT COAT:	None.
REMARKS:	
Plural component:	For application using plural component equipment, the base (35489) and curing agent (95680) can be heated to 120°F maximum. Line heaters should be set at 120°F maximum as well. Heating to higher temperature will have a negative effect on the overall application and performance properties.
Thinning:	At higher degree of thinning it should be kept in mind that adding thinner increases the quantity of liquid paint without contributing to the solids content. Consequently, a proportionally higher wet film thickness must be applied when adding any significant amount of thinner in order to obtain the specified dry film thickness.
Film thicknesses:	May be specified in other film thicknesses than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating interval. Normal range dry is 100-150 microns/4-6 mils.
Overcoating:	The best time for overcoating is when the paint film is slightly tacky. If the maximum overcoating interval is exceeded, roughening of the surface is necessary to insure intercoat adhesion.
Chalking:	A tendency to chalk in outdoor exposure does not detract from the protective properties.
NOTE:	HEMPEL'S EPOXY 35480 is for professional use only.
ISSUED BY:	HEMPEL (USA), Inc. - 3548001950US004

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

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Product data are subject to change without notice and become void five years from the date of issue.