

# Hempel's Epoxy Filler 35253

## Product characteristics

### Description

Hempel's Epoxy Filler 35253 is a solvent-free, epoxy filler. Especially suited for the repair of cracks, fissures and small imperfections.

### Recommended use

Hempel's Epoxy Filler 35253 is suitable on glass fibre, hardwood, steel and other rigid materials. For interior and exterior use above and below the waterline.

### Features

- On surfaces especially suited for smooth filling. For filling of minor pinholes in weldings, cavities in propellers, keels and similar. Repair of osmosis damage in glass fibre hulls.

## Product safety

**Flash point** 130°C [266°F]

### VOC content mixed product

Legislation	Value
EU	26 g/L [0.22 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://hempel.com) or at your local Hempel website.

### Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

## Product data

### Product code

35253

### Product components

Base 35259  
Curing Agent 95250

### Standard shade / code

Light grey 19810

### Volume solids

99 ± 2%

### Specific gravity

1.6 kg/L [13 lb/US gal]

### Reference dry film thickness

1000 micron [40 mils]

## Surface preparation

### Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.

### New build:

- Uncoated surface: Sand and remove all dust.
- Prime with 1-2 coats of specified Hempel's Primer.

### Maintenance and Repair

- Previously coated surface: Abrade, clean and dry the surface.

### Roughness

- Sand to smoothen filler.

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## Application

### 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.

### Cleaner

Hempel's Thinner 845 08451  
Hempel's Degreaser 99611

### Pot life

Product temperature	10°C [50°F]
Pot life	2 hours

### Application method

Tool	Application parameters
Putty knife	Not Applicable.

Do not use thinner in conjunction with this product.

### Film thickness

	Recommended
Dry film thickness	1000 micron [40 mils]
Wet film thickness	1014 micron [41 mils]
Theoretical spreading rate	1 m <sup>2</sup> /L [41 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval.

### Application conditions

- Surface temperature must be above 10°C [50°F] during application and curing.

### Relative Humidity:

- Relative humidity must be below 85% during drying and curing.

### Application remarks

- The product can be applied in a thickness up to 5 mm.
- Fair the product whilst it is still possible to make finger prints in the filler.
- Overcoat when dry with 2 coats of recommended Hempel's Primer.
- Use a single component primer if overcoating with a single pack topcoat.
- Topcoat finishes should not be applied directly on top of the product.

## Drying and overcoating

### Product compatibility

- Previous coat: Recommended product is: Hempel's Light Primer
- Subsequent coat: Recommended products are: Hempel's Light Primer or Hempel's Primer Undercoat

### Drying time

Surface temperature	10°C [50°F]	20°C [68°F]
Touch dry	hours	18
Ready to sand	hours	-
Fully cured	days	12

Determined for dry film thickness 1000 micron [40 mils] at standard conditions, see Hempel's Explanatory Notes for details.

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## Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		10°C [50°F]	20°C [68°F]
Atmospheric medium			
Hempel's Epoxy Filler 35253	Min	18 h	8 h
	Max	54 h	24 h
Immersion			
Hempel's Epoxy Filler 35253	Min	-	-
	Max	-	-
Hempel's Light Primer 45551	Min	9 h	4 h
	Max	67 d	30 d
Hempel's Primer Undercoat	Min	9 h	4 h
	Max	7 d	72 h

## Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.
- Condensation on the freshly applied coating should be avoided.

## Overcoating details

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

## Other remarks

- The surface must be clean before overcoating.

## Storage

### Shelf life

Ambient temperature	25°C [77°F]
Base	24 months
Curing Agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

### Storage conditions

- The curing agent is sensitive to moisture. Store in a dry place and keep the can tightly closed until use.
- Product must be stored according to local legislation, at minimum 5°C [41°F], without direct sunlight and protected from rain and snow.
- The product must be stored in accordance with Safety Data Sheet, label and local regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

## Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	5.7 g CO <sub>2</sub> e/m <sup>2</sup>	0.03 lb CO <sub>2</sub> e/ft <sup>2</sup>

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

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## Additional documents

Additional information is available at the Hempel website  
<https://www.hempel.com/service-and-support/technical-guidelines>  
 or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- Further information: Hempel Yacht Paint Manual and [hempelyacht.com](http://hempelyacht.com)

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at [www.hempel.com](http://www.hempel.com) (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from [www.hempel.com](http://www.hempel.com).

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.