



HEMPATEX HI-BUILD 46410

Description:	HEMPATEX HI-BUILD 46410 is physically drying high build paint with good colour retention as a flat finish. Based on acrylic resin and non-chlorinated plasticizer. Contains zinc phosphate. Resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.
Recommended use:	<ol style="list-style-type: none">1. As a primer, intermediate or finishing coat in HEMPATEX-systems in moderately corrosive environment.2. As a selfprimed repair and touch-up coating for containers as well as other cases where a fast and economic repair job is desired.3. As a finishing coat for containers.
Service temperature:	Maximum, dry exposure only: 80°C/176°F see REMARKS overleaf
Certificates/Approvals:	Approved by CSIRO, Australia for carriage of foodstuffs.
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Shade nos/Colours:	11480* / Grey.
Finish:	Flat
Volume solids, %:	42 ± 1
Theoretical spreading rate:	4.2 m ² /l [168.4 sq.ft./US gallon] - 100 micron/4 mils
Flash point:	24 °C [75.2 °F]
Specific gravity:	1.2 kg/litre [10 lbs/US gallon]
Surface dry:	1 approx. hour(s) 20°C/68°F
Dry to touch:	4 approx. hour(s) 20°C/68°F
VOC content:	511 g/l [4.2 lbs/US gallon] <i>*other shades according to assortment list.</i>
	<i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>
APPLICATION DETAILS:	
Application method:	Airless spray / Air spray / Brush
Thinner (max.vol.):	08080 (5%) / 08080 (15%) / 08080 (5%)
Nozzle orifice:	0.017 - 0.021 "
Nozzle pressure:	175 bar [2537.5 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	HEMPEL'S THINNER 08080
Indicated film thickness, dry:	100 micron [4 mils] see REMARKS overleaf
Indicated film thickness, wet:	225 micron [9 mils]
Recoat interval, min:	According to specification.
Recoat interval, max:	According to specification.
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.



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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 the cleaning degree specified for the final coating system, usually Sa 2½ (ISO 8501-1:2007). 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. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up bare spots to full film thickness.

APPLICATION CONDITIONS:

Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT

None, or as per specification.

SUBSEQUENT COAT:

None, or as per specification.

REMARKS:

Colours/Colour stability:

Certain lead-free red and yellow colours may discolour when exposed to chlorine-containing atmosphere.

To obtain full opacity, an extra coat may be necessary, especially for certain lead-free colours in red, orange, yellow and green.

Weathering/service temperatures:

As the paint is a thermoplastic product, prolonged mechanical exposure at temperatures above approximately 40°C/105°F may cause film indentation. When temperature drops below, mechanical strength is recovered.

Application(s)

If a skid-proof surface is desired, sprinkle while paint is still wet HEMPEL'S ANTI-SLINT 67500 evenly on the first coat of: HEMPATEX HI-BUILD. When the paint is dry, sweep up surplus grit and apply a second coat of: HEMPATEX HI-BUILD 46410. Antiskid properties can be obtained by mixing 1.0 kg of HEMPEL'S ANTISLIP BEADS 67420 into: 20 litre HEMPATEX HI-BUILD 46410.

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 recoating interval. Normal range dry is: 75-125 micron/3-5 mils. To obtain an even dry film thickness (of 125 micron), application in two passes (wet-in-wet) is recommended. If applied by roller, e.g. as deck coating, usual dry film thickness is approx. 50 microns per coat. A series of maintenance jobs may result in build up of a too high total film thickness which may cause blister formation due to "entrapped" solvents. As each coat may also retain solvents, it is generally recommended not to apply the product in excessive film thickness.

Recoating intervals:

In case of multi-coat application, drying time and minimum recoating interval will be influenced by the number of coats and by thickness of each coat applied - reference is made to the corresponding painting specification.

No maximum recoating interval, but after prolonged exposure to polluted atmosphere remove accumulated contamination by (high pressure) fresh water cleaning and allow to dry.

Note:

HEMPATEX HI-BUILD 46410 For professional use only.

ISSUED BY:

HEMPEL A/S

4641011480

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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