



HEMPATEX HI-BUILD 46330

Description:	HEMPATEX HI-BUILD 46330 is based on chlorinated rubber. Physically drying. Resistant to salt water, splashes of mineral oils, aliphatic solvents and a wide range of chemicals, but not to animal and vegetable oils or aromatic solvents.
Recommended use:	Selfprimed, or as an intermediate or finishing coat on steel structures in moderately to severely corrosive environment, including permanently submerged surfaces.
Service temperature:	Maximum, dry exposure only: 80°C/176°F see REMARKS overleaf
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:	5.3 m ² /l [212.5 sq.ft./US gallon] - 80 micron/3.2 mils
Flash point:	32 °C [89.6 °F]
Specific gravity:	1.3 kg/litre [10.9 lbs/US gallon]
Dry to touch:	8 approx. hour(s) 20°C/68°F
VOC content:	510 g/l [4.2 lbs/US gallon]
	<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 (touch up)
Nozzle orifice:	0.021 - 0.023 "
Nozzle pressure:	150 bar [2175 psi] (Airless spray data are indicative and subject to adjustment)
Cleaning of tools:	THINNER 08080
Indicated film thickness, dry:	80 micron [3.2 mils] see REMARKS overleaf
Indicated film thickness, wet:	175 micron [7 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 Sa 2½ (ISO 8501-1:1988). For temporary protection, if required, use a suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting.

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. Recommended systems are: HEMPATEX.

Ship bottoms: Antifouling according to specification.

REMARKS:

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.

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: 60-100 micron/2.4-4 mils. 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 46330 For professional use only.

ISSUED BY:

HEMPEL A/S

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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.

The Products are supplied and all technical assistance is given subject to HEMPEL's 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.