

Hempatex HI-Build 46330

Product characteristics

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].

Product safety

Flash point 32°C [90°F]

VOC content

Legislation	Value
EU	511 g/L [4.26 lb/US gal]
US (coatings)	511 g/L [4.26 lb/US gal]
US (regulatory)	511 g/L [4.26 lb/US gal]
China	511 g/L [4.26 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

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.

For professional use only.

Product data

Product code

46330

Standard shade* / code

Grey 11480

Gloss

Flat

Volume solids

42 ± 2%

Specific gravity

1.3 kg/L [11 lb/US gal]

Reference dry film thickness

80 micron [3.1 mils]

Surface preparation

Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove dust, blast media and loose materials.

New build:

- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- All damage of shopprimer and contamination from storage and fabrication should be thoroughly mechanically/chemically cleaned prior to final painting.
- Remove dust, blast media and loose materials.

Maintenance and Repair

- Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC).
- Minor areas may be hand or power tool cleaned instead of abrasive blasting.
- Remove dust, blast media and loose materials.

Consult Hempel's separate Surface Preparation Guidelines for more details.

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Application

Mixing ratio

Stir well before use.

Thinner

Hempel's Thinner 08080

Cleaner

Hempel's Thinner 08080

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 150 bar [2200 psi] Nozzle orifice: 0.021-0.023"
Air spray		Not Applicable.
Brush		Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	40 micron [1.6 mils]	100 micron [3.9 mils]	80 micron [3.1 mils]
Wet film thickness	100 micron [4 mils]	230 micron [9 mils]	190 micron [8 mils]
Theoretical spreading rate	10 m ² /L [410 sq ft/US gal]	4.2 m ² /L [170 sq ft/US gal]	5.2 m ² /L [210 sq ft/US gal]

For best performance, avoid excessive film thickness.

Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Provide adequate ventilation during application and drying.

Application remarks

- When brush or roller is used for applying physically drying paints it is recommended to use the same colour of primer, intermediate and topcoat in order to avoid "bleed through" of different colours from the underlying coats.
- Consult Hempel's Application Guidelines and Instructions for more details.

Drying and overcoating

Product compatibility

- Previous coat: None or according to Hempel's specification.
- Subsequent coat: None or according to Hempel's specification.

Drying time

Surface temperature		20°C [68°F]
Touch dry	min	60
Dry to handle	hours	4

Determined for dry film thickness 80 micron [3.1 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

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

Quality name	Atmospheric medium			
		-10°C [14°F]	0°C [32°F]	10°C [50°F]
Hempatex HI-Build 46330	Min	52 h	24 h	15 h
	Max	Ext*	Ext	Ext

Overcoating details

- The surface must be dry and clean prior to application.

Other remarks

- Hempatex qualities are thermoplastic, therefore prolonged direct pressure at temperatures above 40°C [104°F] may cause film indentations.
- Remove zinc salts or other contamination before overcoating.
- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

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Storage

Shelf life

Ambient temperature	25°C [77°F]	35°C [95°F]
Product	60 months	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

Additional documents

Additional information is available at the Hempel website hempel.com or at your local Hempel website:

- Explanatory Notes explaining the fields in this Product Data Sheet.
- Surface Preparation Guidelines.
- Application Guidelines for different application methods.

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 (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 www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

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.

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.