



Product Data

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 temperatures:	Maximum, dry exposure only: 80°C/176°F (see remarks overleaf).
Availability:	Part of Group Assortment. Local availability subject to confirmation.
PHYSICAL CONSTANTS:	
Colours/Shade nos:	Grey/11480 - Red/50630
Finish:	Flat
Volume solids, %:	42 ± 1
Theoretical spreading rate:	5.3 m ² /litre - 80 micron 211 sq.ft./US gallon - 3.2 mils
Flash point:	32°C/90°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon
Dry to touch:	8 (approx.) hours at 20°C/68°F
V.O.C.:	510 g/litre - 4.2 lbs/US gallon

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush (touch-up)
Thinner (max.vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.021"-.023"		
Nozzle pressure:	150 bar/2200 psi <i>(Airless spray data are indicative and subject to adjustment)</i>		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	80 micron/3.2 mils <i>(See REMARKS overleaf)</i>		
Indicated film thickness, wet:	175 micron/7 mils		
Recoat interval, min:	8 hours (20°C/68°F) <i>(See REMARKS overleaf)</i>		
Recoat interval, max:	None <i>(See REMARKS overleaf)</i>		

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:	New steel: Abrasive blasting to Sa 2½. For temporary protection, if required, use suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use HEMPATEX HI-BUILD 46330. Maintenance: Remove oil and grease, etc. with suitable detergent. Remove salt 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 to full film thickness.
APPLICATION CONDITIONS:	As dictated by normal good painting practice. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	None or according to specification.
SUBSEQUENT COAT:	None, or HEMPATEX system as per specification. Ship bottoms: Antifouling according to specification.
REMARKS:	
Service temperatures:	As HEMPATEX HI-BUILD 46330 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:	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 40-100 micron/1.6-4 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 HEMPATEX HI-BUILD 46330 in excessive film thickness.
Recoating:	In case of multi-coat application, drying time and minimum recoating interval will be influenced by the number of coats and by the thickness of each coat applied - reference is made to the corresponding painting specification. No maximum recoating interval, but before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water cleaning and allow to dry.
Note:	HEMPATEX HI-BUILD 46330 is for professional use only.
ISSUED BY:	HEMPEL A/S - 4633011480C0001

*This Product Data Sheet supersedes those previously issued.
For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.
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