



# Product Data

## HEMPATEX® HI-BUILD 46410

**Description:** HEMPATEX HI-BUILD 46410 is a physically drying high build paint with good colour retention as a semi-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:**

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 temperatures:** 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:

Colours/Shade nos: Grey/11480\* - Red/50630\*  
Finish: Semi-flat  
Volume solids, %: 42 ± 1  
Theoretical spreading rate: 4.2 m<sup>2</sup>/litre - 100 micron  
168 sq.ft./US gallon - 4 mils  
Flash point: 24°C/75°F  
Specific gravity: 1.2 kg/litre - 10.0 lbs/US gallon  
Surface dry: 1 (approx.) hrs at 20°C/68°F (ISO 1517)  
Dry to touch: 4 (approx.) hours at 20°C/68°F  
V.O.C.: 515 g/litre - 4.3 lbs/US gallon

*\*Other shades according to assortment list.*

*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/Roller
Thinner (max. vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	175 bar/2500 psi <i>(Airless spray data are indicative and subject to adjustment)</i>		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	100 micron/4 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	225 micron/9 mils		
Recoat interval, min:	When dry (See REMARKS overleaf)		
Recoat interval, max:	None (See REMARKS overleaf)		

**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.



## HEMPATEX HI-BUILD 46410

SURFACE PREPARATION:	<p><b>New steel:</b> Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. 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 46410.</p> <p><b>Repair and maintenance:</b> Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning.</p> <p>Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up bare spots with HEMPATEX HI-BUILD 46410 to full film thickness.</p>
APPLICATION CONDITIONS:	<p>As dictated by normal good painting practice.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	None, or according to specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Colours:	<p>Certain lead-free red and yellow colours may discolour when exposed to sulphide and chlorine-containing atmosphere.</p> <p>To obtain full opacity, an extra coat may be necessary, especially for certain lead-free colours in eg red, orange, yellow and green.</p>
Service temperatures:	<p>As HEMPATEX HI-BUILD 46410 is a thermoplastic product, prolonged, mechanical exposure at temperatures above approx. 40°C/104°F may cause film indentation. When temperature drops below, mechanical strength is recovered.</p>
Film thicknesses:	<p>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 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 deckcoating, 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 <b>not</b> to apply HEMPATEX HI-BUILD 46410 in excessive film thickness.</p>
Deck coating:	<p>If a skid-proof surface is desired, sprinkle HEMPEL'S ANTI-SLINT 67500 evenly on the first coat of HEMPATEX HI-BUILD 46410 while still wet (consumption approx. 2.5 kg/5.5 lbs to 25 m<sup>2</sup> /270 sq.ft.). When the paint is dry, sweep up surplus grit and apply a second coat of HEMPATEX HI-BUILD 46410. Antiskid properties can also be obtained by mixing 1.0 kg of HEMPEL'S ANTISLIP BEADS 67420 into 20 litre of HEMPATEX HI-BUILD 46410.</p>
Recoating:	<p>For multicoat application minimum recoating interval is influenced by the actual film thickness and number of coats applied. Reference is made to the corresponding painting specification.</p> <p>No maximum recoating interval, but before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water hosing and allow to dry.</p>
Note:	<b>HEMPATEX HI-BUILD 46410 is for professional use only.</b>
ISSUED BY:	HEMPEL A/S - 4641011480C0003

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