



# Product Data

## HEMPATEX HI-BUILD 46820

**Description:** HEMPATEX HI-BUILD 46820 is based on acrylic resin, physically drying. Optimum colour retention. Resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.

**Recommended use:**

1. As a finishing coat on structural steel in moderately to severely corrosive environments.
2. As a finishing coat on containers, rolling stocks, etc.

Note about application and touch-up, please see REMARKS overleaf.

**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: Light alu./19000  
Finish: Semi-flat  
Volume solids, %: 31 ± 1  
Theoretical spreading rate: 3.9 m<sup>2</sup>/litre - 80 micron  
155 sq.ft/US gallon - 3.2 mils  
Flash point: 25°C/77°F  
Specific gravity: 1.0 kg/litre - 8.4 lbs/US gallon  
Dry to touch: 3-4 hours at 20°C/68°F  
V.O.C.: 600 g/litre - 5.0 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 (20%)	08080 (5%)
Nozzle orifice:	.017"-.021" (See REMARKS overleaf)		
Nozzle pressure:	175 bar/2500 psi (See REMARKS overleaf) (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	80 microns/3.2 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	250 microns/10 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.



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SURFACE PREPARATION:	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. Prime/touch up with suitable primer followed by HEMPATEX 46820 to full film thickness.
APPLICATION CONDITIONS:	The surface must be completely clean and dry, its temperature must be above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
PRECEDING COAT:	HEMPADUR PRIMER 15300, HEMPADUR ZINC 15360 or according to specification.
SUBSEQUENT COAT:	None or according to specification.
REMARKS:	
Service temperatures:	Being a thermoplastic product, prolonged direct contact at temperatures above approximately 40°C/104°F may cause film indentation. When temperature drops below, mechanical strength is recovered.
Application:	Way of application will influence the appearance of the paint film. Spray application, especially by conventional spray, will facilitate optimum appearance. If applied by brush, use a flat brush not more than 10 cm/4" wide. After the paint has been distributed it should be laid off with light strokes and in one direction only. If the paint is worked too much with brush or roller, it will become streaky and greyish and lose its lustre. <b>Irrespective of measures taken during application, touch-up may, however, cause areas of different visual appearance as to different gloss or sheen.</b>
Film thicknesses:	This effect is cosmetic only and has no influence on the protective properties. 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 recoat interval. Normal range 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 <b>not</b> to apply HEMPATEX HI-BUILD 46820 in excessive film thickness.
Recoating:	In any case, avoid exaggerated film thicknesses. For this reason it is also recommended to use lowest possible nozzle orifice and pressure when applied by airless spray. In case of multi-coat application, drying time and minimum recoat 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. Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water cleaning and allow to dry.
Note:	<b>HEMPATEX HI-BUILD 46820 is for professional use only.</b>
ISSUED BY:	HEMPEL A/S - 4682019000C0006

***This Product Data Sheet supersedes those previously issued.***

***For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.***

***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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***Product data are subject to change without notice and become void five years from the date of issue.***