

# HEMPALIN\* PRIMER HI-BUILD 13200

<b>Description:</b>	HEMPALIN PRIMER HI-BUILD 1320 is a quick-drying, urethane-modified alkyd primer with zinc phosphate, rust-inhibiting pigments.
<b>Recommended use:</b>	General purpose primer for HEMPALIN systems on well cleaned interior and exterior steel in mildly to moderately corrosive atmosphere. Not suited for permanent immersion or in association with impressed current cathodic protection.
<b>Service temperatures:</b>	Maximum, dry: 120°C/248°F.
<b>Approvals, certificates:</b>	Approved as a low flame spread material by Danish, British, German, Italian and Japanese authorities.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Yellow/22430	White/10000
Finish:	Flat	Flat
Volume solids:	45%	44%
Theoretical spreading rate:	6.0 m <sup>2</sup> /litre - 75 micron 241 sq.ft./US gallon - 3.0 mils	5.9 m <sup>2</sup> /litre - 75 micron 235 sq.ft./US gallon - 3.0 mils
Flash point:	31°C/88°F	31°C/88°F
Specific gravity:	1.2 kg/litre - 10.0 lbs/US gallon	1.2 kg/litre - 10.0 lbs/US gallon
Surface dry:	1 (approx.) hr at 20°C/68°F (ISO 1517)	1 (approx.) hr at 20°C/68°F (ISO 1517)
Dry to touch:	4 (approx.) hours at 20°C/68°F	4 (approx.) hours at 20°C/68°F
V.O.C.:	445 g/litre - 3.7 lbs/US gallon	445 g/litre - 3.7 lbs/US gallon

*The physical constants are subject to normal manufacturing tolerances.  
Further reference is made to "Explanatory Notes" in the Hempel Book.*

## APPLICATION DETAILS:

Application method:	Airless spray	Brush (touch up)
Thinner (max.vol.):	0808 (5%)	0808 (5%)
Nozzle orifice:	.021"-.023"	
Nozzle pressure:	200 bar/2900 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	THINNER 0808	
Indicated film thickness, dry:	75 micron/3 mils	
Indicated film thickness, wet:	175 micron/7 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

## 2. HEMPALIN PRIMER HI-BUILD 13200

SURFACE	<b>New steel:</b> Abrasive blasting to Sa 2½, SSPC-SP-10, is recommended. For temporary protection, if
PREPARATION:	required, use a suitable zinc-free or low-zinc 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 HEMPALIN PRIMER HI-BUILD 1320. <b>Maintenance:</b> 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.
SUBSEQUENT COAT:	HEMPALIN system according to specification.
REMARKS:	
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 50-75 micron/2-3 mils.
Recoating:	Recoating intervals related to later conditions of exposure: (75 micron/3 mils dry film thickness of HEMPALIN PRIMER HI-BUILD 1320)

	Minimum		Maximum	
Surface temperature	20°C/68°F		20°C/68°F	
	Atmospheric		Atmospheric	
Recoated with	Mild	Medium	Mild	Medium
HEMPALIN, except 5324 and 1320	5 hours	8 hours	None	3 days
1320	5 hours	8 hours	None	None
5324	5 days	5 days	None	10 days

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

Before recoating after exposure in contaminated environment, clean the surface thoroughly with (high pressure) fresh water and allow to dry.

Note: **HEMPALIN PRIMER HI-BUILD 1320 is for professional use only.**

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. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation of possible solvent vapours or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

This Product Data Sheet supersedes those previously issued. For definition and scope, see explanatory notes to applicable Product Data Sheets. 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.

Issued by HEMPEL'S MARINE PAINTS A/S.

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