

HEMUCRYL* PRIMER HI-BUILD 18030

Description:	HEMUCRYL PRIMER HI-BUILD 18030 is a water-borne, acrylic dispersion paint with good anticorrosive properties. Especially suited for application by airless spray.
Recommended use:	As a primer in water-borne paint systems on interior and exterior steelwork in mildly to moderately corrosive environment. May also be used as a primer in water-borne paint systems on hot dip galvanized steel, aluminium, and stainless steel in mildly corrosive environment.
Service temperatures:	Maximum, dry: 120°C/248°F.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Light grey/12170 - Red/50710
Finish:	Flat
Volume solids:	44%
Theoretical spreading rate:	5.9 m ² /litre - 75 micron 235 sq.ft./US gallon - 3 mils
Flash point:	> 66°C/151°F
Specific gravity:	1.2 kg/litre - 10.0 lbs/US gallon
Surface dry:	½ (approx.) hr at 20°C/68°F (ISO 1517)
Dry to touch:	1½ (approx.) hour at 20°C/68°F
V.O.C.:	22 g/litre - 0.2 lbs/US gallon 130 g/litre - 1.1 lbs/US gallon (ASTM D 3960 - water reduced)

*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.):	Fresh water (5%)	HEMUCRYL BRUSH AGENT 99810 (3-8%)
Nozzle orifice:	.015"-.019"	
Nozzle pressure:	130 bar/1900 psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools:	Fresh water (See REMARKS overleaf)	
Indicated film thickness, dry:	75 micron/3 mils (See REMARKS overleaf)	
Indicated film thickness, wet:	175 micron/7 mils	
Recoat interval, min:	2 hours (20°C/68°F)	
Recoat interval, max:	None (See REMARKS overleaf)	

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SURFACE PREPARATION:	<p>New steel: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to minimum Sa 2½, SSPC-SP-10. For temporary protection, if required, use suitable shopprimer. All damaged shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use HEMUCRYL PRIMER HI-BUILD 18030.</p> <p>Repair: Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove rust and loose paint by abrasive blasting or power tool cleaning to St 3 before recoating. Touch up bare spots with HEMUCRYL PRIMER HI-BUILD 18030.</p> <p>Aluminium: Very careful degreasing, followed by high pressure fresh water cleaning to remove all salts and other contamination. Any anodizing must be completely removed. Thorough sand papering or abrasive sweeping with mineral abrasives is recommended. Cast aluminium is recommended to be abrasive swept to a uniform, evenly grey appearance. Hot dip galvanized steel: Wet rubbing/grinding with ammonia - water 1:20, followed by fresh water hosing. In case this method is not feasible, the procedure described for stainless steel may be used.</p> <p>Stainless steel: Very careful degreasing, followed by fresh water hosing to remove all contamination.</p> <p>Note: HEMUCRYL TI-COAT 18200 may preferably be used as the first coat on aluminium, hot dip galvanized steel and stainless steel.</p>
APPLICATION CONDITIONS:	Use only where application can proceed at temperatures above 5°C/41°F, preferably above 10°C/50°F. Apply on a clean and dry surface with a temperature above the dew point to avoid condensation. Relative humidity: during application above 60%, preferably 75-90% to avoid dry spray. During drying below 80%, preferably between 40-60%. (Contact HEMPEL for further advice). Good ventilation during application and drying is necessary. During drying it is of utmost importance that sufficient ventilation is covering all parts of the surfaces painted. Ventilation requirements to remove the water vapours liberated during application and drying are approximately 75 m³/litre of the paint at 20°C/68°F. (Relative humidity of the air supply 40%).
SUBSEQUENT COAT:	HEMUCRYL ENAMEL HI-BUILD 58030 or 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 50-100 micron/2-4 mils. When used in 50 micron dry film thickness, 3-5% thinning will be necessary to secure proper film formation. For proper film formation the recommended nozzle sizes should be used.
Good painting practice:	The durability/performance of water-borne coatings is to a very high degree depending on the fulfilment of good painting practice. For instance application to riveted and skip-welded constructions will require extra care when coating sharp edges, riveted joints, etc. Avoid too high thicknesses per coat. Preferably apply an extra stripe coat.
Brush application:	Add 3-8% by volume of HEMUCRYL BRUSH AGENT 99810. Typical dry film thickness per coat will be 30-40 micron/1.2-1.6 mils.
Exposure to low temperatures shortly after application:	If the painted items will be exposed to humidity/water at temperatures below 5-10°C/40-50°F shortly after finishing the paint application, it is of utmost importance for later good performance that the following rules are complied with: <ul style="list-style-type: none">- Excessive film thickness must be avoided.- The (last applied) paint layer must dry for at least 24 hours at 20°C/68°F before exposure.
Recoating:	No maximum recoating interval, but after prolonged exposure to polluted atmosphere remove accumulated contamination by (high pressure) fresh water cleaning and allow to dry.
Cleaning of tools:	Clean tools carefully with fresh water or lukewarm soap water immediately after use. Dried remains of paint can be removed with HEMPEL'S NAVI WASH 9933, undiluted, or HEMPEL'S TOOL CLEANER 99610.
Shelf life/storage:	Store at temperatures between 5-40°C/41-104°F. Shelf life is reduced at temperatures above 30°C/86°F. Do not expose to frost during storage and transport, or before the coating is dry.
Note:	HEMUCRYL PRIMER HI-BUILD 18030 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.

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