

# HEMPATEX\* HI-BUILD 46330

<b>Description:</b>	HEMPATEX HI-BUILD 4633 is based on chlorinated rubber. Physically drying. Resistant to salt water, splashes of mineral oils, aliphatic solvents, petrol, and a wide range of chemicals, but not to animal and vegetable oils or aromatic solvents. For service temperature range, see REMARKS overleaf.
<b>Recommended use:</b>	Selfprimed, or as an intermediate or finishing coat on steel structures in moderately to severely corrosive environment, including permanently submerged surfaces.
<b>Service temperatures:</b>	Maximum, dry: 80°C/176°F.
<b>Approvals:</b>	Approved as a low flame spread material by Nippon Kaiji Kyokai, Tokyo.
<b>Availability:</b>	Subject to confirmation.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/11480	Red/50630
Finish:	Flat	Flat
Volume solids:	45%	45%
Theoretical spreading rate:	5.6 m <sup>2</sup> /litre - 80 micron 226 sq.ft./US gallon - 3.2 mils	5.6 m <sup>2</sup> /litre - 80 micron 226 sq.ft./US gallon - 3.2 mils
Flash point:	32°C/90°F	32°C/90°F
Specific gravity:	1.4 kg/litre - 11.7 lbs/US gallon	1.4 kg/litre - 11.7 lbs/US gallon
Dry to touch:	8 (approx.) hours at 20°C/68°F	8 (approx.) hours at 20°C/68°F
V.O.C.:	509 g/litre - 4.2 lbs/US gallon	506 g/litre - 4.2 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	Air spray	Brush (touch-up)
Thinner (max.vol.):	0808 (5%)	0808 (15%)	0808 (5%)
Nozzle orifice:	.021"-.023"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 0808		
Indicated film thickness, dry:	80 micron/3.2 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	175 micron/7 mils		
Recoat interval, min:	8 hours (20°C/68°F) (See REMARKS overleaf)		
Recoat interval, max:	None (See REMARKS overleaf)		

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SURFACE PREPARATION:	<b>New steel:</b> 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 4633. <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.
PRECEDING COAT:	None or according to specification.
SUBSEQUENT COAT:	None, or HEMPATEX system as per specification. Ship bottoms: Antifouling according to specification.
REMARKS: Colours:	Certain lead-free red and yellow colours may discolour when exposed to sulphide and chlorine-containing atmosphere. As HEMPATEX HI-BUILD 4633 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 <b>not</b> to apply HEMPATEX HI-BUILD 4633 in excessive film thickness. 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:	<b>HEMPATEX HI-BUILD 4633 is for professional use only.</b>
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.

\*This is a corporate trademark of the Hempel Group.

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