

HEMPATEX* HI-BUILD 46410

Description:	HEMPATEX HI-BUILD 4641 is a physically drying high build paint with good colour retention as a semi-flat finish. Based on acrylic resin, alkyd and non-chlorinated plasticizer. Contains zinc phosphate. Resistant to splashes of mineral oils, animal and vegetable oils. For service temperature range, see below.
Recommended use:	<ol style="list-style-type: none">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: 80°C/176°F (<i>See REMARKS overleaf</i>).
Approvals, certificates:	Approved as a low flame spread material by Japanese authorities. Approved by CSIRO, Australia for carriage of foodstuffs.
Availability:	Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/11480*	Red/50630*
Finish:	Semi-flat	Semi-flat
Volume solids:	45%	44%
Theoretical spreading rate:	4.5 m²/litre - 100 micron 180 sq.ft./US gallon - 4 mils	4.4 m²/litre - 100 micron 176 sq.ft./US gallon - 4 mils
Flash point:	24°C/75°F	24°C/75°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.) hrs at 20°C/68°F (<i>ISO 1517</i>)	1 (approx.) hrs at 20°C/68°F (<i>ISO 1517</i>)
Dry to touch:	4 (approx.) hours at 20°C/68°F	4 (approx.) hours at 20°C/68°F
V.O.C.:	511 g/litre - 4.2 lbs/US gallon	513 g/litre - 4.3 lbs/US gallon

**Other shades according to assortment list.*

*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/Roller
Thinner (max. vol.):	0808 (5%)	0808 (15%)	0808 (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 0808		
Indicated film thickness, dry:	100 micron/4 mils (<i>See REMARKS overleaf</i>)		
Indicated film thickness, wet:	225 micron/9 mils		
Recoat interval, min:	When dry (<i>See REMARKS overleaf</i>)		
Recoat interval, max:	None (<i>See REMARKS overleaf</i>)		

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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 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 4641.</p> <p>Repair and maintenance: 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 bare spots with HEMPATEX HI-BUILD 4641 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>As HEMPATEX HI-BUILD 4641 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 not to apply HEMPATEX HI-BUILD 4641 in excessive film thickness.</p>
Deck coating:	<p>If a skid-proof surface is desired, sprinkle HEMPEL'S ANTI-SLINT 6750 evenly on the first coat of HEMPATEX HI-BUILD 4641 while still wet (consumption approx. 2.5 kg/5.5 lbs to 25 m² /270 sq.ft.). When the paint is dry, sweep up surplus grit and apply a second coat of HEMPATEX HI-BUILD 4641. Antiskid properties can also be obtained by mixing 1.0 kg of HEMPEL'S ANTISLIP BEADS 6742 into 20 litre of HEMPATEX HI-BUILD 4641.</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:	HEMPATEX HI-BUILD 4641 is for professional use only.
SAFETY:	<p>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.</p>

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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