

HEMPATEX* HI-BUILD 46820

Description: HEMPATEX HI-BUILD 4682 is based on acrylic resin, physically drying. Optimum colour retention. Resistant to salt water, splashes of mineral oils, aliphatic solvents and vegetable oils. For service temperature range, see REMARKS overleaf.

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: 80°C/176°F.

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Light alu./19000	Grey/17700
Finish:	Semi-flat	Semi-gloss
Volume solids:	33%	35%
Theoretical spreading rate:	4.1 m ² /litre - 80 micron 165 sq.ft/US gallon - 3.2 mils	4.4 m ² /litre - 80 micron 178 sq.ft/US gallon - 3.2 mils
Flash point:	25°C/77°F	25°C/77°F
Specific gravity:	1.0 kg/litre - 8.4 lbs/US gallon	1.0 kg/litre - 8.4 lbs/US gallon
Surface dry:	½ (approx) hour at 20°C/68°F (ISO 1517)	½ (approx) hour at 20°C/68°F (ISO 1517)
Dry to touch:	3-4 hours at 20°C/68°F	3-4 hours at 20°C/68°F
V.O.C.:	605 g/litre - 5.0 lbs/US gallon	590 g/litre - 4.9 lbs/US gallon

*The physical constants are subjects 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 (20%)	0808 (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 0808		
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)		

Issued:

April 1998

2. HEMPATEX HI-BUILD 46820

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 4682 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 1530, HEMPADUR ZINC 1536 or according to specification.
SUBSEQUENT COAT:	None or according to specification.
REMARKS:	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 grayish and lose its lustre. Irrespective of measures taken during application, touch-up may, however, cause areas of different visual appearance as to different gloss or sheen.
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. 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. 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. Before recoating after exposure in contaminated environment, clean the surface thoroughly by high pressure fresh water cleaning and allow to dry.
Note:	HEMPATEX HI-BUILD 4682 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.

*This is a corporate trademark of the Hempel Group.

April 1998 - 4682019000CO005