

# HEMPALIN\* ENAMEL HI-BUILD 5222<sub>0</sub>

<b>Description:</b>	HEMPALIN ENAMEL HI-BUILD 5222 is an alkyd paint, which can be applied in high film thickness by airless spray. This property enables the use of specifications with fewer coats and reduced application cost.
<b>Recommended use:</b>	As a finishing coat in HEMPALIN Systems on interior and exterior steel in mildly to moderately corrosive environment.
<b>Service temperatures:</b>	Maximum, dry: 120°C/248°F.
<b>Approvals, certificates:</b>	Approved as a low flame spread material by Danish authorities.
<b>Availability:</b>	Subject to confirmation. If HEMPALIN ENAMEL HI-BUILD 5222 is not available in the desired colour, HEMPALIN ENAMEL 5214 can be used. See Product Data Sheet.

## PHYSICAL CONSTANTS:

Colours/Shade nos:	White/10000*
Finish:	Glossy
Volume solids:	50%
Theoretical spreading rate:	8.3 m <sup>2</sup> /litre - 60 micron 334 sq.ft/US gallon - 2.4 mils
Flash point:	38°C/100°F
Specific gravity:	1.1 kg/litre - 9.2 lbs/US gallon
Surface dry:	2½ (approx) hours at 20°C/68°F (ISO 1517)
Dry to touch:	6-8 hours at 20°C/68°F
V.O.C.:	400 g/litre - 3.3 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	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:	60 micron/2.4 mils (See REMARKS overleaf)	
Indicated film thickness, wet:	125 micron/5 mils	
Recoat interval, min:	See REMARKS overleaf	
Recoat interval, max:	See REMARKS overleaf	

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## 2. HEMPALIN ENAMEL HI-BUILD 52220

APPLICATION CONDITIONS: As dictated by normal good painting practice.  
In confined spaces provide adequate ventilation during application and drying.

PRECEDING COAT: HEMPALIN PRIMER HI-BUILD 1320 or according to specification.

SUBSEQUENT COAT: None.

REMARKS: Recoating: Recoat intervals related to later conditions of exposure:  
(60 micron/2.4 mils dry film thickness of HEMPALIN ENAMEL HI-BUILD 5222)

	Minimum		Maximum	
Surface temperature	20°C/68°F		20°C/68°F	
Recoated with (quality numbers only)	Atmospheric		Atmospheric	
	Mild	Medium	Mild	Medium
5222	12 hours	16 hours	None	5 days

If the maximum recoat interval is exceeded, roughening of the surface is recommended to ensure intercoat adhesion.

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

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.

Do not expose liquid paint to temperatures above 40°C/104°F neither during storage nor in connection with application.

Note: **HEMPALIN ENAMEL HI-BUILD 5222 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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