



# Product Data

## HEMPATEX HI-BUILD 46370

**Description:** HEMPATEX HI-BUILD 46370 is a physically drying high build paint with optimum colour retention. Based on acrylic resin and chlorinated plasticizer. Resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.

**Recommended use:**

1. As an exterior finishing coat on containers.
2. As an intermediate or finishing coat in HEMPATEX systems in moderately to severely corrosive environment.

**Service temperatures:** Maximum, dry exposure only: 80°C/175°F (see REMARKS overleaf).

**Certificates/Approvals:** Complies with EU Directive 2004/42/EC, subcategory i (see REMARKS overleaf).

**Availability:** Normally available on orders for container new-buildings only.

### PHYSICAL CONSTANTS:

Colours/Shade Nos: White/10000\*  
Finish: Semi-flat  
Volume solids, %: 40 ± 1  
Theoretical spreading rate: 4.7 m<sup>2</sup>/litre - 85 micron  
189 sq.ft./US gallon - 3.4 mils  
Flash point: 25°C/77°F  
Specific gravity: 1.2 kg/litre - 10.0 lbs/US gallon  
Surface dry: ½ (approx) hour at 20°C/68°F (ISO 1517)  
Dry to touch: 4 (approx) hours at 20°C/68°F  
V.O.C.: 535 g/litre - 4.5 lbs/US gallon

*\*Concerning other shades, reference is made to HEMPEL'S CONTAINER COLOUR CARD.*

*The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1.*

### APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush
Thinner (max. vol.):	08080 (20%)	08080 (30%)	08080 (5%)
	For on-line container production thinning according to specification		
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	150 bar/2200 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	85 micron/3.4 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	200 micron/8 mils		
Recoat interval, min:	4 hours (20°C/68°F) (See REMARKS overleaf)		
Recoat interval, max:	None (See REMARKS overleaf)		

**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. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.



## HEMPATEX HI-BUILD 46370

**SURFACE PREPARATION:** **Repair and Maintenance:** Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by high pressure fresh water cleaning. Followed by:  
**For steel:** Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up bare spots with e.g. suitable primer followed by HEMPATEX HI-BUILD 46370 to full film thickness.  
**For other metals, concrete:** Reference is made to the corresponding painting specification and to the Product Data Sheet for the primer/sealer.

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

**PRECEDING COAT:** HEMPADUR ZINC 15360, HEMPADUR PRIMER 15300 or according to specification.

**SUBSEQUENT COAT:** None, HEMPATEX ENAMEL 56360, or as per specification depending on area of use.

### REMARKS:

VOC - EU directive 2004/42/EC:

	As supplied	26 vol. % thinning	Limit phase I, 2007	Limit phase II, 2010
VOC in g/l	535	600	600	500

VOC:

For VOC of other shades, please refer to Safety Data Sheet.

Colours:

Certain lead-free red and yellow colours may discolour when exposed to chlorine-containing atmosphere.

Leaded colours may become discoloured when exposed to sulphide-containing atmosphere.

To obtain full opacity, an extra coat may be necessary, especially for certain lead-free colours in eg red, orange, yellow and green.

Service

temperatures:

As HEMPATEX HI-BUILD 46370 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.

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 recoat interval. Normal range is 75-100 microns/3-4 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 **not** to apply HEMPATEX HI-BUILD 46370 in excessive film thickness.

Recoating:

In case of multicoat application, drying time and minimum recoat interval are influenced by the actual film thickness and number of coats 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 hosing and allow to dry.

Note:

**HEMPATEX HI-BUILD 46370 is for professional use only.**

ISSUED BY:

HEMPEL A/S - 4637010000C0016

***This Product Data Sheet supersedes those previously issued.***

***For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.***

***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.***

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***Product data are subject to change without notice and become void five years from the date of issue.***