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| <b>Description:</b>            | HEMPATEX HI-BUILD 46410 is physically drying high build paint with good colour retention as a flat finish. Based on acrylic resin and non-chlorinated plasticizer. Contains zinc phosphate. Resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.  |
| <b>Recommended use:</b>        | <ol style="list-style-type: none"><li>1. As a primer, intermediate or finishing coat in HEMPATEX-systems in moderately corrosive environment.</li><li>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.</li><li>3. As a finishing coat for containers.</li></ol> |
| <b>Service temperature:</b>    | Maximum, dry exposure only: 80°C/176°F see REMARKS overleaf  |
| <b>Certificates/Approvals:</b> | Complies with Section 175.300 of the Code of Federal Regulations Title 21 – Liquid Foodstuff.<br><br>Approved as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on <a href="http://www.Hempel.com">www.Hempel.com</a> for further details.                                  |
| <b>Availability:</b>           | Part of Group Assortment. Local availability subject to confirmation.  |
| <b>PHYSICAL CONSTANTS:</b>     |  |
| Shade nos/Colours:             | 11480* / Grey.   |
| Finish:                        | Flat   |
| Volume solids, %:              | 42 ± 1   |
| Theoretical spreading rate:    | 4.2 m <sup>2</sup> /l [168.4 sq.ft./US gallon] - 100 micron/4 mils   |
| Flash point:                   | 26 °C [78.8 °F]  |
| Specific gravity:              | 1.2 kg/litre [10 lbs/US gallon]  |
| Surface-dry:                   | 45 minute(s) 20°C/68°F   |
| Through-dry:                   | 1.5 hour(s) 20°C/68°F  |
| VOC content:                   | 508 g/l [4.2 lbs/US gallon]  |
| Shelf life:                    | 5 years (25°C/77°F) from time of production.<br><i>*other shades according to assortment list.</i>   |
|                                | <i>The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.</i>   |
| <b>APPLICATION DETAILS:</b>    |  |
| Application method:            | Airless spray / Air spray / Brush  |
| Thinner (max.vol.):            | 08080 (5%) / 08080 (15%) / 08080 (5%)  |
| Nozzle orifice:                | 0.017 - 0.021 "  |
| Nozzle pressure:               | 175 bar [2537.5 psi]<br>(Airless spray data are indicative and subject to adjustment)  |
| Cleaning of tools:             | HEMPEL'S THINNER 08080   |
| Indicated film thickness, dry: | 100 micron [4 mils] see REMARKS overleaf   |
| Indicated film thickness, wet: | 250 micron [10 mils]   |
| Overcoat interval, min:        | see REMARKS overleaf   |
| Overcoat interval, max:        | see REMARKS overleaf   |
| <b>Safety:</b>                 | Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Safety Data Sheets and follow all local or national safety regulations.   |

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| SURFACE PREPARATION:             | <p><b>New steel:</b> Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Abrasive blasting to the cleaning degree specified for the final coating system, usually Sa 2½ (ISO 8501-1:2007). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating.</p> <p><b>Repair and maintenance:</b> Remove oil and grease etc. thoroughly with suitable detergent. Remove salts 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 to full film thickness.</p> |
| APPLICATION CONDITIONS:          | Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.   |
| PRECEDING COAT:                  | None, or as per specification.   |
| SUBSEQUENT COAT:                 | None, or as per specification.   |
| REMARKS:                         |  |
| Colours/Colour stability:        | <p>Colour stability for some shades may be effected by exposure to harsh chemical atmospheres. This does not affect the performance of the coating.</p> <p>For certain colours extra coats may be necessary to obtain full opacity.</p> <p>For aluminium pigmented shades scratching actions or high humidity/water may cause discolouration/ disturbances of the surface. This will have no influence on the performance. This phenomenon may be avoided by applying a clear varnish.</p>   |
| Weathering/service temperatures: | As the paint 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.  |
| Application(s):                  | If a skid-proof surface is desired, sprinkle while paint is still wet HEMPEL'S ANTI-SLINT 67500 evenly on the first coat of: HEMPATEX HI-BUILD. When the paint is dry, sweep up surplus grit and apply a second coat of: HEMPATEX HI-BUILD 46410. Antiskid properties can be obtained by mixing 1.0 kg of HEMPEL'S ANTISLIP BEADS 67420 into: 20 litre HEMPATEX HI-BUILD 46410.  |
| Film thicknesses/thinning:       | 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 overcoating interval. Normal range dry is: 50-125 micron/2-5 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 deck coating, 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 the product in excessive film thickness.   |
| Shades:                          | This product is available in several aluminium pigmented shades with different volume solids content. Contact HEMPEL for more information.   |
| Overcoating:                     | Overcoating intervals related to later conditions of exposure: If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion. Before overcoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.   |

A specification supersedes any guideline overcoat intervals indicated in the table.

| Environment | Atmospheric, medium |      |            |      |             |      |
|-------------|---------------------|------|------------|------|-------------|------|
|             | -10°C (14°F)        |      | 0°C (32°F) |      | 20°C (68°F) |      |
|             | Min                 | Max  | Min        | Max  | Min         | Max  |
| HEMPATEX    | 26 h                | None | 12 h       | None | 4 h         | None |

NR = Not Recommended, Ext. = Extended, m = minute(s), h = hour(s), d = day(s)

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| Overcoating intervals: | <p>In case of multi-coat application, drying time and minimum overcoating interval will be influenced by the number of coats and by thickness of each coat applied - reference is made to the corresponding painting specification.</p> <p>No maximum overcoating interval, but after prolonged exposure to polluted atmosphere remove accumulated contamination by (high pressure) fresh water cleaning and allow to dry.</p> |
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Note: **HEMPATEX HI-BUILD 46410 For professional use only.**

ISSUED BY: HEMPEL A/S 4641011480

This Product Data Sheet supersedes those previously issued.  
 For explanations, definitions and scope, see "Explanatory Notes" available on [www.hempel.com](http://www.hempel.com). 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.