

# Hempatex HI-Build 46410

## Product characteristics

### Description

Hempatex HI-Build 46410 is a physically drying, high-build coating with good colour retention as a flat finish. The product is based on acrylic resin and non-chlorinated plasticizer. Contains zinc phosphate. The product is resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.

### Recommended use

Hempatex HI-Build 46410 is recommended as a primer, intermediate or finishing coat in Hempatex-systems in moderate corrosive environments. The product is suitable as a self-priming repair and touch-up coating for containers as well as other cases where a fast and economic repair job is desired. Can also be used as a finishing coat for containers.

### Service temperature:

- Maximum, dry exposure only: 80°C [176°F].

### Certificates / Approvals

- EC-type examined as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on [hempel.com](http://hempel.com) for further details.
- Complies with US FDA and EU food regulations for contact with dry foodstuff. Consult Hempel for details.

### Features

- Physically drying.
- Good colour retention.
- Resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.

## Product safety

Flash point 26°C [79°F]

### VOC content

Legislation	Value
EU	513 g/L [4.28 lb/US gal]
US (coatings)	513 g/L [4.28 lb/US gal]
US (regulatory)	513 g/L [4.28 lb/US gal]
China	513 g/L [4.28 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](http://hempel.com) or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

### Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

## Product data

### Product code

46410

### Standard shade / code

Mid Grey 11480 \*  
Grey 11480

Wide range of colours is available via Hempel's tinting system.

### Gloss

Flat

### Volume solids

42 ± 2%

### Specific gravity

1.2 kg/L [10 lb/US gal]

# Hempatex HI-Build 46410

## Reference dry film thickness

100 micron [4.0 mils]

## Aluminium shade / code

Aluminium 19000  
Aluminium grey 19000

## Gloss

Please consult Hempel's Guideline on aluminium pigmented coatings.

## Volume solids

40 ± 2%

## Specific gravity

1.2 kg/L [10 lb/US gal]

## Reference dry film thickness

100 micron [4.0 mils]

## Surface preparation

### Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

### New build:

- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

### Maintenance and Repair

- Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC).
- Minor areas may be hand or power tool cleaned instead of abrasive blasting.
- Remove dust, blast media and loose materials.

Consult Hempel's separate Surface Preparation Guidelines for more details.

## Application

### Mixing ratio

Stir well before use.

### Thinner

Hempel's Thinner 08080

### Cleaner

Hempel's Thinner 08080

### Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 175 bar [2500 psi] Nozzle orifice: 0.017-0.021"
Air spray	15%	Not Applicable.
Brush	5%	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

### Film thickness

Specification range	Low	High	Recommended
Dry film thickness	50 micron [2.0 mils]	125 micron [5.0 mils]	100 micron [4.0 mils]
Wet film thickness	120 micron [4.8 mils]	300 micron [12 mils]	240 micron [9.6 mils]
Theoretical spreading rate	8.3 m <sup>2</sup> /L [338 sq ft/US gal]	3.3 m <sup>2</sup> /L [134 sq ft/US gal]	4.2 m <sup>2</sup> /L [171 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

### Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.

# Hempatex HI-Build 46410

## Application remarks

- Two coats of the topcoat may be necessary to obtain full hiding power.

## Drying and overcoating

### Product compatibility

- Previous coat: None or according to Hempel's specification.
- Subsequent coat: None or according to Hempel's specification.

### Drying time

Surface temperature		-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
Surface dry	hours	2½	1½	¾	½
Hard dry	hours	9	4½	1½	1

Determined for dry film thickness 100 micron [4.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

### Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		-10°C [14°F]	0°C [32°F]	20°C [68°F]	30°C [86°F]
Atmospheric medium					
Hempatex HI-Build 46410	Min Max	26 h No max	12 h No max	4 h No max	3 h No max

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

### Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

### Overcoating details

- The surface must be dry and clean prior to application.

## Other remarks

- Hempatex qualities are thermoplastic, therefore prolonged direct pressure at temperatures above 40°C [104°F] may cause film indentations.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

## Storage

### Shelf life

Ambient temperature	25°C [77°F]
Product	60 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

### Storage conditions

- The product must be stored in accordance with Safety Data Sheet, label and local regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

## Carbon Footprint

Dry film thickness	1 µm	1 mil
GWP (Global Warming Potential)	8.3 g CO <sub>2</sub> e/m <sup>2</sup>	0.043 lb CO <sub>2</sub> e/ft <sup>2</sup>

The carbon footprint is for 1 square meter / square foot of surface area with a dry film thickness of 1 micron / mil.

The scope includes raw materials, in-bound transport to the Hempel factory, Hempel manufacturing processes, and any Volatile Organic Compounds emitted during and after the application of the product.

It is calculated based on the standard shade defined in this PDS. Values may vary with shade.

# Hempatex HI-Build 46410

## Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- Surface Preparation.
- Application Instruction for this product.

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at [www.hempel.com](http://www.hempel.com) (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from [www.hempel.com](http://www.hempel.com).

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.