

Hemucryl Primer HI-Build

Product characteristics

Description

Hemucryl Primer HI-Build 18032 is a water-borne, acrylic dispersion paint with good anticorrosive properties. Especially suited for application by airless spray.

Complies with EU Directive 2004/42/EC, The Paints Directive on the limitation of volatile organic compounds: subcategory i.

Recommended use

As a primer in water-borne paint systems on interior and exterior steelwork in mildly to moderately corrosive environment. May also be used as a primer in water-borne paint systems on hot dip galvanized steel, aluminium, and stainless steel in mildly corrosive environment.

Service temperature:

- Maximum, dry exposure only: 120°C [248°F].

Product safety

Flash point 74°C [165°F]

VOC content

Legislation	Value	5% thinning, by volume	Limit value, phase II (2010) ^a
EU	42 g/L [0.35 lb/US gal]	82 g/L [0.68 lb/US gal]	140 g/L [1.17 lb/US gal]
US (regulatory)	122 g/L [1.02 lb/US gal]	-	-
China	42 g/L [0.35 lb/US gal]	-	-

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9. ^aEU Directive 2004/42/CE.

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

18032

Standard shade* / code

Light grey 12170

Gloss

Flat

Volume solids

43 ± 2%

Specific gravity

1.2 kg/L [10 lb/US gal]

Reference dry film thickness

75 micron [3.0 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 can be cleaned by power tool to St 3 provided the surface is roughened and not polished.
- Remove dust, blast media and loose materials.

Roughness

- Surface profile Medium (G) (ISO 8503-2).

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

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Application

Mixing ratio

Stir well before use.

Thinner

Fresh water

Cleaner

Hempel's Tool Cleaner 99610

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	5%	Nozzle pressure: 130 bar [1900 psi] Nozzle orifice: 0.015-0.019"
Brush	8%	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]	100 micron [3.9 mils]	75 micron [3.0 mils]
Wet film thickness	120 micron [5 mils]	230 micron [9 mils]	175 micron [7 mils]
Theoretical spreading rate	8.6 m ² /L [350 sq ft/US gal]	4.3 m ² /L [180 sq ft/US gal]	5.7 m ² /L [230 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.
- Surface temperature must be above 10°C [50°F] during application and curing.

Relative Humidity:

- Relative humidity must be below 80% during curing.
- Relative humidity must be below 80% during application.

Drying and overcoating

Product compatibility

- Previous coat: None.
- Subsequent coat: According to Hempel's Specification.
Recommended product is: Hemucryl Enamel Hi-Build 58030

Drying time

Surface temperature		20°C [68°F]
Surface dry	min	60
Through dry	min	90

Determined for dry film thickness 75 micron [3.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.
- Condensation on the freshly applied coating should be avoided.

Overcoating details

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

Other remarks

- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]	35°C [95°F]
Product	36 months	24 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

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Storage conditions

- Temperature must not go below 5°C [41°F] during transport and storage.
- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.

Additional documents

Additional information is available at the Hempel website hempel.com or at your local Hempel website:

- Explanatory Notes explaining the fields in this Product Data Sheet.
- Surface Preparation Guidelines.
- Application Guidelines for different application methods.
- General Application Guidelines

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 (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 www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

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.

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.