



HEMUCRYL PRIMER HI-BUILD 18032

Description:	HEMUCRYL PRIMER HI-BUILD 18032 is a water-borne, acrylic dispersion paint with good anticorrosive properties. Especially suited for application by airless spray.
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
Certificates/Approvals:	Complies with EU Directive 2004/42/EC: subcategory i.
Availability:	Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade nos/Colours:	12170* / Grey.
Finish:	Flat
Volume solids, %:	43 ± 1
Theoretical spreading rate:	5.7 m ² /l [228.6 sq.ft./US gallon] - 75 micron/3 mils
Flash point:	73 °C [163.4 °F]
Specific gravity:	1.2 kg/litre [10.2 lbs/US gallon]
Surface dry:	0.5 approx. hour(s) 20°C/68°F
Dry to touch:	1.5 hour(s) 20°C/68°F
VOC content:	41 g/l [0.3 lbs/US gallon]

**other shades according to assortment list.*

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas.

APPLICATION DETAILS:

Application method:	Airless spray / Brush
Thinner (max.vol.):	Fresh water (5%) / HEMUCRYL BRUSH AGENT 99810 (3-8%)
Nozzle orifice:	0.015 - 0.019 "
Nozzle pressure:	130 bar [1885 psi]
Cleaning of tools:	Fresh water see REMARKS overleaf.
Indicated film thickness, dry:	75 micron [3 mils] see REMARKS overleaf.
Indicated film thickness, wet:	175 micron [7 mils]
Recoat interval, min:	According to specification.
Recoat interval, max:	According to specification.

Safety: 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:

New steel: 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 8501-1:1988). Apply immediately after cleaning. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to overcoating.

Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Remove rust and loose paint by abrasive blasting or power tool cleaning to St 3 (ISO 8501-1:1988) (minor areas) before recoating. For repair and touch-up use: HEMUCRYL PRIMER HI-BUILD 18030.

Aluminium: Very careful degreasing, followed by high pressure fresh water cleaning to remove all salts and other contamination. Any anodizing must be completely removed. Thorough sand papering or abrasive sweeping with mineral abrasives is recommended. Cast aluminium is recommended to be abrasive swept to a uniform, evenly grey appearance.

Hot dip galvanized steel: Wet rubbing/grinding with ammonia - water 1:20, followed by fresh water hosing. In case this method is not feasible, the procedure described for stainless steel may be used.

Stainless steel: Very careful degreasing followed by fresh water hosing to remove all contamination.

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above: 10°C/50°F. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity: During application: above 60%, preferably 40-60%.

Good ventilation during application and drying is necessary. During drying it is of utmost importance that sufficient ventilation is covering all parts of the surfaces painted. Ventilation requirements to remove the water vapours liberated during application and drying are approx. 75 m³/litre of paint at 20°C/68°F. (Relative humidity of the air supply 40%)

SUBSEQUENT COAT:

According to specification. Recommended systems are: HEMUCRYL ENAMEL HI-BUILD 58030

REMARKS:

VOC - EU Directive 2004/42/EC:

Product		5 vol. % thinning	Limit phase II, 2010
1803212170	41 g/l	82 g/l	140 g/l

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

Application(s)

The durability/performance of water-borne coatings is to a very high degree depending on the: fulfilment of good painting practice. For instance application to riveted and skip-welded constructions will require extra care when coating sharp edges, riveted joints, etc. Avoid too high thicknesses per coat. Preferably apply an extra stripe coat.

If the painted items will be exposed to humidity/water at temperatures below 5-10°C/40-50°F shortly after finishing the paint application, it is of utmost importance for later good performance that the following rules are complied with:

Excessive film thickness must be avoided. The (last applied) paint layer must dry for at least 6 hours at 20°C/68°F - 40-60% RH, 9 hours at 15°C/59°F - 40-60% RH before exposure to temperatures below 10°C/50°F and/or condensation/water exposure. Avoid outdoor application in seasons with low night temperatures especially in combination with condensation or rain.

Application equipment:

Brush application: 3-8 % by volume HEMUCRYL BRUSH AGENT 99810. Typical dry film thickness per coat: 30-40 micron/1.2-1.6 mils

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 recoating interval. Normal range dry is: 50-100 micron/2-4 mils. When used in 50 micron dry film thickness, 3-5% thinning will be necessary to secure proper film formation. For proper film formation the recommended nozzle sizes should be used.

"Edge effect":

As water-borne paints have a high tendency to "withdraw" from sharp edges, etc., proper corrosion protection will be highly supported by careful rounding of edges and that any joints are completely closed and tight.

Cleaning of tools:

Clean tools carefully with fresh water or lukewarm soap water immediately after use. Dried remains of paint can be removed with: HEMPEL'S TOOL CLEANER 99610

Storage Conditions:

Store at temperatures between 5-40°C/41-104°F. Shelf life is reduced at temperatures above 30°C/86°F. Do not expose to frost during storage and transport, or before the coating is dry.

Recoating intervals:

No maximum recoating interval, but after prolonged exposure to polluted atmosphere remove accumulated contamination by (high pressure) fresh water cleaning and allow to dry.

Nota:

HEMUCRYL PRIMER HI-BUILD 18032 For professional use only.

ISSUED BY:

HEMPEL A/S

1803212170

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on 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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