



Product Data

BAJATEX HI-BUILD 46410

Description:

BAJATEX HI-BUILD 46410 is a physically drying high build paint with good colour retention as a semi-flat finish. Based on acrylic resin, alkyd and non-chlorinated plasticizer. Contains zinc phosphate. Resistant to salt water, splashes of aliphatic hydrocarbons, animal and vegetable oils.

Recommended use:

1. As a primer, intermediate or finishing coat in BAJATEX-systems in moderately corrosive environment.
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.
3. As a finishing coat for containers.

Service temperatures:

Maximum, dry: 80°C/176°F (See REMARKS overleaf).

PHYSICAL CONSTANTS:

Colours :	Grey - Red
Finish:	Semi-flat
Volume solids, %:	42 ± 1
Theoretical spreading rate:	4.2 m ² /litre - 100 micron 168 sq.ft./US gallon - 4 mils
Flash point:	24°C/75°F
Specific gravity:	1.2 kg/litre - 10.0 lbs/US gallon
Surface dry:	1 (approx.) hrs at 20°C/68°F (ISO 1517)
Dry to touch:	4 (approx.) hours at 20°C/68°F
V.O.C.:	515 g/litre - 4.3 lbs/US gallon

APPLICATION DETAILS:

Application method:	Airless spray	Air spray	Brush/Roller
Thinner (max. vol.):	08080 (5%)	08080 (15%)	08080 (5%)
Nozzle orifice:	.017"-.021"		
Nozzle pressure:	175 bar/2500 psi (Airless spray data are indicative and subject to adjustment)		
Cleaning of tools:	THINNER 08080		
Indicated film thickness, dry:	100 micron/4 mils (See REMARKS overleaf)		
Indicated film thickness, wet:	225 micron/9 mils		
Recoat interval, min:	When dry (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 BAJAK Material Safety Data Sheets and follow all local or national safety regulations. This goes for personal protection such as, but not limited to, protection of lungs, eyes and of the skin, medical treatment in case of swallowing the paint or in case of other direct contact with the paint. Take necessary precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant.

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SURFACE PREPARATION:	<p>New steel: Remove oil and grease etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Abrasive blasting to Sa 2½. For temporary protection, if required, use suitable shopprimer. All damage of shopprimer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting. For repair and touch-up use BAJATEX HI-BUILD 46410.</p> <p>Repair and maintenance: Remove oil and grease etc. with suitable detergent. Remove salt 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 with BAJATEX HI-BUILD 46410 to full film thickness.</p>
APPLICATION CONDITIONS:	<p>As dictated by normal good painting practice.</p> <p>In confined spaces provide adequate ventilation during application and drying.</p>
PRECEDING COAT:	None, or according to specification.
SUBSEQUENT COAT:	None, or as per specification.
REMARKS:	
Colours:	Certain lead-free red and yellow colours may discolour when exposed to sulphide and chlorine-containing atmosphere.
Service temperatures:	As BAJATEX HI-BUILD 46410 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 recoating interval. Normal range is 75-125 micron/3-5 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 deckcoating, 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 BAJATEX HI-BUILD 46410 in excessive film thickness.
Deck coating:	If a skid-proof surface is desired, sprinkle BAJAK'S ANTI-SKID 67500 evenly on the first coat of BAJATEX HI-BUILD 46410 while still wet (consumption approx. 2.5 kg/5.5 lbs to 25 m ² /270 sq.ft.). When the paint is dry, sweep up surplus grit and apply a second coat of BAJATEX HI-BUILD 46410. Antiskid properties can also be obtained by mixing 1.0 kg of BAJAK'S ANTISKID BEADS 67420 into 20 litre of BAJATEX HI-BUILD 46410.
Recoating:	For multicoat application minimum recoating interval is 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:	BAJATEX HI-BUILD 46410 is for professional use only.