

## Hammercote Hammer Finish

<b>Product Description</b>	<b>A single pack, styrenated-alkyd hammer finish for metal.</b>				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• A one coat system* for the decoration and protection of metalwork, both interior and exterior</li> <li>• Non-yellowing, fast drying and oil and grease resistant when fully dried</li> <li>• Provides excellent protection for metal equipment such as tools, casings, metal furniture, gates and railings</li> <li>• High film build by brush</li> </ul>				
<b>Approvals/ Certification</b>	Please consult Axalta Coating Systems				
<b>Finish</b>	Gloss				
<b>Volume Solids</b>	42 ± 2% (varies with colour)				
<b>VOC Content</b>	499 ± 20 g/litre (varies with colour)				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Minimum</b>	50 µm	119 µm	8.4 m <sup>2</sup> /litre	
	<b>Maximum</b>	100 µm	238 µm	4.2 m <sup>2</sup> /litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
<b>Drying Times</b>	Applied to 50 microns DFT	<b>+10°C</b>	<b>+23°C</b>	<b>+35°C</b>	
	<b>Dust Free</b>		45 min	15 min	10 min
	<b>Hard Dry</b>		5 hr	3 hr	2 hr
	<b>Overcoating</b>	Minimum	2 hr	1 hr	1 hr
		Maximum	Before 36 hrs or after 6 weeks		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
<b>Colours</b>	Limited range of metallic finishes				
<b>Product Code</b>	<b>02HFE</b>				
<b>SG</b>	0.97 kg/lit (varies with colour)				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 12 months if stored as above in unopened containers				
<b>Flash Point</b>	23-60°C				

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all loose flaking paint, dirt, rust, oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li> <li><b>Clean Steel:</b> prepare to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface. Smooth steel will need to be abraded to provide a key</li> <li><b>Rusted steel:</b> should be prepared as above, thoroughly washed with clean water and allowed to dry, to remove corrosion salts. Any flash rusting should then be removed before painting</li> <li><b>Non-ferrous metal:</b> an etch primer will be required – please consult Axalta Coating Systems for advice</li> </ul>											
<p><b>Mixing</b></p>	<p>Must be mixed thoroughly before use. Agitate periodically to ensure paint remains homogeneous</p>											
<p><b>Thinner</b></p>	<p>No.4 Thinner</p>		<p><b>Equipment Cleaner</b> No.4 Thinner</p>									
<p><b>Application Conditions</b></p>	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C</p>											
<p><b>Application Methods</b></p>	<table border="1"> <thead> <tr> <th data-bbox="451 1048 675 1115">Method</th> <th data-bbox="675 1048 940 1115">Airless Spray</th> <th data-bbox="940 1048 1166 1115">Conventional Spray</th> <th data-bbox="1166 1048 1339 1115">Brush</th> <th data-bbox="1339 1048 1490 1115">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 1115 675 1171"></td> <td data-bbox="675 1115 940 1171">Yes</td> <td data-bbox="940 1115 1166 1171">Yes</td> <td data-bbox="1166 1115 1339 1171">Yes</td> <td data-bbox="1339 1115 1490 1171">Yes</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes	<ul style="list-style-type: none"> <li>Brush or roller application is recommended – brush for small areas, roller for larger areas with edges cut-in by brush. For brush, one generous coat is recommended, for roller 2 to 3 coats are likely to be required</li> <li>Airless Spray: output fluid pressure at tip 1800-2200 psi, Tip Size 13-17 thou (0.33-0.43 mm). Thinning up to 10% may be required, more if cobwebbing occurs</li> <li>Conventional spray: typical atomising pressure 30-45 psi, 1.4-1.8mm nozzle. Thinning up to 25% may be required. Two coats are recommended with a minimum of 1 hour between coats</li> </ul>
Method	Airless Spray	Conventional Spray	Brush	Roller								
	Yes	Yes	Yes	Yes								
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li>*While many Hammer finishes are applied as one coat systems, two coats are recommended to a minimum of 100um dft for best exterior protection</li> <li>Best results are obtained when multiple coats are applied as soon after the minimum overcoating time as possible. If overcoating does not take place within 36 hours (at 20°C) the product should not be overcoated for at least 6 weeks</li> </ul>											
<p><b>Health &amp; Safety</b></p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>											

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