

Stokes Hammer Finish

Product Description	A single pack, modified-alkyd hammer finish for metal.				
Features & Use	<ul style="list-style-type: none">A one coat system* for the decoration and protection of metalwork, both interior and exteriorGood flexibility and adhesionFast drying with good gloss and opacityThe hammer finish helps obscure substrate imperfectionsProvides good protection for metal equipment such as metal fabrications, castings, tools, casings, gates and railings				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Gloss				
Volume Solids	34 ± 2% (varies with colour)				
VOC Content	560 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	25 µm	74 µm	13.6 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 25 microns DFT		+10°C	+23°C	+35°C
	Dust Free		45 min	20 min	10 min
	Hard Dry		5 hr	2 hr	1 hr
	Overcoating	Minimum	3 hr	2 hr	1½ hr
		Maximum	Before 4 hrs or after 4 weeks		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Limited range of metallic finishes				
Product Code	20HAF				
SG	0.98 kg/lit (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	Below 23°C – low flash material				

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Surface Preparation	<ul style="list-style-type: none"> 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 Clean Steel: 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 Rusted steel: 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 Non-ferrous metal: an etch primer will be required – please consult Axalta Coating Systems for advice 				
Mixing	Must be mixed thoroughly before use. Agitate periodically to ensure paint remains homogeneous				
Thinner	TH130 Thinner Equipment Cleaner TH130 Thinner				
Application Conditions	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				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes	Yes	No
	<ul style="list-style-type: none"> Brush is suitable for small, horizontal areas. Spray application will give a better finish. Roller is not recommended 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 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 2 hours between coats 				
Product Notes	<ul style="list-style-type: none"> *While many Hammer finishes are applied as one coat systems, two coats are recommended to a minimum of 50um dft for best exterior protection This is a low flash material - ventilate to keep solvent vapour levels below minimum explosive limit and observe low flash regulations 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 4 hours (at 20°C) the product should not be overcoated for at least 4 weeks Paint temperature must be at least 5°C on application, above 10°C is recommended 				
Health & Safety	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.				

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