



HAMMERTONE ENAMEL

General Description:

HAMMERTONE ENAMEL is based on styrene modified alkyd resin and special synthetic additives and pigments.

Major Uses:

A special effect HAMMERTONE ENAMEL on steel structures, machineries, outdoor furniture and appliances. This hammertone enamel provides fast drying and good hold out properties.

Advantages:

- Enhances the beauty of surfaces and provides excellent outlook.
- Prolongs the life span of steel.
- Compatible to oil – based primers.

Characteristics and Physical Properties:

Color	6 Basic Colours
Gloss	Semi - gloss
Flash Point	23 ⁰ C
Volume Solids	35% +/- 2
Specific Gravity	1.0 – 1.05
Coverage	12 – 14 m ² / lit.
Dft.	23 – 27 microns.

Application Details:

Method of Application	Conventional Spray.
Nozzle Orifice	1.4 – 2.0mm
Nozzle Pressure	40 – 55 psi.
Thinner / Dilution	Thinner # 255
Application Conditions	Temperature of the substrate should be minimum 3 ⁰ C.

Surface Preparation:

New Steel / Shop Primed:

Abrasive blasting to minimum Sa 2 ½. If sandblasting is not possible, power tool cleaning or wire brushing is recommended to minor touch – up. All damaged primers and contamination should be

The above information is given to the best of our knowledge based on laboratory test and practical experience. However, as the paint is often used under condition beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without prior notice.

removed and thoroughly cleaned prior to final painting. Apply quick drying primer before application of HAMMERTONE ENAMEL.

Maintenance:

Remove oil, grease and other contaminants prior to final top coating.

Drying Time:

The drying time is evaluated according to ASTM D 1640 at room temperature. However, the drying time varies on the film thickness, number of coats and temperature.

Dry Hard	@25 ⁰ C	25 – 30 mts.
Dry to Touch	@25 ⁰ C	10 – 15 mts.
Dry to Recoat	@25 ⁰ C	30 mts.

Typical Recommended System:

Quick Drying Primer	1 Coat @25microns.
HAMMERTONE ENAMEL	1 Coat @25microns

Storage:

HAMMERTONE ENAMEL should be kept in cool place below 25⁰C. Keep in tightly closed container.

Cleaning of Tools:

All tools should be cleaned with Wash Thinner or PU Thinner # 105 as soon as possible.

Packing:

Available in 1 Usg, 20lit Pail, and 200lit Drum.

Precautions:

HAMMERTONE ENAMEL does not contain dangerous solvents, nevertheless, good ventilation in working rooms is recommended as well as the use of safety tools and equipment. HAMMERTONE ENAMEL is flammable and harmful if swallowed. If contact with eyes or skin occurs, wash well with fresh water and seek immediate medical advise.

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