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HAMMERCOTE HAMMER FINISHES

PRODUCT DESCRIPTION

A high quality styrenated alkyd based enamel available as a hammered metallic finish or a smooth finish. It is a one coat system ideally suited for the decoration and protection of metal work. It is non yellowing, fast drying and oil and grease resistant when fully dried. A colours are lead free.

USES

Provides excellent protection for all metal equipment such as tools, casings, metal furniture, gates and railings, interior and exterior. High film build when brushing ensures excellent corrosion resistance.

TECHNICAL PROPERTIES

Colour	8 colours + specials and 3 smooth colours		
Finish	Full Gloss		
Curing Agent	-		
Mix Ratio	-		
Specific Gravity	0.97		
Volume Solids	50%		
Recommended Film Thickness	100-200 μ WFT / 50-100 μ DFT		
Theoretical Spreading Rate	5-10 m ² /litre		
Application Method	Brush, Roller, Spray		
Flash Point	23°C		
VOC	440 g/litre		
Drying Times	10°C	20°C	30°C
Touch Dry	45 minutes	15 minutes	10 minutes
Hard Dry	5 hours	3 hours	2 hours
Minimum Overcoat	2 hours	1 hour	1 hour
Maximum Overcoat*	36 hours	36 hours	36 hours

**Recoating after 36 hours will cause the film to wrinkle. Best results seen when all coats are applied in quick succession.*

After 36 hours, Hammercote cannot be recoated for up to 6 weeks.

CERTIFICATION/APPROVALS

RECOMMENDED SYSTEMS

One coat system, but may need Etchcote TW or Etch Primer (2K)

SURFACE PREPARATION

Ferrous Substrates

Ensure surfaces are clean, dry and free from dirt, grease and other contamination. Remove all loose flaking paint, dirt, rust and mill scale by mechanical methods. Minimum standard for adequate performance ST2. The better the surface preparation, the better the protection

Smooth steel will need abraded with medium or coarse grade emery or aluminium oxide paper to provide a key. Remove any dust, dirt and degrease with Thinner No.3 Allow to dry before painting.

Galvanised and Aluminium Surfaces

Ensure surfaces are clean, dry and free from dirt, grease and other contamination.

On galvanised surfaces, apply Etchcote TW. Allow to dry before painting.

On aluminium surfaces, apply Etch Primer (2K). Allow to dry before painting.

PRODUCT APPLICATION

Mixing

Stir thoroughly before use.

Thinners

Thinner No.4

Brush

Small areas only. Apply one thick coat for maximum protection.

Roller

Suitable for larger areas. Edges should be brushed in and remaining areas filled quickly with the roller. 2-3 coats are recommended.

Conventional Spray

Thin with 20-25% Thinner No.4 and apply two heavy coats allowing minimum 1 hour between applications. Use 30-45 psi pressure and 1.4-1.8 diameter nozzle.

Airless Spray

Thin up to 10% Thinner No.4 Use tip 0.33-0.43mm, 50-65° angle and 2000 psi pressure. If cobwebbing occurs add more thinners.

Air Assisted Airless Spray

Thin with 20-25% Thinner No.4. Use 1000-1500 psi pressure and 1.4-1.8 mm nozzle.

Cleaner

Thinner No.4

Cleanup Considerations

All equipment should be cleaned immediately after use with Thinner No.4.

It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied.

Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited.

The user must observe local health, safety and environmental regulations when using this product.

Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

PACK SIZES

1, 2½, 5 litre

PACK WEIGHTS

1 litre : 0.97 kg. 2½ litre : 2.43 kg. 5 litre : 4.85 kg.

STORAGE CONDITIONS

Store away from extremes of temperature.

LIMITATIONS

After 36 hours, recoating will cause the film to wrinkle. Leave for minimum 6 weeks before overcoating.

Do not apply when RH exceeds 88% or the surface is less than 2°C above dew point. Drying will be affected in cold conditions.

DISCLAIMER

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It is the user's responsibility to ensure that this sheet is current prior to using the product.