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Date Issued: 2 November, 2009

HAMMERFINISH

Product Line: 69

Product Code: 69XX04; 69XX20 where XX represents digits for colour codes.

Description

Hammerfinish is based on co-polymer resins and quality aluminium paste of high opacity and colour retention. Features include fast drying and outstanding adhesion, excellent spraying characteristics with one coat finish.

Hammerfinish is used as a finishing coat over a range of quick drying metal primers or bare metal. Suitable for use on structural steel, sheetmetal, agricultural implements, machinery etc. wherever a high quality durable finish is required while minimising surface marks and defects.

Typical recommended coating systems

Surface	Classification	Preparation	System	Dry Film Thickness	Recoat
Structural Steel	Value system	Abrasive blast clean to AS1627.4 Class 2	First Coat EasiSpray Metal Primer Top Coat Hammerfinish	40 – 50 µm 40 – 45 µm	Min. 4 hrs
Mild Steel	Value system	Remove rust, clean and degrease with Wax & Grease Remover	First Coat EasiSpray Metal Primer Top Coat Hammerfinish	40 – 50 µm 40 – 45 µm	Min. 4 hrs
Galvanised, zinc coated steel and aluminium	Value system	Clean and degrease with Wax & Grease Remover. Lightly abrade aluminium with a nylon scourer.	First Coat Etch Primer Second Coat EasiSpray Metal Primer Top Coat Hammerfinish	5 – 10 µm 30 – 40 µm 40 – 45 µm	Min 2 hrs Min 16 hrs

Thin/ cleanup EasiSpray Metal Primer and Hammerfinish* with Fast, Medium or Slow Thinners.
 Thin/cleanup Etch Primer with Etch Primer Thinners.
 Refer individual Technical Data Sheets/ MSDS for specific product above.

NOTE: * Hammerfinish is not recommended to be thinned prior to use.

Surface Preparation

Steel

Excellent performances will be achieved by abrasive blast cleaning to AS1627.47 Class 2. However, good results can be achieved in mild exposure conditions on power or hand tooled cleaned surfaces to AS1627.2 or AS1627.7. Prime with Easi Spray Metal Primer to 40 - 50 microns.

Mild Steel

Remove light surface rust with a rust converter or clean and degrease with Wax and Grease Remover. Prime with Easi Spray Metal Primer to 40 - 50 microns. Wet sand with 320 grade paper if required.

Galvanised and Zinc Coated Steel, Aluminium and most non ferrous metals.

Clean with Wax and Grease Remover. Prime with Etch Primer to 5 -10 microns dry film thickness. Apply an intermediate coat of Easi Spray Metal Primer 40 - 50 microns. Wet sand with 320 grade paper if required.

Refinishing

Hammerfinish may be applied directly over bare steel or suitably primed substrates. Hammerfinish when applied over a primer will improve the exterior durability of the coating system.

Mixing Instructions

Stir thoroughly until uniform consistency.

Application

Brush or Roller

Not Suitable



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Airless Spray

Thin approximately 5%max. Tip orifice 0.013" to 0.015". Apply at 14 to 17 Mpa atomising pressure. Apply single coat to a dry film thickness of 40 - 45microns.

Conventional Spray

Apply at air atomising pressure of 340 to 420kPa.

Apply a tack coat of Hammerfinish over the surface to be coated. Allow this coat to flash off then apply a full coat wet on wet application evenly over the surface. DO NOT THIN OTHERWISE PATTERN WILL BE ADVERSELY AFFECTED. (LOSS OF PATTERN)

Do not apply Hammerfinish below 10°C or above 85% relative humidity.

Recoating Time

If required, Hammerfinish must be recoated within 4 hours.

Thinner and Cleaner

Slow, Medium or Fast Thinner.

Approximate Coverage

Practical at 35 micron dft	Airless spray	9.6m ² /L
	Conventional spray	8.6m ² /L

Properties

Colour:	Silver and a limited range of Colours. Note: Colours specified, as containing tint will change drying times depending on tint loading.
Gloss:	High Gloss >65% @ 60°
Drying time:	Approximate air drying times at 25°C and 25 microns
Dust free:	4 - 6 minutes
Tack free:	15 - 20 minutes
Print free:	35 - 45 minutes
Hard Dry:	12 -16 hours
Recoating Time:	<4 hours
Solids:	By weight approximately 38% By volume approximately 31%
Weight per Litre:	Approximately 0.97 kg.
Shelf life:	18 months
Flash Point:	24°C
Durability:	Excellent Interior/ Moderate Exterior
VOC:	Approximately 595 grams per litre
Resistance Properties:	
Abrasion:	Moderate
Heat:	Up to 120°C dry heat
Solvent:	Moderate for intermittent exposure
Oil and Petrol:	Fair
Chemical:	Limited.

Precautions

Hammerfinish is specifically designed for industrial purposes and is not recommended for any other purpose where human consumption is intended.

Hammerfinish contains flammable solvents. Keep away from heat and open flame. When applying in confined spaces use an airline respirator.

Hammerfinish contains paint incompatible silicones and a separate spray gun should be used solely for applying hammerfinish-type paints.