



HAMMERITE FINISH – BRUSHING

HMT4

PRODUCT INFORMATION

Typical Use	<p>Hammerite Hammered Finish paint is a single pack, air-drying corrosion-resistant and decorative coating. It is based on synthetic resins, fast drying solvents and is suitably pigmented for optimum weathering properties.</p> <p>Hammerite Finish is quick drying and capable of multi-coat application in a few hours. The specially selected resins impart a gloss or satin finish which resists dirt pick up. Hammerite Finish has excellent wetting properties making it tolerant to poorly prepared ferrous surfaces.</p> <p>For use as a corrosion resistant and decorative coating for ferrous and non-ferrous metals, wood and certain plastics.</p> <p>Before preparing any surface for painting, read the Safety, Health and Environmental information on page 4 about old lead-based paints.</p>
Appearance	Available in three finishes – hammered, smooth and satin.
Pack Size	<p>Tins: 250ml, 500ml, 1ltr, 2.5 ltrs and 5 ltrs.</p> <p>Aerosol: 400ml</p>
Colour Range	<p>See colour chart.</p> <p>Note: Hammerite Hammered, Smooth and Satin Finishes are produced to Hammerite Products Limited's own in-house colour standards and are not matched to BS 4800 or RAL.</p>
Composition (nominal)	<p>Pigment: Organic / inorganic pigments.</p> <p>Binder: Styrenated oil modified alkyd.</p> <p>Solvent: Aliphatic and aromatic solvents.</p>
Volume Solids	50%
Thinning	Hammerite Brush Cleaner and Thinners.
Application Method	<p>Brush.</p> <p>Temperature Range 8-25 degC (46 – 77 degF).</p> <p>Max Relative Humidity: 85%.</p> <p>Substrate Temperature: 3 degC above dew point temperature.</p>
Film Thickness	<p><i>Film thickness will be dependent on the coverage achieved.</i></p> <p>Wet: 200 microns (0.008”).</p> <p>Dry: 100 microns (0.004”).</p> <p>Note. The number of coats required to achieve this will vary depending on the substrate and method of application.</p>
Drying Times	<p><i>Under good drying conditions:</i></p> <p>Touch Dry: 60 Minutes.</p> <p>Tack Free: 90 Minutes.</p> <p>Recoat: When touch dry but within 8 hours.</p> <p>Painting must be planned so that each coat of Hammerite Hammered Finish is applied within eight hours of the previous coat. After this period curing begins and Hammerite Hammered Finish cannot be recoated for two weeks. If recoated within this period wrinkling may occur.</p>
Practical Coverage	Brush: 4.5sq. metres / litre.
Cleaning Up	<p>After use, clean equipment with Hammerite Brush Cleaner and Thinners.</p> <p>Note: DO NOT use cellulose thinners or white spirit.</p>

SURFACE PREPARATION

FOR ALL METAL SURFACES:

Recommended standard for optimum performance - St 2 (Swedish Standard SIS 05 59 00). This should be achieved by abrasion with coarse emery paper or needle gun/grinder, where applicable. All surfaces must be dry and free from dirt, dust, grease and salt.

BARE METAL SURFACES:

Degrease with **Hammerite** Brush Cleaner and Thinners.

PAINTED METAL SURFACES:

Abrade the painted surface to provide a mechanical key. Wash down thoroughly with diluted detergent to remove contaminants. Rinse with clean water and allow to dry.

Test for compatibility with existing paint by painting a small test area first. Any compatibility problems will be evident within the first hour after application.

SHINY, SMOOTH METAL SURFACES

Extra abrasion is required to ensure maximum adhesion. Degrease with **Hammerite** Brush Cleaner and Thinners.

UNPAINTED GALVANISED / ALUMINIUM / NON FERROUS METAL SURFACES

To ensure maximum adhesion on aluminium and non ferrous metal surfaces use **Hammerite** Special Metals Primer.

Notes:

In many areas, industrial and coastal districts in particular, soluble salts may contaminate the substrate. It is essential to scrub and rinse repeatedly with clean water to remove this contamination.

Extremely rough, abrasively painted or pitted ferrous metals will benefit from the application of **Hammerite** No. 1 Rust Beater before using **Hammerite** Hammered Finish.

OTHER SURFACES:

PLASTICS

Hammerite metal finishes may be used on certain types of plastic such as drainpipes and guttering.

WOOD

Bare Wood: - Apply a water based acrylic wood primer before applying **Hammerite** Hammered Finish.

Painted wood: - Abrade the painted surface to provide a mechanical key.
- Wash down thoroughly with diluted detergent to remove contaminants.
- Rinse with clean water.
- Allow to dry.

Brush - Suitable for small flat areas and intricate wrought ironwork.

Use as large a brush as possible and cover the area quickly.

Do not over-mix. If separation has occurred gently mix in with a brush.

It is essential to get the recommended film build.

Several thin coats are recommended, particularly on intricate vertical surfaces.

Ensure edges and corners are adequately covered.

SYSTEM INFORMATION

APPLICATION

Brush - Suitable for small flat areas and intricate wrought ironwork. Use as large a brush as possible and cover the area quickly. Do not over-mix. If separation has occurred gently mix in with a brush. Thick coverage is essential, however, **Hammerite** Hammered Finish will sag if over applied. An extra coat may be required on intricate vertical surfaces. Ensure edges and corners are adequately covered.

Roller - Suitable for larger flat areas. Thin **Hammerite** Hammered Finish with **Hammerite** Brush Cleaner and Thinners at a ratio of 9 parts paint to 1 part thinners.*

Use a short pile mohair roller, as other types of roller may not be suitable. The edges should be brushed in first and the remaining areas quickly filled with the roller.

* Use only **Hammerite** Brush Cleaner and Thinners. Cellulose thinners and white spirit are not suitable.

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STORAGE

- Tins:** Hammerite Hammered Finish should be stored in a dry, well ventilated area. Protect from extremes of temperature, ie frost and strong sunlight.
- Aerosol:** Pressurised container - protect from sunlight and do not expose to temperatures exceeding 50°C (120°F). Do not pierce or burn even after use.

SHELF LIFE

- Tins:** Minimum two years at 20°C (70°F) stored in original unopened containers.
- Aerosol:** Minimum two years at 20°C (70°F) in original unopened containers.

LIMITATIONS

- NOT suitable for:** Contact with potable water / foodstuffs.
Permanent immersion

PERFORMANCE

- Corrosion Resistance:** Passes more than 1000 hours ASTM B117 1973 at 100 microns (0.004") dry film thickness on ASTM D609, Type 2 A366 steel panels.
- Impact Resistance:** Passes 15cm (face) BS3900, E7 falling ball 15"/lb 7 days at 100 microns (0.004") dry film thickness.
- Adhesion:** Passes 1 BS 3900 E6, 7 days at 100 microns (0.004") dry film thickness.
- Chemical Resistance:** Resists splashing by dilute acids/alkalis (10% max), petrol, diesel and all common building materials when fully cured.

Note: Not suitable for immersion.

- Temperature Resistance:** *Intermittent Use:* Minus 30 degC (minus 22 degF) upto 150 degC (302degF) maximum.
Continuous Use: Recommended maximum 80 degC (176 degF).

Viscosity: 5.0 poise - 7.0 poise at 25°C (ICI cone and plate viscometer) depending on colour/finish.

Specific Gravity: 0.97 - 1.17 at 20°C depending on colour/finish.

COMPATABILITY Test for compatability with existing paint by painting a small test area first. Any compatability problems will be evident within the first hour after application.

SAFETY, HEALTH & ENVIRONMENTAL INFORMATION

SOLVENT-BASED PAINT

FLAMMABLE

Repeated exposure may cause skin dryness or cracking.

Vapours may cause drowsiness and dizziness.

Harmful to aquatic organisms, may cause long-term adverse effects in the aquatic environment.

Keep away from sources of ignition. No smoking.

Contains white spirit. Use only in well ventilated areas. Inside always keep doors and windows fully open during application and drying. When applying by brush or roller to large interior surfaces or in confined spaces, wear a suitable cartridge respirator or air fed respiratory protective equipment. Refer to your COSHH Assessment.

Avoid contact with skin and eyes. When applying it is advisable to wear eye protection. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice. After contact with skin, wash immediately with plenty of soap and water or a proprietary skin cleanser. Do not use solvent, thinners or white spirit.

Keep out of the reach of children. Do not use or store by hanging on a hook. Do not empty into drains or watercourses. Some local authorities have special facilities for disposing of waste paint.

Avoid release to the environment. Before use refer to safety data sheet.

Avoid the inhalation of dust. Wear a suitable face mask if dry sanding.

This product contains no added lead. However, the wood and metal surfaces of the building, especially if it is pre-1960, may have been decorated in the past with a paint made with lead pigments. Preparation and removal of such paint can be hazardous. For a free leaflet explaining how the surface should be prepared safely contact:

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