



810 Hammerlon Enamel

PRODUCT DESCRIPTION & USES

810 Hammerlon Enamel is a fast drying, easy to apply hammer patterned industrial enamel. **810 Hammerlon Enamel** provides a very attractive finish with wide commercial application for the finishing of metal and timber where a unique decorative effect is required. The hammer finish disguises weld joints and minor surface imperfections providing a professional finish to a wide variety of metal objects.

PRODUCT FEATURES

- Fast drying with an excellent “hammer” pattern.
- Easy application by conventional or electrostatic spray.
- Formulated for interior use, but will give good medium term exterior durability.
- May be applied directly to steel, although best results will be obtained by applying over a suitable primer in a similar colour to the Hammerlon Enamel colour.
- Made in New Zealand for New Zealand conditions.

TECHNICAL DATA

Gloss Level	Glossy with a ‘hammer’ texture
Primer	875 AE12 Etch Primer for metal substrates. 930 Customwood Sealer for timber substrates.
Wash Up	002-005 G5 Thinners
Colours	Blue, Black, Charcoal Grey, Green and Silver. Special colours by application.
Pack Size	4L, 20L
Storage Temperature	5°C - 50°C
Shelf Life	Minimum 2 years.
Toxicity	Formulated without added lead or mercury. Dried film is non-toxic.
VOC content	600g/L as per EC-07-09 and APAS definition of Volatile Organic Compound.
Flash Point (Closed Cup)	4°C
Volume Solids	31%
Wet Film Thickness	83-100µ per coat
Dry Film Thickness	26-31µ per coat
Coverage	10-12 m ² /L depending on surface texture and method of application.

SUBSTRATE PREPARATION INSTRUCTIONS

General Surface Preparation: Surfaces to be painted must be clean with all traces of grease, oil and dirt removed. Remove all loose material, corrosion and any salt deposits. Clean surfaces with a mild detergent solution using a bristle brush. Rinse thoroughly. Use **G5 Thinners** for degreasing.

RECOMMENDED APPLICATION METHODS AND TECHNIQUES

CAUTION: The hammer effect is achieved by the addition of hammer finish silicones. To ensure there is no contamination of subsequently applied non-hammer spray finishes it is recommended that dedicated stirrers, pots and spray equipment be used when applying **810 Hammerlon Enamel**.

Mix the contents in the can thoroughly before use.

Apply a mist coat followed by a coarsely atomized coat of **810 Hammerlon Enamel** applied wet on wet. The hammer pattern forms as the coarse droplets of paint coalesce.

Thin, if required for ease of application, with up to 5% **002-005 G5 Thinners**. When applied over **930 Customwood Sealer** add 5% **002-000 Lacquer thinners** to ensure adhesion.

Minimum Surface Temperature: 5°C

Maximum Relative Humidity: 75%

Temperature Range: 5°C - 35°C

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Suitable Application Methods:	Conventional Spray equipment
Thinners:	002-005 G5 Thinners. When applied over 930 Customwood Sealer add 5% 002-000 Lacquer thinners to ensure adhesion.
Cleaning Solvent:	002-005 G5 Thinners.
Max. Volume Thinners:	5%
Fluid Nozzle:	1.5 – 2.0 mm
Pressure to gun:	30 – 40 psi (210 - 350 kPa)

DRYING CHARACTERISTICS

All figures quoted are at 20°C and 65% relative humidity.

Drying will take longer at lower temperatures and/or at higher relative humidity.

Do not paint when temperature of surface is below 5°C, above 35°C or when humidity is very high.

Do not apply when rain or dew is expected within 4 hours.

Touch Dry; 30 minutes

Recoat: 1 hour

Full Cure: 2-3 hours

HEALTH & SAFETY

CAUTION! FLAMMABLE

Contains petroleum solvents: keep away from heat and open flame. Close container when not in use.

KEEP OUT OF REACH OF CHILDREN

WARNING: This material may be harmful if swallowed or inhaled and may cause skin or eye irritation.

PRECAUTIONS: Avoid breathing vapour -- use with adequate ventilation. Do not eat, drink, or smoke whilst using. Store in a cool, well ventilated area indoors between 5°C - 20°C. Dispose of empty container safely. Empty cans or cans containing dry material may be recycled. Do not contaminate any water supply.

FIRST AID

If Swallowed: Give water to dilute. Owing to the aspiration hazard of hydrocarbon solvents, DO NOT CAUSE VOMITING. Get medical attention without delay.

Eye Contact: Treat immediately with water -- hold open and flush for at least 15 minutes. Get medical attention if irritation persists.

Skin Contact: Remove any contaminated clothing and wash skin thoroughly with soap and water. Avoid scrubbing skin.

Inhalation: Leave the hazard area, maintain breathing and get medical attention.

FIRE: Use foam, carbon dioxide or dry chemical powder.

SPILLS: Absorb with sand or earth. Collect and seal in properly labelled drums for disposal according to local waste management authority.

Refer MSDS, available on request, for detailed safety instructions.

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