



## DIRECT TO RUST HAMMERED/SMOOTH



### PRODUCT USES

As a corrosion resistant and decorative coating for ferrous and non-ferrous metals, wood and certain plastics.



### FEATURES AND BENEFITS

It is based on synthetic resins and is suitably pigmented for optimum weathering properties.

It is fast drying and capable of multi-coat application.

The selected resins impart a gloss or satin finish which resists dirt pick up.

Hammerite has excellent wetting properties making it tolerant to poorly prepared ferrous surfaces.



### PRODUCT INFORMATION

<b>Appearance</b>	<b>Smooth:</b> a smooth gloss <i>Gold, Silver and Copper are metallic sheen finishes.</i> <b>Hammered:</b> a smooth gloss incorporating a hammered pattern <i>Pattern will vary depending on temperature, colour, substrate and method of application.</i>
<b>Colour</b>	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 standards.
<b>Colour Mixing</b>	<b>Hammered colours:</b> can be intermixed though the pattern may be affected. <b>Smooth colours:</b> can be intermixed except for Smooth Gold, Silver and Copper. Do not intermix Hammerite Hammered and Smooth
<b>Viscosity</b>	5.0 poise - 8.0 poise at 25°C (ICI cone and plate viscometer) depending on colour/finish.
<b>Specific Gravity</b>	0.96 - 1.10 at 20°C depending on colour/finish
<b>Film Thickness</b>	Wet: 200 microns    Dry: 100 microns <i>The number of coats required to achieve this will vary depending on substrate and method of application.</i>
<b>Spreading Rate</b>	Up to 5 m <sup>2</sup> per litre for 2 coats at recommended dry film thickness (brushing).
<b>VOC Levels</b>	EU Category A 500g/L (2010)



### APPLICATION INFORMATION

<b>Application conditions</b>	Minimum application temperature: 3°C above dew point Ideal Conditions: 8 - 30°C Maximum Relative Humidity: 85% Apply at least 2 coats
<b>Application methods</b>	Brush, roller, conventional spray or airless spray
<b>Drying Time</b>	Touch / Surface Dry: 2 hours approximately
<b>Recoating Time</b>	After 4 hours
<b>Cleaning of Equipment</b>	Use <b>Hammerite Brush Cleaner</b>

A corrosion resistant and decorative coating for ferrous and non-ferrous metals, wood and certain plastics





250ml  
500ml  
1L  
5L



400ml



## APPLICATION INFORMATION

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

Stir before use.

At least 2 coat coverage is essential to bare or rusty metal to achieve film thickness for corrosion resistance, however Hammerite paint will take longer to dry and sag if over applied.

Ensure edges and corners are adequately covered, these are at greatest risk of premature rusting.

### Roller - Suitable for larger flat areas.

Hammerite is designed to be ready for use.

Hammerite paint can be thinned to ease roller application. Use **Hammerite Brush Cleaner** or white spirit at a ratio of 9 parts paint to 1 part **Brush Cleaner**.

The edges should be brushed in first and the remaining area's quickly filled in with the roller.

For best results apply liberally using short, quick strokes.

### Spray - Suitable for large flat and uneven surfaces

The following contain silicones:

Hammered finish - all colours

Smooth finish - gold, silver and copper.

### Conventional Spray

Thin Hammerite metal finish with 15% **Hammerite Brush Cleaner** and **Thinners**.

Set professional spray gun to between 25/35 psi (approx. 2 Bar).

Use a full fan spray at maximum spray volume.

Apply 3-4 thin coats in quick succession allowing approximately 1 hour between coats. The final coat should be sprayed heavily enough to flow to a glossy finish avoiding runs and sags.

### Airless Spray

If necessary Thin Hammerite metal finish with 15% **Hammerite Brush Cleaner** and **Thinners**.

Fluid pressure: 2500 - 3000 psi (approx. 170 Bar). Nozzle size: 375-500 microns/0.015 - 0.020".

Apply 2-3 coats, leaving each coat for approximately 1 hour or until it is touch dry before applying further coats.

### For both Conventional spray and Airless spray:

Shake spray gun before and during use to ensure an even colour.

For best results use only **Hammerite Brush Cleaner** and **Thinners**.

### Aerosol - Suitable for touch up/small applications.

Store aerosol at room temperature for 2 hours prior to use.

Shake can vigorously for a full 3 minutes after the agitator ball is heard. Use a vertical rather than a horizontal motion.

Apply light even coats from a distance of approx. 15 cms (6"). To avoid runs and sags keep the aerosol moving. Do not concentrate the spray in any one spot.

Several thin coats are recommended, particularly on intricate and vertical surfaces. Allow approx. 15 minutes between coats.

To avoid blockages, invert can and spray for 2 seconds between coats and after final use.



## SURFACE PREPARATION

### BARE METAL SURFACES

Degrease with Hammerite Brush Cleaner.

### PAINTED METAL SURFACES

Abrade the painted surface to remove contaminants/gloss. Wash down thoroughly with diluted detergent.

Rinse with clean water. 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

Abrasion is required to ensure maximum adhesion.

Degrease with **Hammerite Brush Cleaner** and **Thinners**, a proprietary metal degreaser or diluted detergent both for removal of surface contaminants and soluble salts.

Rinse with clean water. Allow to dry.

Apply a phosphoric acid etch primer (mordant solution) to convert the galvanised steel zinc surface before application of **Direct to Galvanised**.

### RUSTED METAL SURFACES

Minimum standard for adequate 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 loose rust, dirt, dust, grease and salt.

### UNPAINTED GALVANISED / ALUMINIUM / NON-FERROUS METAL SURFACES

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

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 or pitted ferrous metals will benefit from the application of **Hammerite No.1 Rust Beater** before using **Hammerite** paint.

### PLASTICS

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

### WOOD

**Bare wood:** apply a suitable water based acrylic wood primer before applying Hammerite paint.

**Painted wood:** Abrade the painted surface to remove contaminants or gloss.

Wash down thoroughly with diluted detergent.

Rinse with clean water. Allow to dry.



## ADDITIONAL INFORMATION

### Storage Conditions and Shelf Life

Minimum 2 years at 20°C stored in original unopened containers.

**Tins:** Hammerite paint should be stored in a dry, well ventilated area. Protect from extremes of temperature.

**Aerosol:** Pressurised container - protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn even after use.

### Limitations Not suitable for:

Use on equipment operating at or above 150°C  
Contact with potable water / foodstuffs  
Permanent immersion

**Impact Resistance** Passes 15cm (face) BS3900, E7 falling ball 15"/lb 7 days at 100 microns dry film thickness.

### Temperature resistance range when fully cured

Intermittent use: Minus 20°C up to 150°C maximum  
Continuous use: 80°C

*Colours may fade after prolonged exposure at temperatures exceeding 50°C.*

### Chemical resistance when fully cured

Resists splashing by dilute acids/alkalis (10% max), petrol, diesel and all common building materials.

**Corrosion resistance** Passes 1600hours (8 year equivalent ASTM B117 1973 at 100 microns dry film thickness ASTM D609, Type2 A366 steel panels.