



## HAMMER FINISH ENAMEL

### PRODUCT DESCRIPTION

Commercial Performance Coatings Hammer Finish Enamel is a fast air-dry, spraying enamel based on a copolymer alkyd resin and pigmented with aluminium flake to give a decorative patterned finish.

It is designed as a general purpose industrial enamel pattern finish for use where speed of dry is important, and can be applied over bare steel or properly prepared surfaces, including metal and timber. Typical uses are on sheet steel, agricultural equipment, vehicle chassis, engines, furniture, cabinets and electrical switchboards.

Utilizing the SELEMIX® universal tinter system, Commercial Performance Coatings Hammer Finish Enamel is available in a range of standard colours.

### PRODUCTS

Hammer Finish Enamel Mixed Colour		HFE
Reducers	<i>Normal conditions</i>	AER20 Alkyd Enamel Reducer Normal
	<i>Hot conditions</i>	AER30 Alkyd Enamel Reducer Slow
Cleaners		971-9119 PROTEC® Metal Conditioner
		AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

### SUBSTRATES & PREPARATION



Commercial Performance Coatings Hammer Finish Enamel can be applied over the following primers:

- EPS EtchPro Primer Surfacer, 426 EtchPro, 426 Vinyl Etch
- 411 Structural Primer, 425 Structural ZP Primer, 402 ZP Primer

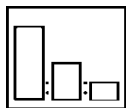


Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

*For other primer options please consult the PPG Commercial Performance Coatings Technical Team.*

## MIXING RATIO BY VOLUME



### PRODUCT

HFE Mixed Colour

Reducer

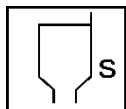
### PARTS

100

Not normally required

*Product is supplied ready for use; if necessary, up to 15% (by volume) reducer can be added.*

## SPRAY VISCOSITY



25 - 35 seconds (DIN 4) at 25°C

## SPRAYGUN



### CONVENTIONAL, HVLP

#### SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm

#### SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar

## APPLICATION & FLASH OFF



Apply 2 wet, even coats

Allow 5 minutes flash off between coats at 25°C

## DRYING TIMES



### AIR DRY (25°C)

- DUST FREE: 5 minutes
- TOUCH DRY: 15 minutes
- DRY TO HANDLE: 1 hour
- HARD DRY: Overnight

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

## RECOAT



Recoating should not be attempted after 4 hours drying and before 72 hours drying, as the enamel is then in a sensitive dry stage and may react to overcoating.

**TOTAL DRY FILM BUILD**

20 - 30 µm

**TECHNICAL PARAMETERS**

<b>VOLUME SOLIDS (RFU)</b>	30 - 40%, depending on colour
<b>COVERAGE</b>	10.0 - 20.0 metres squared per litre (m <sup>2</sup> /L)
<b>RESISTANCE PROPERTIES</b>	
<b>WEATHERING</b>	Fair
<b>ABRASION</b>	Fair
<b>SOLVENT</b>	Poor
<b>CHEMICAL</b>	Poor
<b>HEAT</b>	Satisfactory up to 120°C Dry Heat
<b>IMMERSION</b>	Not recommended

**EQUIPMENT CLEANING**

After use, clean all equipment thoroughly with cleaning solvent or thinner.

**HEALTH AND SAFETY**

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.  
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.  
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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