

TEMALAC HAMMER

DESCRIPTION

A one component glossy alkyd hammer finish.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ A glossy aluminium pigmented alkyd varnish with hammer finish effect for steel surfaces.
- ◆ Good gloss and colour retention when exposed to weathering.
- ◆ Suitable for steel structures, machinery, equipment, conveyors and tools.

TECHNICAL DATA

Volume solids 42 ± 2 %. (ISO 3233)

Weight solids 48 ± 2 %.

Specific gravity 1.0 kg / l

Product code 615 7231

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
30 µm	70 µm	14.3 m ² /l
50 µm	120 µm	8.3 m ² /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying times

DFT 40 µm	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	2 h	½ h	15 min
Touch dry, after	8 h	4 h	2 h
Recoatable, "wet-on-wet", after		3 h or > 4 d	

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish Glossy.

Colours Hammerfinish colours according to Metallic Colour Card. TEMASPEED tinting.

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APPLICATION DETAILS

Surface preparation	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4) <u>Primed surfaces:</u> Oil, grease, salt and dirt are removed from the surface by appropriate means. Repair any damage to the primer coat. Note the overcoating time of primer. (ISO 12944-4)
Primer	TEMAPRIME EE, TEMAPRIME EUR, TEMAPRIME ML, TEMALAC HAMMER and FONTECRYL 10.
Finish	TEMALAC HAMMER.
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below + 5 °C during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
Application	Mix the varnish thoroughly before use. Thin 0 - 3 vol-% if necessary. Use conventional spray equipment with atomization air pressure 2.0 - 4.0 bar and nozzle tip size Ø 1,8 mm. Use lower pressure and thicker varnish than in usual spraying. Smaller hammer effect will be reached with higher pressure and thinner varnish (thin > 3 vol-%). To ensure that the hammer effect is as wanted begin with spraying a small test area. A very porous and rough surface may need a primer. On zinc or zinc coated steel surfaces use always a suitable primer (TEMAPRIME EE or FONTECRYL 10). Note! It is recommended to use "wet-on-wet" technique when spraying vertical surfaces.
Thinner	Thinner 1006.
Cleaning of equipment	Thinner 1006.
VOC	The Volatile Organic Compounds amount is 520 g/litre of paint. VOC content of the paint (thinned 3 % by volume) is 530 g/l.
HEALTH AND SAFETY	Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Tikkurila Coatings Oy.

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