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# 350 HAMMERFINISH

## Patterned Enamel

### Description and uses

350 Hammerfinish is a rapid drying alkyd spraying enamel for decoration and protection of metal and timber substrates. This product is designed to cover surface imperfections such as grinding marks, weld spots, scratches and uneven surfaces.

350 Hammerfinish has the following features:

- Excellent hold up on vertical surfaces.
- One coat finish and rapid dry.
- Various patterns achieved by altering spraying technique and viscosity.
- Excellent adhesion to ferrous surfaces.

Typical areas of application are:

- Machinery, metal furniture and tool boxes.
- Cabinets and lockers.
- Lawn mowers, electrical motors, pumps etc.

### Technical Specifications

FINISH: Gloss

THINNERS: T104

VOLUME SOLIDS: 35-40% depending on colour.

COVERAGE: Approximately 9-10 Square metres per litre (at a D.F.T. of 40 microns).

RECOMMENDED FILM THICKNESS: 25-50 microns dry.

APPLICATION: Conventional or airless spray.

DRYING AT 25°C: Touch dry 20 minutes

Recoat – 2 hours

Hard dry overnight



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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 <sup>st</sup> Coat	50	210 Metalprime (thinner T102 or T104)
	2 <sup>nd</sup> Coat	25-50	350 Hammerfinish (thinner T104)

D.F.T. um			
System 2	1 <sup>st</sup> Coat	5-10	258 Twin Pack Etch or 260 Key-Coat (thinner T166)
	2 <sup>nd</sup> Coat	25-50	350 Hammerfinish (thinner T104)

APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 or abrasive blast clean to AS1627.4 Class 2	1
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	2

**Note:** All surfaces to be painted should be clean and free from dust, dirt, oil, grease etc. All surfaces must be free of moisture and topcoat not applied when the substrate temperature is below 5°C.

### Application

As mentioned, various patterns can be achieved by altering spraying techniques and spraying at various viscosities. 350 Hammerfinish can be sprayed unthinned or reduced with thinner T104. **Do not use slow enamel thinner T102.** When spraying unthinned, a pronounced pattern results, where small craters are produced, and the base metal or primer shows through. When reduced with thinner, the paint flows out and a less pronounced pattern results, with a smoother finish. When spraying the reduced paint, it is advisable to apply a **tack coat first**, allow 2-5 minutes to set up, then apply the final passes.

**Conventional spray:** Thin as required to achieve desired pattern up to approximately 20% with T104. Apply 2 coats wet on wet using 350-400 kPa atomizing pressure.

**Airless spray:** Thin approximately 50-10% with T104, apply at approximately 15 mPa atomizing pressure.

**Clean up:** T102 or T134 All Purpose Thinner



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### **Safety Instructions**

Flammability: Highly flammable, avoid heat and sources of ignition. Container should be earthed when pouring.

Personal Protection: Avoid contact with skin or eyes, wear suitable clothing such as impervious overalls, PVC or neoprene gloves, and safety goggles. Wear an approved half-face respirator suitable for organic vapor, meeting AS1715/1716.

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.

Although this information is presented in good faith and compiled from sources believed to be accurate, Lacnam Paints make no representations or warranty as to the completeness or accuracy thereof. As the product's performance and suitability depends on various factors, the purchasers of our products should determine for themselves whether the product is suitable for their particular use.