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

<table>
<thead>
<tr>
<th>Recommended film thicknesses and theoretical coverage</th>
<th></th>
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</thead>
<tbody>
<tr>
<td>dry</td>
<td>wet</td>
</tr>
<tr>
<td>30 µm</td>
<td>70 µm</td>
</tr>
<tr>
<td>50 µm</td>
<td>120 µm</td>
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</tbody>
</table>

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

Drying time

<table>
<thead>
<tr>
<th>DFT 40 µm</th>
<th>+ 10 ºC</th>
<th>+ 23 ºC</th>
<th>+ 35 ºC</th>
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</thead>
<tbody>
<tr>
<td>Dust dry</td>
<td>2 h</td>
<td>½ h</td>
<td>15 min</td>
</tr>
<tr>
<td>Touch dry</td>
<td>8 h</td>
<td>4 h</td>
<td>2 h</td>
</tr>
<tr>
<td>Recoatable, “wet-on-wet”</td>
<td>3 h or &gt; 4 d</td>
<td></td>
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</tbody>
</table>

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)

Primed surfaces: 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, EUR and 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 / 41 °F during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C / 38 °F above the dew point.

Application
Mix the varnish thoroughly before use. Thin 0 - 3 % with Thinner 1006 if necessary. Spray nozzle tip 1,8 mm, low pressure (200 - 300 kPa). Spray angle shall be chosen according to the shape of the object. Use lower pressure and thicker varnish than in usual spraying. Smaller hammer effect will be reached with higher pressure and thinner varnish. To ensure that the hammer effect is as wanted begin with spraying a smaller test area. A very porous and rough surface may need a primer. Note! Be careful when spraying vertical surfaces to avoid sagging.

Thinner
Thinner 1006.

Cleaning of equipment
Thinner 1006.

VOC
The Volatile Organic Compounds amount to 510 ± 20 g/litre of paint.

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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