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| PRODUCT NAME | Hammer Finishes (Noncell) |
| ISSUE DATE | 22/9/2005 |
| PRODUCT CODE | TOPNONHAM |



PRODUCT DESCRIPTION

HMG Hammer finishes are used to produce an attractive and durable special effect finish, which will hide imperfections on marked, pitted, or uneven surfaces of all types.

Non-Cell (Air dry acrylic) are the most popular general purpose Hammer finish for application on a wide variety of substrates, offering excellent drying gloss, adhesion and weathering properties.

HMG manufacture a range of both air dried, stoving enamel, and 2 Pack Hammer finishes to cover all types of application and performance requirements.



SPECIAL PROPERTIES

- Quick drying
- Ease of use



MAXIMUM VOC CONTENT (RFU)

0.54kgs/ltr

REGULATIONS / COMPLIANCE

- Not Applicable



COLOUR RANGE

A Standard range of colours are available, other colours by request.



TECHNICAL INFORMATION

| | |
|-------------------------|---|
| SPECIFIC GRAVITY | 0.96 |
| COVERAGE | 20 square metres per litre |
| FLASHPOINT | 25°C |
| TEMP RESISTANCE | 80°C |
| STORAGE | 12 months in original sealed containers |



CLEANING

Surfaces should be thoroughly clean, dry, free of all contamination & degreased. Etch Primers should be used over aluminium and alloys. For best results on steelwork use HMG HBZP primer or Speedbuild primer prior to applying the Hammer finish.













HEALTH AND SAFETY

Refer to MSDS and tin label prior to use.

Contaminated Rags, Spray Booth Filters or other substrates should be segregated from other chemical waste, soaked with Water and disposed of in a non-combustible container with a tight fitting Lid.

APPLICATION METHODS

| | AEROSOL | GRAVITY GUN | PRESSURE POT | COMPLIANT SPRAY GUN |
|---|--|--|--|--|
|  | MIXING RATIO | | | |
| | RFU | Base 85 - 95% Thinner 5 - 15% | Base 85 - 95% Thinner 5 - 15% | Base 85 - 95% Thinner 5 - 15% |
|  | THINNER OPTIONS | | | |
| | | Thinner 2621 Thinner 2622 | Thinner 2621 Thinner 2622 | Thinner 2621 Thinner 2622 |
|  | VISCOSITY | | | |
| | RFU | 30-40secs seconds B4 cup | 30-40secs seconds B4 cup | 30-40secs seconds B4 cup |
|  | SPRAY GUN SETUP | | | |
| | | 1.6-1.8 | 1.6-1.8 | 1.0-1.2 |
|  | NUMBER OF COATS (GUIDE ONLY) | | | |
| | 1-2 coats | 1-2 coats | 1-2 coats | 1-2 coats |
|  | FLASH OFF | | | |
| | 10mins | 10mins | 10mins | 10mins |
|  | DRYING TIME | | | |
| | Touch dry 30mins@20°C Hard dry 4-6hrs@20°C Full dry 24hrs@20°C | Touch dry 30mins@20°C Hard dry 4-6hrs@20°C Full dry 24hrs@20°C | Touch dry 30mins@20°C Hard dry 4-6hrs@20°C Full dry 24hrs@20°C | Touch dry 30mins@20°C Hard dry 4-6hrs@20°C Full dry 24hrs@20°C |
|  | RECOATABILITY / OVERCOATING | | | |
| | 10mins minimum 18hrs maximum | 10mins minimum 18hrs maximum | 10mins minimum 18hrs maximum | 10mins minimum 18hrs maximum |
|  | WET FILM THICKNESS | | | |
| | 100microns | 100microns | 100microns | 100microns |
|  | DRY FILM THICKNESS | | | |
| | 40microns | 50microns | 50microns | 50microns |

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.