



DESCRIPTION

It is a fast drying, solvent-based, hammerton-patterned topcoat paint containing a modified phthalic resin combination anticorrosive pigment mixture that can be applied directly on metal.

FEATURES

Dr Ferro Hammerton paint is a one component, air drying, decorative and corrosion resistant paint. It provides protection against light and medium atmospheric conditions thanks to the binder and suitable pigment combination. The combination of resin gives a bright appearance and dirt-repellent. Due to its good spreading and wetting properties, it can be applied directly to metal on surfaces with simple rust cleaning.

RECOMMENDED APPLICATION FIELDS

Steel structures, machinery, garden furniture and accessories, iron railings and doors, agricultural tools, equipment used for painting and corrosion protection.

CHARACTERISTICS

PAINT FILM		AVERAGE DRYING TIMES	
BINDER TYPE	Metallic Gloss-hammered looking	10°C	25°C
VISCOSITY	Special Resin Combination	TOUCH DRY	45 min 30 min
SPECIFIC GRAVITY	95-100 KU	DUST FREE TIME	3 Hour 2 Houts
SOLID CONTENT(%By Weight)	0,99-1.02 kg/lt	WAITING TIME BETWEEN THE LAYERS	5 Hour 3 Hour
SOLID CONTENT(%By Volume)	55	TRUE DRYING TIME	2 Days 1 Day
V.O.C	48	MAXIMUM CURING	9 Days 7 Days
FLASH POINT	<420 gr/L	Drying times can be change on temperature, relative humidity and film thickness.	
RECOMMENDED FILM THICKNESS	21°C (70°F)	MINIMUM	MAXIMUM
WET(MICRON)		208	312
DRY(MICRON)		100	150
CONSUMPTION m2/L RECOMMENDED		5	3,5
THEORETICAL COATING AREAm2/L (35 n		13,7	
NOTE: In brush and roller applications, it may be necessary to apply multiple coats to achieve maximum film thickness.			
CLEANING METHOD OF APPLICATION	TC Xylene, Cellulosic Thinner, Thinner 646		
SHELF LIFE	24 months unopened original box		
STORAGE TEMPERATURE	It is best suited for indoors with no direct sunlight between 5 ° C and 35 ° C		

SURFACE PREPARATION

Before starting the painting process, clean the surface using a suitable method (eg sanding, sandblasting or solvent cleaning) of dirt, dust, oil and sheet. Clean the surfaces to be painted with a cleaning solvent. Stir the can thoroughly before application. The second application should be done within maximum 3 hours following the first coat painting process. In case of application with spray gun, apply by mixing with 20% by weight of Thinner 646. It is recommended to apply 3-4 coats in thin coats with 15-20 minutes interval between coats. The sprayer should be 15-20 cm away from the surface and the air pressure should be 2 bar. Thinning rate and application conditions may vary depending on the design dimensions of the paint.

Minimum recommended surface preparation
 Iron and Steel Surfaces: SSPC-SP2/ISO8501-1:2007 S12

UYGULAMA

Airless Spray
 Pressure minimum (170 bar)
 Nozzle Size 0.015 "-0.021"
 Thinning 10-15% by volume Xylene, Industrial thinner, Thinner 646
BRUSH
 Brush Type Nylon / Polyester or Natural Bristle Brush
 Thinning 5-10% by volume Xylene, Industrial thinner, Thinner 646
AIR SPRAY (1.4-1.6 mm top spray gun)
 Pressure 1.8-2.2 bar
 Thinning 15-20% by volume Xylene, Industrial thinner, Thinner 646
 Specified Film Thickness, Dry: 100 micron
 Specified Film Thickness, Age: 208 microns
 Wait between layers, min: 3 hours 25 ° C; 5 hours 10 ° C

APPLICATION CONDITIONS

Temperature (air, surface, Product):
 5 ° C minimum, 35 ° C maximum
 At least 3 ° C above dew point
 Relative Humidity: 85% maximum

CERTIFICATES / APPROVALS

ADDITIONAL INFORMATION

Corrosion resistance	100 micron dry film, Type 2 A366 steel panel, 1600 hours (8 years) ASTM B117 1973
Impact resistance	100 micron dry film, 15cm (face) BS3900, E7 falling ball 15"/lb 7 days
Adhesion	100 micron dry film, BS3900, E6 falling, 7 days
Resistance to chemicals	When fully cured against acid and alkali splashes, petroleum, diesel, construction chemicals
Temperature resistance	Short-term exposures from -20 ° C to 150 ° C, up to 80 ° C continuous, after full curing NOTE: Temperatures above 50 ° C may cause discoloration.
UV Resistance	Resin content makes chalking and color yellowing against UV rays.

RECOMMENDED SYSTEMS

Dry Film Thickness (Iron-Steel Surface mikron)	
1.	FR.272.0000 Dr Ferro Rapid Primer Ur 80
2.	FM.273.0000 Dr Ferro DTM Hammert 200 C4 M ISO 12944
The systems listed above are representative of the product's use, other systems may be appropriate.	

HEALTH AND SAFETY

Read the Safety Data Sheet before use. CST reserves the right to change the technical document. Contact our technical service department for more information.

WARRANTIES

CST guarantees that this product is manufactured in accordance with the standards and without any error. In the event of a proven manufacturing defect, CST will replace the defective product or refund the fee. Under no circumstances, CST does not provide warranties.

Disclaimer

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