

DECORATIVE & PROTECTIVE PAINTS
PRODUCT DATA SHEET
DR.FERRO DTM HAMMERTONE PAINT
PRESTIGE SERIES



DESCRIPTION

It is a fast drying, solvent based hammerton patterned topcoat paint containing a mixture of phthalic resin combination anticorrosive pigment 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 and equipment is used to protect against corrosion.

CHARACTERISTICS

PAINT FILM	Metallic Gloss-hammered looking	
BINDER TYPE	Special Resin Combination	
VISCOSITY	95-100 KU	
SPECIFIC GRAVITY	0,99-1.02 kg/l	
SOLID CONTENT(%By Weight)	55	
SOLID CONTENT(%By Volume)	48	
V.O.C	<420 gr/L	
FLASH POINT	21°C (70°F)	
RECOMMENDED FILM THICKNESS	MINIMUM	MAXIMUM
WET(MICRON)	208	312
DRY(MICRON)	100	150
CONSUMPTION m²/L RECOMMENDED	5	3,5
THEORETICAL COATING AREA m²/L (β)	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	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	

AVERAGE DRYING TIMES

	10°C	25°C
TOUCH DRY	45 MIN	30 MIN
DUST FREE TIME	3 H	2 H
WAITING TIME BETWEEN THE LAYERS	5 H	3 H
TRUE DRYING TIME	2 D	1D
MAXIMUM CURING	9D	7 D

Drying times may vary depending on temperature, relative humidity and film thickness.

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, Wet: 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 micron)
- FR.272.0000 Dr Ferro Rapid Primer 80-120
Dr Ferro DTM Hammertone
 - 100-200 C4 I ISO 12944
Paint

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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