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TECHNICAL INFORMATION SHEET

350 HAMMERFINISH PATTERNED ENAMEL

June 2009

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Description and uses:

350 Hammerfinish is rapid drying alkyd spray enamel for decoration and protection of metal and timber substrates. This product is designed to cover surface imperfections such as grinding marks, weld stops, 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
- Standard colour range and custom colour matching available

Typical areas of application are:

- Machinery, metal furniture and tool boxes.
- Cabinets and lockers.
- Bobcats, lawn mowers, electrical motors and pumps.
- Ornamental metal work.

Technical Specifications:

FINISH: Gloss.

THINNERS: T104

VOLUME SOLIDS: 35% - 40% depending on colour.

VOC: 530 gms/litre. (Silver).

COVERAGE: 9 - 11 Square metres per litre (at a D.F.T. of 40 microns).

RECOMMENDED FILM THICKNESS: 25 - 50 microns.

APPLICATION: Conventional or Airless Spray.

DRYING AT 25°C / 50% Humidity:	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 st Coat	40-60	210 Metalprime (thinner T102 or T104)
	2 nd Coat	25-50	350 Hammerfinish (thinner T104)

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

D.F.T. um			
System 3	1 st Coat	40-60	240 Lacquer Primer Surfacer (thinner T130 or T134)
	2 nd 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, 2
Aluminum, Galvanized Steel or Zinc Anneal	Light abrasive blast or treat with 212 Metal Clean	2
Timber (Closed Grain)	Sand if necessary and dust down before painting.	3

Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, millscale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 5' Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3' Celsius above dewpoint.

Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Brush or Roller - Not Suitable.

Conventional Spray - 1.3 -2.0mm tip (or equivalent). Pressure pot set at 55 - 100kpa (8 - 15psi) and maintain gun air pressure 275 - 380kpa (40 -55psi).

Airless Spray - Use heavy-duty airless spray with 10 -15 "(0.25 – 0.38mm) plus tip and pump ratio 30:1

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Application Thinning:

Various patterns can be achieved by altering gun setup, spraying techniques and spraying viscosities. 350 Hammerfinish can be sprayed unthinned or reduced with thinner T104. **Do not use slow enamel thinner** as this will make the pattern less defined. When spraying unthinned, a pronounced "closed" pattern results, where small craters are produced and the base metal or primer may show through. When reduced with thinner, the paint flows out and a less pronounced "open" pattern results with a smoother finish. When spraying paint that has been thinned significantly it is advisable to apply a **tack coat first**, allow 2-5 minutes to set up, and then apply the final passes.

Brush or Roller - Not Suitable

Conventional Spray - Thin as required to achieve desired pattern up to maximum 20% with T102.

Airless Spray - Thin approximately 5-10% with T104.

Clean Up - T102, T104 or T134 All Purpose Thinner.

Safety Instructions:

Storage: Store in a cool, dry banded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

Flammability: Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

Personal Protection: Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

Using: Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

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.

REFER MSDS BEFORE USE

(Phone 02 9688 1999 or refer to www.lacnam.com.au for copy MSDS)

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