



## TECHNICAL DATA SHEET

### 650 HAMMERTONE

CURRENT AS AT: January 2014

|                |  |            |              |            |            |                |                 |           |           |
|----------------|--|------------|--------------|------------|------------|----------------|-----------------|-----------|-----------|
| DESCRIPTION:   | KINGSTON 650 HAMMERTONE is a fast air dry spraying enamel based on a copolymer alkyd resin and pigmented with the highest quality light fast pigments and aluminium flake to give a decorative patterned finish. It is designed as a general purpose industrial enamel pattern finish for use where speed of dry is important, and can be applied over bare steel or properly prepared surfaces, including metal and timber. Typical uses are on sheet steel, agricultural equipment, vehicle chassis, engines, furniture, cabinets and electrical switchboards. |            |              |            |            |                |                 |           |           |
| COLOUR:        | Available in a range of standard colours or can be matched to customers requirements.  |            |              |            |            |                |                 |           |           |
| GLOSS:         | Just below full gloss.   |            |              |            |            |                |                 |           |           |
| DRYING TIME:   | At normal ambient conditions and nominal film thickness of 25 microns, KINGSTON 650 HAMMERTONE is <table> <tr> <td>Dust free:</td> <td>3 –5 minutes</td> </tr> <tr> <td>Touch dry:</td> <td>15 minutes</td> </tr> <tr> <td>Dry to handle:</td> <td>45 – 60 minutes</td> </tr> <tr> <td>Hard dry:</td> <td>Overnight</td> </tr> </table>  | Dust free: | 3 –5 minutes | Touch dry: | 15 minutes | Dry to handle: | 45 – 60 minutes | Hard dry: | Overnight |
| Dust free:     | 3 –5 minutes   |            |              |            |            |                |                 |           |           |
| Touch dry:     | 15 minutes   |            |              |            |            |                |                 |           |           |
| Dry to handle: | 45 – 60 minutes  |            |              |            |            |                |                 |           |           |
| Hard dry:      | Overnight  |            |              |            |            |                |                 |           |           |
| RECOATING:     | <p>Recoating not generally required but can be recoated by itself up to 4 hours drying and again after 72 hours drying under normal ambient conditions and normal film thickness.</p> <p>Recoating should not be attempted after 4 hours drying and before 72 hours drying as the enamel is then in a sensitive dry stage and may react to overcoating.</p>  |            |              |            |            |                |                 |           |           |
| COVERAGE:      | Theoretical coverage a 25 microns dry film thickness is 13 square metres per litre. However, for practical purposes and depending on overspray, a spreading rate of 9 – 12 square metres per litre should be used.   |            |              |            |            |                |                 |           |           |
| SHELF LIFE:    | 12 months minimum.   |            |              |            |            |                |                 |           |           |
| VOLUME SOLIDS: | Approximately 32%  |            |              |            |            |                |                 |           |           |
| FLASH POINT:   | Less than 10C Abel.  |            |              |            |            |                |                 |           |           |

## RESISTANCE PROPERTIES:

|              |                                   |
|--------------|-----------------------------------|
| Abrasion:    | Moderate                          |
| Solvent:     | Poor                              |
| Chemical:    | Poor                              |
| Oil:         | Fair                              |
| Heat:        | Satisfactory up to 120oC dry heat |
| Flexibility: | Good                              |
| Durability:  | Good exterior durability          |

THINNING: Supplied ready for use. Apply a mist coat followed immediately by a single full coat. For use with low pressure gun add up to 5% by volume with KINGSTON 500-0100 ENAMEL THINNER.

SURFACE PREPARATION: All surfaces to be painted should be clean, dry and free from oil and grease.

Mild Steel – New bright steel surfaces should be thoroughly washed with KINGSTON 500-0111 WAX & GREASE REMOVER. Surfaces showing heavy soil and/or surface rust should be treated with a Metal Conditioner and Degreaser. KINGSTON 650 HAMMERTONE may be applied on un-primed surfaces. If priming is required, suitable primers are KINGSTON 621. For best results, first apply a Single Pack Etch Primer before priming with any of the above primers.

Galvanised Iron, Aluminium and most Non-Ferrous Metals – Clean surfaces thoroughly with KINGSTON 500-0111 WAX & GREASE REMOVER and etch prime immediately after cleaning with KINGSTON 406/413 TWO PACK ETCH PRIMER.

KINGSTON 615 VINYL ETCH PRIMER can be used as a single alternative to the systems detailed above, being satisfactory over steel, galvanised iron and aluminium surfaces.

Timber (interior only) – Sand to a smooth finish. Ensure surface is clean, dry and free from dust, grease and other contaminants. Prime with KINGSTON 630 Q.D. UNDERCOAT.

CONTAINER SIZE: 4 Litres, 20 Litres

PRECAUTIONS: KINGSTON 650 HAMMERTONE contains flammable solvents and therefore should be stored away from heat and open flames. Do not smoke whilst using. When applying in a confined space use an air feed respirator. Do not allow spilt product to remain on the skin. Normal health and hygiene standards should be observed when using this product.

HEALTH & SAFETY: Contains flammable volatile solvents. Keep away from all sources of heat and open flames. Do not smoke whilst handling. Wear suitable protective clothing to avoid contact with skin and eyes and avoid breathing vapour. Do not spray in confined or poorly ventilated areas without the use of approved air supplied breathing apparatus.

**FIRST AID:**

- Eyes:** If paint splashed in eyes, irrigate with copious amounts of clean water for 15 minutes seek medical aid if irritation persists.
- Skin:** If paint splashed on skin, wash affected area thoroughly with soap and water. If irritation persists, seek medical aid. Remove all contaminated clothing and launder before re-use.
- Inhalation:** If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist.
- Ingestion:** If swallowed, give glass of water to drink and seek medical assistance. Do not induce vomiting.

**Consult separate Material Safety Data Sheet for more detailed Health & Safety information.**

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