



TECHNICAL DATA SHEET

STOKES HAMMER FINISH PAINT

Reference AH	Revision No 2	Revision Date 30 August 1996	Printed 15 January 2008	Page 1 of 2
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Properties and Uses	<p>PROPERTIES Stokes Hammer Finish dries to give an attractive hammered appearance with a good gloss and excellent opacity. It has both good flexibility and adhesion which in turn gives good protection. It is fast drying thus enabling the rapid handling of painted materials. The hammered pattern helps reduce the visual defects of slightly imperfect surfaces. A selective range of attractive colours is available.</p> <p>USES. Recommended for use on metal fabrications and castings for both interior and exterior applications.</p>
Technical Data	<p>TYPE. Modified alkyd resin, with silicone Hammer Finish Additive.</p> <p>DRYING TIME. About 20 minutes to BS3900 part C2 under normal conditions of temperature and humidity. Handleable within 1 hour. Recoatable after approximately 2 hours. Do not recoat between 4 hours - 4 weeks after application because of possible lifting problems, this problem becomes more pronounced if applied by brush and if extremely thick coats of paint exist.</p> <p>THEORETICAL SPREADING CAPACITY. Approx. 13 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 25 microns. Coverage will vary according to surface profile.</p> <p>FLASH POINT. Below 21°C. HIGHLY FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT. By volume 33% nominal. By weight 42% nominal.</p> <p>THINNERS AND CLEANING SOLVENT. Stokes Thinners Ref. TH013.</p> <p>HEAT RESISTANCE. The normal changes encountered on heating are summarised below, but depend on the length of time for which the surface is heated. Up to 80°C Usually unaffected. 80°C to 90°C Slight discolouration of pastel shades. 90°C to 150°C Most colours tend to yellow. Above 150°C Unsuitable.</p> <p>OIL RESISTANCE. Good resistance to most hot and cold lubricating oils, mineral oils and cutting oils. Tests for suitability with any particular oil should be made before large scale application.</p> <p>CHEMICAL RESISTANCE. Good resistance to most common dilute acids and alkalis. Tests should be made for resistance to particular agents before large scale application.</p> <p>LEAD CONTENT. Most paints in this range are below 0.25% on the dry film weight. Exception :- AH064 Pine Quick Dry Hammer Finish is approx. 2% on the dry film weight.</p> <p>COLOUR RANGE. A selective range of colours is available from stock. Shades to meet customers special requirements can be supplied by arrangement.</p>
Stock Container Sizes	5 litre tins.

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Processes	<p>PREPARATION. The surface to be painted must be clean, dry and free from grease, dust, dirt, rust and peeling or loose material. Apply a coat of Stokes Etch Primer (either single or twin pack type) if a higher standard of protection is required.</p> <p>FINISHING. Apply one or preferably two coats of Stokes Hammer Finish Paint. The second coat gives a more attractive finished pattern than is obtained by one thick coat and is more durable. (See also Drying Time section of this data sheet).</p> <p>WARNING. Over previously painted surfaces, test a small area to ensure that there is no lifting.</p>
Application	<p>NOTE:- The temperature of paint and also that of the substrate should be at least 5°C., if the paint is applied below this temperature it is possible that the hammer pattern will not develop properly.</p> <p>BRUSH. Spray is more appropriate for the application of Hammer Finish Paint; however, with skill, small horizontal areas may be applied by brush without thinning.</p> <p>CONVENTIONAL SPRAY. Supplied ready for use. Thin as necessary with Stokes Thinners Ref. TH013.</p> <p>AIRLESS SPRAY. Supplied ready for use. Thin if necessary with Stokes Thinners Ref. TH013.</p> <p>ELECTROSTATIC SPRAY. Adjust conductivity of paint if necessary with Stokes Thinner Ref. TH009.</p>
Storage	<p>Use within 12 months of delivery. Keep in original containers until required for use. Partly used containers should be re-sealed securely and stored according to the recommended manner. (See section 7 of MSDS AHLF)</p>
Health and Safety	<p>THIS MATERIAL IS HIGHLY FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. AHLF FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING MEASURES, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>
Disclaimer	<p>The above information is for guidance only. It is given in good faith but without warranty. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.</p> <p>This Data Sheet supercedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond the control of R.J.Stokes & Co Ltd. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.</p> <p>R.J.Stokes & Co. Ltd. employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.</p>