

**WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899**  
**Little London Road | Sheffield | S8 0UH | Tel: 0114 258 9595 | Fax: 0114 250 9836 | Email: sales@rjstokes.co.uk**

<b>Properties and Uses</b>	<p>PROPERTIES Stokes Stoving Hammer Finish Paint when fully cured produces an attractive hammered appearance with a good gloss and excellent opacity. It has both good flexibility and adhesion which in turn gives good protection. The hammered pattern helps reduce the visual defects of slightly imperfect surfaces.</p> <p>USES. Recommended for use on filing cabinets, elevators, warm air ducting, computers and a multitude of other metals fabrications designed for interior usage and castings etc.</p>
<b>Technical Data</b>	<p>TYPE. Modified alkyd/amino resin blend with silicone Hammer Finish Additive.</p> <p>STOVING SCHEDULE. Approximately 30 minutes , 120°C (metal temperature).</p> <p>THEORETICAL SPREADING CAPACITY. Depending on colour varies between approx. 9.5 - 12.5 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of about 37.5 microns (1.5 thou.)</p> <p>FLASH POINT. In the range of 21- 55°C. FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT. By volume 35 - 46% nominal. varies according to shade By weight 44 - 53% nominal.</p> <p>THINNERS AND CLEANING SOLVENT. Stokes Thinners Ref. TH012.</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 - 90°C Slight discolouration of light shades. 90°C - 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. Below 0.25% on the Dry Film.</p> <p>COLOUR RANGE. Silver Blue Ref. AH014. Silver Ref. AH015. Mid. Green Ref. AH022. Other shades by special request.</p>
<b>Stock Container Sizes</b>	5 & 25 litre containers.

## STOKES STOVING HAMMER FINISH PAINT

**Reference**  
AHSTOHAM

**Revision No**  
1

**Revision Date**  
2 July 1996

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<b>Processes</b>	<p><b>PREPARATION.</b> The surface to be painted must be clean, dry and free from grease, dust, dirt, rust, peeling or loose material or any other form of contamination. Apply a coat of Stokes Grey Etch Primer Ref. IP021 or IP048, if a high standard of protection is required on bare steel. See also Stokes Data Sheet Systems for Metal.</p> <p><b>FINISHING.</b> Apply one or preferably two coats of Stokes Hammer Finish Paint. The second coat gives a more attractive finished pattern than that which is obtained by attempting to apply just one thick coat and will give a more durable coating.</p> <p><b>WARNING.</b> Over previously painted surfaces, test a small area to ensure that there is no lifting.</p>
<b>Application</b>	<p><b>CONVENTIONAL SPRAY.</b> Supplied ready for use. Thin as necessary with Stokes Thinners Ref. TH012.</p>
<b>Storage</b>	<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 Stokes Material Safety Data Sheet Ref. AHSF).</p>
<b>Health and Safety</b>	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF.AHSF FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROL / PERSONAL PROTECTION AND DISPOSAL.</p>
<b>Disclaimer</b>	<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 &amp; 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 &amp; 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>