



PUFFIN HAMMERTONE

Is one component thermoplastic acrylic coating with metallic colour hammertone finishing. Can be use as top coat or single coat. Suitable for carbon steel, iron, aluminum, galvanized steel, concrete, stainless steel, stone, plastic ABS and wooden substrates.

1. Properties

COLOR	Metalic colour hammertone finishing
GLOSS LEVEL	gloss(75-85)
FILM THICKNESS, DRY (μm)	50-100
FILM THICKNESS, WET (μm)	150-300
THEORETICAL SPREADING RATE (M^2/L)	3-6
SOLIDS (VOL %)	35% +/- 2
DENSITY (g/cm^3)	0,9
FLASH POINT	40°C \pm 2%
PRACTICAL COVERAGE	ALLOW APPROPRIATE LOSS FACTORS

2. Characteristics

Reccomended

Artistic paint for steel, plastic, alluminium, stainless seel, iron, wooden and concrete substrate
Suitable for balconies, stairs, railings, windows, doors, natural stone, home or office furniture

3. Usage

1) Surface preparation:

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination. Oil or grease should be removed.

2) Substrate Minimum Recommended : The surface should be assessed and treated in accordance withSubstrate Minimum

Recommended:

For carbon steel substrate : Sa 2½ (ISO 8501-1)

For concrete : Min Age of concrete 1 months with PH<9 , moisture content < 17 % . Clean ,dry and free from any contamination

For wooden substrate : Clean and dry surface. Surface contamination is to be removed by detergents and fresh water cleaning.

For Stainless steel Cleanliness and surface profile corresponding to Sa 2½, Fine G (ISO 8503-2)

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For Aluminium: The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface and to remove all polish from the surface. Dry abrasive blast cleaning to SSPCSP 13/NACE No. 6.

For Galvanised steel: The surface shall be clean, dry and appear with a rough and dull profile. Light brush blasting using nonmetallic abrasive leaving a clean, rough and even pattern. Coated surfaces Clean, dry and undamaged compatible coating (ISO 12944-4 6.1) Clean, dry and undamaged compatible coating (ISO 12944-4 6.1)

For stone : Clean ,dry and free from any contamination .

For coated substrated : clean ,dry , free for any contaminations and undamaged compatibility coatings

3) Application:

Airless spray, airspray, brush, roller

Spray; Recommended: Pressure at nozzle (minimum): 150 bar/2100 psi

Nozzle tip (inch/1000): 13-19

Filter Check to ensure that filters are clean.

Brush Recommended : for stripe coating and small areas.

Care must be taken to achieve the specified dry film thickness.

4) Dilution

Puffin Thinner HG

5) Drying and Curing time:

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The shortest time allowed before the next coat can be applied.

Surface (touch) Dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness

SUBSTRATE TEMPERATURE (°C)	-5	0	5	10	23	40
SURFACE DRY (min)	30	20	17	15	10	10
DRY ON WALK (hours)	20	20	17	11	10	6
Dry to over coat, minimum (hours)	4	4	3	2.5	2	1.5

6) Product compatibility :

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product.

Some examples are shown below.

Subsequent coat:

Polyurethane,Acrylic

4. Precaution

- 1) Ensure to clean the surface before application.
- 2) Health and safety : Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.
- 3) Storage: The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care. Shelf life at 23 °C : 24 Month(s)

5. Packing :

1 L & 5 L & 20 L