

1. DESCRIPTION Impa Hammertone Enamels is a twin-pack durable, fast drying finish with good adhesion to ferrous metals. 2. FEATURES - They are eminently suitable for the finishing of light metal articles such as tool boxes, tin trunks etc. - Dries to a good quality, tough and durable finish. - Easy application and rapid drying - Not resistant to strong acids and alkalis outside ph range of 6-9. 3. RECOMMENDED PRIMER - Although the product will adhere to clean metal surfaces, the performance will greatly enhanced by first applying a suitable prime. Impa QD Zinc Phosphate Primer is prescribed as a suitable primer. 4. LIMITATION - Requires a skilled applicator 5. MIXING - Stir the base component well with a flat – bottomed paddle or mechanical mixer until product is uniform 6. PREPARATION OF SURFACES - Surfaces must be clean, sound and dry - Remove grease and oil with Impa Degreasing Solvent - Grind and fettle weld spatter, protrusions and sharp edges to a minimum radius of 2mm - All surfaces shall be abrasive blast cleaned to grade SA 2½ of standard ISO 8501-1 with a blast profile 30-40µm. The coating must be applied before any flash rusting occurs or the surface shall be re-blast cleaned again. - Alternatively abrade the surface thoroughly using grinding disks to achieve a similar profile.	SOLVENTBASE SPECIALISED EFFECT IMPA HAMMERTONE ENAMEL ISSUED DATE: JUNE 2014 Rev 1 TECHNICAL DATA <table> <tr> <td>Product Code</td><td>Base: HA2600 Effect attitude: HA2601</td></tr> <tr> <td>Colour</td><td>Grey, Silver and Standard Colours</td></tr> <tr> <td>Appearance</td><td>Gloss</td></tr> <tr> <td>Shelf life</td><td>12 Months</td></tr> <tr> <td>Packaging</td><td>1L & 5L</td></tr> <tr> <td>Flashpoint</td><td>4°C</td></tr> <tr> <td>Viscosity</td><td>60 – 65 Ku/23°C</td></tr> <tr> <td>S.G (weight)</td><td>0,96-0,98kg/L</td></tr> <tr> <td>Solids per volume</td><td>31 – 32%</td></tr> <tr> <td>Solids per mass</td><td>34– 35%</td></tr> <tr> <td>Practical Spreading rate (depending on porosity)</td><td>8m²/L @ 25µm, DFT</td></tr> <tr> <td>Recommended finishing coats.</td><td>1</td></tr> <tr> <td>DRYING TIME</td><td></td></tr> <tr> <td>Temperature Resistance</td><td>Dry 80°C</td></tr> <tr> <td>Touch dry time</td><td>15 Min at 23°C for 50µm @ 65%RH</td></tr> <tr> <td>Recoating Time</td><td>Not recommended</td></tr> <tr> <td>Full Cure</td><td>4-7 Days</td></tr> <tr> <td>APPLICATION</td><td></td></tr> <tr> <td>Spray Airless</td><td>Ready for use Pump Ratio: 30 to 1Min. Nozzle Orifice: 11 to 15 Thou Tip Pressure: 145 Bar Min Pressure & Gravity Feed. Pressure as needed. Impa E Thinners max 50% SL Base : 25ml effect additive</td></tr> <tr> <td>Conventional Spray</td><td></td></tr> <tr> <td>Mixing Ratio</td><td></td></tr> <tr> <td>Cleaning & Thinning</td><td>Impa E Thinners</td></tr> </table>	Product Code	Base: HA2600 Effect attitude: HA2601	Colour	Grey, Silver and Standard Colours	Appearance	Gloss	Shelf life	12 Months	Packaging	1L & 5L	Flashpoint	4°C	Viscosity	60 – 65 Ku/23°C	S.G (weight)	0,96-0,98kg/L	Solids per volume	31 – 32%	Solids per mass	34– 35%	Practical Spreading rate (depending on porosity)	8m²/L @ 25µm, DFT	Recommended finishing coats.	1	DRYING TIME		Temperature Resistance	Dry 80°C	Touch dry time	15 Min at 23°C for 50µm @ 65%RH	Recoating Time	Not recommended	Full Cure	4-7 Days	APPLICATION		Spray Airless	Ready for use Pump Ratio: 30 to 1Min. Nozzle Orifice: 11 to 15 Thou Tip Pressure: 145 Bar Min Pressure & Gravity Feed. Pressure as needed. Impa E Thinners max 50% SL Base : 25ml effect additive	Conventional Spray		Mixing Ratio		Cleaning & Thinning	Impa E Thinners
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7. APPLICATION

- Conventional, air assisted airless or airless spray. It is suggested that a mist coat be applied first followed by a full coat, control of film thickness will determine pattern size.

8. PRECAUTIONS.

- Application should be avoided in cold and moist weather conditions.
- **Do Not** apply the product at surface temperatures below 6°C (minimum of 2°C above dew point) and temperatures above 40°C
- **Do Not** apply if ambient temperature is less than 10°C or more than 40°C.
- **Do Not** apply if relative humidity temperature is less than 10°C or more than 85. °C
- Extremely cold conditions will make the drying time longer.
- Paint in area where there is good ventilation
- Containing inflammable solvents
- Product will chalk on extended exterior exposure
- Do not apply over galvanized surfaces, zinc coatings or alkali surfaces
- Low solids coating, apply sufficient coats to achieve protection
- Avoid contact with skin by using gloves, barrier creams and face mask.
- Must be over coated to provide corrosion resistance.

Environmental Health & Safety Information

WARNING! IRRITANT! HARMFUL IF SWALLOWED. CONTAINS: LOW & HIGH AROMATIC SOLVENTS. MAY CAUSE EYE, NOSE AND THROAT IRRITATION. AVOID CONTACT WITH SKIN AND EYES AND AVOID BREATHING OF VAPORS AND SPRAY MIST. WEAR EYE PROTECTION AND PROTECTIVE CLOTHING. USE ONLY WITH ADEQUATE VENTILATION. To avoid breathing vapours and spray mist, open windows and doors or use other means to ensure fresh air entry during application and drying. If you experience eye watering, headaches or dizziness, increase fresh air. If properly used, a respirator (NIOSH approved for organic vapor with P series particulate pre-filter) may offer additional protection; obtain professional advice before using. A dust mask does not provide protection against vapors. Avoid contact with eyes and skin. Wash thoroughly after handling. Close container after each use. **FIRST AID:** If you experience difficulty in breathing, leave the area to obtain fresh air. If continued difficulty is experienced, get medical assistance immediately. In case of eye contact, flush immediately with plenty of water for at least 15 minutes and get medical attention; for skin, wash thoroughly with soap and water. If swallowed, get medical attention immediately.

CAUTION: KEEP OUT OF REACH OF CHILDREN AND ANIMALS - DO NOT TAKE INTERNALLY.

Refer to Material Safety Data Sheet for additional health and safety information.

IN CASE OF FIRE: Use foam, CO₂, dry chemical, or water fog.

SPILL – Absorb with inert material and dispose of as specified under **Thinning/Clean-up**.

† **WARNING!** If you scrape, sand or remove old paint, you may release lead dust.

DISCLAIMER

The technical information contained in this document are given in good faith and are meant to be used as a guideline by the specifier or user. Whilst we are confident about the quality of our products, we cannot accept any liability for the incorrect use or application of our products. Surface preparation forms an integral part of the scope of works and it is expected that the highest standards are maintained during surface preparation and application, to ensure that our products perform as intended. Always ensure to use the same product batch numbers, refrain from doing spot touch-ups and paint surfaces from corner to corner to prevent colour and sheen variance. As technology may change over time we reserve the right to change products to keep up with changes in raw materials or product trends without pre notice. Although we will always prevail to keep clients informed about changes to be made, but cannot bind ourselves to such notes Please ensure the use of the latest Technical Data Sheet.

Please note: that all our latest Product Data Sheets and Material Safety Data Sheets are available for viewing on our website at www.impa.co.za. All information listed is owned or used under licence of Impa Paints and its related companies. © 2010 Lurama 149 (Pty) Ltd. All rights is reserved.