

PRODUCT NAME

Stoving Enamel Hammer

ORIGINALLY ISSUED

04/11/2020

VERSION

1.0

PRODUCT CODE

TOPSTV

VERSION DATE

04/11/2020



PRODUCT DESCRIPTION

A high performance, rapid curing, high build, general purpose Stoving Enamel in a hammer finish.

It combines excellent colour and gloss retention together with good physical properties.

It is suitable for most domestic and industrial applications where it offers fast production turn around combined with economy and good technical properties.



IMPORTANT INSTRUCTIONS BEFORE USE

- Read and follow SDS, TDS and label instructions
- Stir all paints thoroughly before use
- Always use the same batch number on the same job
- Check colour & sheen. HMG will not accept any discrepancies arising after use
- Filter the product immediately before use
- Reduce emissions and maintain quality by replacing tin lid after use
- If in any doubt speak HMG Technical Service Department on (0161) 205 7631



SPECIAL PROPERTIES

- Ease of use
- Good long term durability



MAXIMUM VOC CONTENT (RFU)

0.5Kg/L

REGULATIONS / COMPLIANCE

- Not Applicable



COLOUR RANGE

- Available in a wide colour range.



GENERAL INFORMATION

Coverage 20 square metres per litre @ 25 microns dft
Flashpoint 4°C
Temp Resistance 160°C
Storage Store between 5°C - 25°C. When not in use, cans must be kept sealed
Shelf Life 12 months from delivery date in original sealed containers



CLEANING

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove all traces of contaminants.

HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process.

Please refer to our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



SURFACE PREPARATION

Please refer to Knowledge Base for details on Surface Preparation.



HEALTH AND SAFETY

- Refer to SDS and tin label prior to use.

APPLICATION METHODS



COMPLIANT SPRAY GUN		PRESSURE POT					
MIXING RATIO							
Base	1	Base	1				
Thinner	< 20%	Thinner	< 20%				
THINNER OPTIONS							
Thinner 2691		Thinner 2691					
VISCOSITY							
25-35	seconds B4 cup	25-35	seconds B4 cup				
SPRAY GUN SETUP							
1.6-1.8		1.2-1.4					
NUMBER OF COATS (GUIDE ONLY)							
1-2 full coats		1-2 full coats					
FLASH OFF							
15mins @ 20°C		15mins @ 20°C					



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Thinner 2691

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**DRYING TIME**

Full dry	30mins @120°C	Full dry	30mins @120°C				
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**WET FILM THICKNESS***

50microns	50microns		
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**DRY FILM THICKNESS***

25microns	25microns		
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* - HMG Technical Data Sheets indicate a Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film thickness will vary depending on actual use and specification. Great care should be taken to achieve the dft stated in the agreed specification and to avoid areas of excessively low or high thickness.

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.