

TECHNICAL DATA AND APPLICATION GUIDE

One step * and the rust is history

Stops and prevents rust in one step*.

Glassguard protection.

Save \$ - no primer needed.

Paint right over rust.

Save time – dry to touch in 30 minutes.

Outlasts other paints.

***See Recommended Uses**

For more information call: 1-866-PRIMER-1

Web Site: www.masterchem.com

HAMMERITE COATING GENERAL INFORMATION

DESCRIPTION:

ONE STEP FINISH – PAINT RIGHT OVER RUST

HAMMERITE is a self-priming quick-dry gloss paint coating.

HAMMERITE is designed for use on rusty metal and most other metal surfaces, without the need of a primer.

GLASSGUARD PROTECTION: As the HAMMERITE coating dries, millions of heat-hardened glass flakes interlock with the special resins forming a super-tough barrier that seals out moisture to prevent rusting.

The Quick dry Hammered Metal Finish has two different silicones with Aluminum and glass beads that give the “Hammered” effect.

The Quick-dry Smooth finish contains no silicones or aluminum.

RECOMMENDED USES:

HAMMERITE is a long-lasting coating that can be applied directly over a firm, rusty surface.

*Aluminum, galvanized and zinc sprayed surfaces require a prime coating of HAMMERITE GALVANIZED AND ALUMINUM PRIMER.

HAMMERITE Galvanized and Aluminum Primer dries to touch in 1-2 hours @ 60°F (16°C). Allow primer to dry 24 hours before applying finish coat.

HAMMERITE aesthetic value and rust protection properties make a durable coating for exterior applications on residential and commercial projects. Some suggested uses are:

1. Exterior doors, mail boxes, wrought iron, ventilation pipes/fittings. Wheel barrows, swing sets, snow blowers, lawn mowers, fences, storage sheds, etc
2. Playground equipment, recreation vehicles, boat trailers, etc.
3. Architectural structures, tank farms, machinery, theme parks, transportation equipment, above water marine applications, etc.
4. Frames, wheels, bumpers, trailer hitches, under car and truck carriages, trunk areas, floor trays, etc.

SURFACE PREPARATION:

Remove all loose rust, paint and millscale. This can be achieved by scraping, sanding or wire brushing. Remove all dirt, oil, grease, salt contamination from ocean or street salt, and mildew, using an approved cleaner, fresh water and a commercial mildew remover. Rinse surface thoroughly and let dry before continuing. Smooth or hard, slick surfaces must be deglossed or abraded by sanding or grit blasting. A new or clean metal surface that is very smooth and/or glossy, or non-porous MUST be sanded with a minimum 80 grit sandpaper. DO NOT use any rust converter, or any other acid or conversion type product to clean or prepare a rusted surface before applying a Hammerite coating. Aluminum and galvanized surfaces require a prime coating of HAMMERITE Galvanized and Aluminum Primer.

Professional painting practice required previously painted or shop primed surfaces must be "patch" tested for compatibility. Apply HAMMERITE to a small area and expose for 72 hours minimum and check for adhesion and any signs of lifting or cracking, etc.

APPLICATION:

Mix the paint coating thoroughly before and stir during application. Ideal application temperature is between 60°F and 80°F

BRUSH OR ROLLER:

Always maintain a wet edge to avoid lap marks and avoid over brushing and/or rolling. A ¼” mohair roller or synthetic bristle brush is recommended for flat surfaces. Brush irregular surfaces. Apply thickly and quickly. Do not overwork coating. Ensure corners, edges and heavily pitted areas are adequately coated. 2-3 coat minimum to achieve a 4-mil dry thickness.

SPRAY-BRUSH-ROLL:

Apply two or more coats as needed to achieve the 4-mil dry film thickness required for maximum rust and substrate protection. Recoat after each coat has dried to touch (30 to 45 minutes) additional coats would be applied the same (30 to 45 minutes between coats). All Hammered coatings must be applied within 4 hours or after 14 days of drying. All Smooth coatings must be applied within 4 hours or after 72 hours of drying. Dries to handle in 90 minutes at 77°F (21°C) 50% Relative Humidity.

SPRAY APPLICATION:

INFORMATION BELOW IS FOR GUIDELINE USE ONLY. Before operating any spray system, review the technical manual for detailed information needed to properly operate and maintain the equipment.

a) Conventional Air Spray:

Pot Pressure: 15-20 p.s.i.

Atomizing pressure: 25-35 p.s.i.

Nozzle size: 70-80 thousandths

Apply 3-4 coats allowing each coat to set 30-45 minutes at 60°F (16°C) before application of the next coat to prevent sags. Final coat must be wet enough to flow to a uniform glossy finish.

b) Airless Spray:

Atomizing pressure: 1800-2600 p.s.i.

Tip Size: 17-21

Apply 3-4 coats to a minimum dry film thickness of 4 mils for rust protection. Allow each coat to set 30-45 minutes at 60°F (16°C) before application of the next coat to avoid sagging. Final coat must be wet enough to provide a uniform glossy finish.

AEROSOL CONTAINERS:

Read and follow all application and precautionary information. Shake can for two or three minutes after activating ball and occasionally during use. Spray light, even coats, holding the container upright approximately 8" to 12" from surface being painted. **The aerosol Hammered Metallic Finish is not as pronounced as the paint from the quart and/or gallon containers.** This is due to the thinning of the product so the propellant will push it out through the siphon tube and spray tip orifice.

Three to five coats will be required to eliminate any pinholes and thin spots to achieve the 4 mil dry thickness required to keep moisture from penetrating the coating.

The final coating must be thick enough to flow to a smooth even finish with a well-defined pattern, but not heavy enough to run. Make sure all corners, edges and heavily pitted areas are adequately coated.

All coatings can be applied as soon as the previous coating is dry to touch, about 15 minutes. All coatings must be applied within one hour or after 10 days cure time.

After use, invert container (turn upside down) and spray to clear valve of the paint coating.

COVERAGE:

Approximately 200 square feet per gallon depending on the method of application, porosity and texture of the surface and to achieve a 4 mil dry film thickness.

CLEAN-UP/DISPOSAL:

Clean all tools and equipment after use with HAMMERITE CLEANER AND THINNER, Xylene or Lacquer Thinner. Close container when not in use. Dispose of empty container and/or unused portion of paint in accordance with local, state and federal regulations.

PHYSICAL PROPERTIES:

Solids/Volume: HAMMERITE is a high solid, low VOC coating. Approximately 60% solids dependent on color.

Dry To Touch: Approximately 30 minutes; dry to handle: 2-4 hours at 60-80°F (16-27°C). 50% Relative Humidity.

Hard Dry: 2 weeks for Hammered and 72 hours for Smooth.

Impact Resistance: Good

Adhesion: Excellent to most properly prepared surfaces. Some surfaces may require a primer or special preparation. The Hammerite can withstand intermittent temperatures up to 200°F (93°C) maximum without peeling. Light colors may undergo color changes when subjected to high temperatures. Check with your HAMMERITE Representative.

Adhesion Problems (Peeling):

Too thin a film coating which can be permeable by moisture. Substrate not cleaned and prepped thoroughly. Smooth substrate, which has not been abraded, (sanded or scuffed) sufficiently. Sand with 80-grit sandpaper and recoat. Incompatible primer or a conversion coating used (Ospho, Naval Jelly, etc.)

Aerosol Plugged:

Cans must be inverted and sprayed until no paint comes out of the spray tip to clear the tube and tip of the paint after use. Before use, shake cans vigorously for at least three minutes after mixing ball moves freely, and occasionally during use. A 4-mil/dry thickness is a must for all applications. This will consist of three (3) to five-(5) coats wet aerosol application for Hammered or Smooth finish.

Respirator-Filter/Cartridge Information:

NIOSH/MSHA Approved or TC 23C:

MSDS (USA)

UN1263 Brushable. UN1250 Aerosols.

Non-leaded, non-toxic when dry.

For printing reasons, the color shown on the front of the container and/or color card may not exactly match the color of the paint.

LIMITED WARRANTY: In lieu of all other warranties and guarantees, if this product is found to be defective upon inspection by its representative, Masterchem Industries, Inc. will, at its option, either furnish an equivalent amount of new product or refund the purchase price to the original consumer purchaser of this product upon proof of purchase. Masterchem Industries will not be liable for any representations or warranties made by any retail seller or applicator of this product. **This warranty excludes (1) labor or cost of labor for the removal of this product or any other product, the repair or replacement of substrates to which this product is applied or the application of replacement product and (2) any incidental or consequential damages.** Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. This warranty gives you specific rights and you may also have other rights which vary from state to state. To make a warranty claim, write to Technical Service, Masterchem Industries, Inc., 3135 Old Highway M, Imperial, MO 63052-2834, or e-mail Technical Service at techservice @Masterchem.com

WARNING!!

CONTAINS XYLENE AND PETROLEUM DISTILLATES

Vapor harmful. May affect the brain or nervous system causing dizziness, headache or nausea. Causes eye, skin, nose and throat irritation.

NOTICE: Reports have associated repeated and prolonged occupational over exposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling and contents may be harmful or fatal. Keep away from heat, sparks and flame. **VAPORS MAY CAUSE FLASH FIRE:** Do not smoke. Extinguish all flames and pilot lights and turn off stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation. This product contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

USE ONLY WITH ADEQUATE VENTILATION: Do not breathe vapors or spray mist. Ensure fresh air entry during applications and drying. If you experience eye watering, headache, dizziness or if air monitoring demonstrates vapor/mist levels are above applicable limits, wear an appropriate, properly fitted respirator (NIOSH/MSHA approved) during and after application. Follow respirator manufacturer's directions for respirator use. Close container after each use. Avoid contact with eyes, skin and clothing. Wash thoroughly after handling.

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. If spilled, contain spilled materials and remove with inert absorbent. Dispose of contaminated absorbent, container and unused contents in accordance with local, state and federal regulations.

**MASTERCHEM INDUSTRIES
3135 OLD HIGHWAY M
IMPERIAL, MO 63052
1-866-PRIMER-1**

Web Site: www.masterchem.com

