

VITROS STOVING HAMMER FINISH

INTRODUCTION

A range of quick bake stoving hammer finishes giving a tough durable abrasion resistant finish with resistance to a wide range of solvents and chemicals. VITROS STOVING HAMMER FINISHES have good application properties together with a fast curing cycle producing a hammered effect finish which can help hide surface defects such as tool marks, pock marks etc. producing a resilient film with good chip and impact resistance.

AVAILABILITY

Supplied from stock in the following shades:

632/001 Silver Grey 632/004 Black

Other shades manufactured to customers order requirements subject to current minimum order size.

PACKAGE SIZES

Supplied in 5 litre lever lid cans and 20 litre pails.

COMPOSITION

An alkyd amino with aluminium paste and organic and/or inorganic pigments in a ketone and hydrocarbon solvent blend.

APPEARANCE WHEN DRY

¾ gloss hammered finish

SHELF LIFE

12 months in original unopened container

SOLIDS BY WEIGHT

61% Typical

SOLIDS BY VOLUME

44% Typical

VISCOSITY AS SUPPLIED

160 +/- 10 seconds at 25°C (BS EN ISO 2431)

SPECIFIC GRAVITY

1.16 Typical. Will vary with shade

SURFACE PREPARATION

All surfaces should be clean and dry free from oil, grease and other surface contaminants. Metal surfaces should be primed with an AIRSPEED ETCH PRIMER or other suitable stoving primer and lightly flatted if required prior to the application of VITROS STOVING HAMMER FINISHES.

APPLICATION

Formulated for application by conventional air assisted spray. An addition of approximately 10% 800/003 Thinners will be required to achieve optimum application viscosity. Typical air atomising pressure 30 - 50 Psi.

THEORETICAL COVERAGE

Applied at 15²m per litre will give a DFT of 30µ, corresponding WFT 70µ.

Losses on narrow section and bar may be considerable due to overspray.

CURING SCHEDULE

Convected air temperature - Allow 10 minutes flash off period followed by 20 minutes at 120°C.

Infra red - Allow 10 minutes flash off period followed by 10 minutes at 150°C.

The curing cycle will vary with oven capacity and the thermal conductivity of the articles being stoved.

OVERCOATING

May be recoated with subsequent coats of VITROS STOVING HAMMER FINISH after light abrasion in order to promote adequate intercoat adhesion.

SOLVENT FOR THINNING AND CLEANING EQUIPMENT
800/003 Thinners.

HEALTH AND SAFETY INFORMATION

This Data Sheet should be read in conjunction with Product Safety Data Sheet CCL632.

ADDITIONAL INFORMATION

Crosbie Coatings Limited believe that the aforementioned information is to the best of our knowledge correct but no responsibility can be held for conditions of use beyond our control. Should there be any query as to the suitability for use please do not hesitate to contact the Technical Department of Crosbie Coatings Limited.