

HAMMERITE NO. 1 RUST BEATER PRIMER

TECHNICAL DATA SHEET

Version 3 – 2018 September

THIS ISSUE SUPERSEDES ALL PREVIOUS PUBLICATIONS

PRODUCT DESCRIPTION

Hammerite No.1 Rust Beater provides a high build finish to heavily pitted areas of rust and prevents new rust forming.

PRODUCT USES

- An anti-corrosive rust-stabilising primer for direct application to bare and rusty iron and steel.

FEATURES AND BENEFITS

- It penetrates and stabilises existing rust and create a barrier to prevent further rust.
- It helps to level rough and profiled surface.
- 3 in 1 Rust Protection – Kills rust, primers and undercoat all in one
- Corrosion resistant, reduces expensive surface preparation, and provides a stable, smooth surface ready for painting.

PRODUCT INFORMATION

Colour	Brown
Spreading Rate	Approx. 12m ² per litre per coat by brush depending on profile and application method.
Recommended thickness	Film thickness will be dependent on the coverage achieved. Wet (WFT) Min. 80µm. Dry (DFT) Min. 50µm NOTE: The number of coats required to achieve this will vary depending on the substrate and method of application.
Flash Point	Flammable.
Corrosion resistance:	Excellent corrosion resistance when application instructions are followed.
Temperature resistance	Range when fully cured. Intermittent use: Minus 30°C up to 150°C maximum. Continuous use: Recommended maximum 80°C.
Service Limitations	Not suitable for: <ul style="list-style-type: none"> • Use on equipment operating at or above 80°C. • Contact with drinking water or foodstuffs. • Permanent immersion. • Use on non-ferrous metals

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PRODUCT INFORMATION

VOC Levels	Hammerite is conforms to EU Directive 2004/42/CE for VOC. The product shown above is classified as Category A/i 600g/l (2007) 500g/l (2010). The product contains a max. 499g/l
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APPLICATION INFORMATION

Mixing	Stir until homogeneous with a flat paddle.
Application Surface conditions	Surface Temperature between 8 - 25°C. Relative Humidity between 10 - 85 % OR 2°C above dew point minimum.
Application methods	Brush, roller and spray applications.

BRUSH – Suitable for mall flat areas and intricate wrought iron work

- Apply 1 or 2 coats, allowing minimum 6 hours between coats.
- Ensure corners and edges are well covered.
- Apply topcoat after minimum of 6 hours.

NOTE: for best results, 24 hours should be allowed before application of topcoat.

ROLLER – Suitable for large flat surfaces

- Normally thinning is not necessary, but if required thin with **Hammerite Brush Cleaner & Thinners** up to maximum 9 parts paint to 1 part thinners.

NOTE: Do NOT use cellulose thinners.

- Apply 2 coats, using short pile mohair roller allowing 6hours between coats
 - Brush in edges and corners first, before quickly covering remaining area with roller.
- NOTE: Other types of roller may be unsuitable – check for compatibility.

- Apply topcoat after minimum of 6hours, for best results, 24 hours should be allowed before application of topcoat.

SPRAY – Suitable for large, flat and uneven surfaces.

For both conventional and airless stray

- Shake spray gun before and during use to ensure and even colour
- For best results use **Hammerite Brush Cleaner & Thinners** to thin the paint
- Apply mist coat and allow to dry (15-30 minutes)
- Apply further 2 coats allowing 15-30 minutes between coats
- Apply topcoat after minimum of 6hours, for best results, 24 hours should be allowed before application of topcoat.

NOTE: Do NOT use cellulose thinners.

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APPLICATION INFORMATION

SPRAY – Suitable for large, flat and uneven surfaces – Continue

Conventional spray

- Thin **Hammerite No1 Rust Beater** with 10% **Hammerite Brush Cleaner & Thinners**
- Set professional spray gun to between 25/35 psi (approximately 2 Bar)
- Use a full fan spray at maximum volume.
- Apply 3-4 thin coats allowing approximately 30-60 minutes between coats. Do not leave too long between coats as this could lead to wrinkles forming. The final coat should be sprayed heavily enough to flow to a glossy finish avoiding runs and sags.
- Apply topcoat after minimum 6hours.
- For best results allow 24 hours before application of topcoat.

Airless spray

- If necessary thin 15% **Hammerite Brush Cleaner & Thinners**.
- Fluid pressure: 2500 – 3000 psi (approximately 170 Bar)
- Nozzle size: 375-500 microns / 0.015 – 0.020"
- Apply 2-3 coats, leaving each coat for approximately 1 hour or until it is touch dry before further coats
- NOTE: Do NOT use cellulose thinners.

Thinner	Thinning not recommended. Ready for use after thorough stirring for brush applications. Use Hammerite Brush Cleaner & Thinners as stipulated for roller and respective spray applications.
Drying Time	Drying times when applied by brush or roller (under good dry conditions, 23°C): Touch dry – 2 hour Tack free - 3 hours
Recoating Time	6 Hours. (with itself/other alkyds). For best results, 24 hours should be allowed before application of topcoat.
Cleaning of equipment	After use, remove as much product as possible, and then clean immediately with Hammerite Brush Cleaner & Thinner NOTE: Do NOT use cellulose thinners.
Substrates	Suitable for rusted metal surfaces and bare ferrous surfaces, e.g. cast ironwork, machinery, railings, street furniture, structural steel work, shot, grit and blasted steel.

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APPLICATION INFORMATION

Precautions:	Do not apply during cold (below 10°C) or wet weather. Special precautions should be taken to avoid inhalation of dust during surface preparation of pre-1960's paint surfaces over wood and metal as they may contain harmful lead. <u>Not suitable for:</u> Contact with potable water/foodstuffs, permanent immersion, or use on non-ferrous metals.
Coats Required	Apply one or two coats to achieve the recommended minimum dry film thickness.
Top Coating	Apply Hammerite Direct To Rust Metal Paint after a minimum of 6 hours. For best results allow 24 hours.

SURFACE PREPARATION

Special precautions should be taken during surface preparation of pre-1960s paint surfaces over wood and metal as they may contain harmful lead.

- Ensure surface is dry and free from loose rust, paint, oil and grease.
- For maximum adhesion remove all loose rust and paint with a wire brush.
- Remove dirt and salt deposits with dilute detergent, rinse with fresh water and allow drying.
- Degrease bare metal with **Hammerite Brush Cleaner & Thinners** and allow drying.
- Abrade clean steel with abrasive paper to provide a key. Remove dust
- Recommended minimum preparation standard: St2 (SIS 05 59 00) via wire brushing in 2 directions.

HEALTH AND SAFETY INFORMATION

Solvent-based paint are flammable. **Hammerite** paints contains no added lead.

Avoid contact with skin or eyes. Keep out of reach of children. If accidentally swallowed, seek medical advice immediately and show this container to the doctor. Dry sanding, flame cutting and/or welding of the dry paint film will give rise to dust and/or hazardous fumes. Wet sanding should be used wherever possible.

If exposure cannot be avoided by the provision of local exhaust ventilation, suitable respiratory protective equipment should be used. Do not empty into drains or watercourses.

Ensure good ventilation during application and drying. It is recommended to use suitable protective clothing and equipment. To avoid the risk of spillage, always store and transport containers in a secure upright position. Refer to Material Safety Data Sheet for complete information.

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ADDITIONAL INFORMATION

Packaging	250ml, 500ml, 1Lt, 5Lt.
Storage Conditions	Store in a well-ventilated area below 25°C. Store in a dry, well ventilated area. Protect from extremes of temperature, i.e. frost and strong sunlight.
Shelf Life	<u>Tins:</u> Maximum 2 years at 21°C stored in original, unopened container.
Disclaimers	Hammerite is intended for decorative applications and hence is not recommended for heavy industrial or high end performance coatings applications.

TDS STANDARD DISCLAIMER

The recommendations contained herein are given in good faith and meant to guide the specifier or user in accordance with good painting practices. They are gained from our tests and experiences and are believed to be accurate and reliable. No warranty/guarantee is implied by the recommendations contained herein since the conditions of use; application method, substrate and cleanliness of the substrate are beyond Dulux control.

Important Note; Technology may change with time, necessitating changes to this Technical Data Sheet (TDS).

It is the responsibility of the user to ensure that the latest TDS is being used for reference. Dulux Technical Data Sheets are available on our website www.duluxtrade.co.za or please contact: Dulux On-Line on 0860 330 111.

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