

Product Description: ICS Hammertone Silver Metallic Tint Base

PRODUCT CODES: IB-0686 – Hammertone Silver Metallic

DESCRIPTION: ICS Hammertone Silver Metallic is a fast drying, versatile, industrial finishing enamel for manufacturers of metal products. It can be tinted in the ICS color system. Use 844 colorants and clear base formulas, cutting the formula in half to approximate color of the ICS chip. It offers a quick dry time and an appealing hammertone finish for interior use only.

PHYSICAL PROPERTIES:

Weight Solids: 38%
Volume Solids: 32%
Resin Type: Alkyd
Gloss: 90+ at 60°
Theoretical Coverage: 515 square feet at 1.0 mil
Weight per Gallon: 7.0 to 9.0 pounds
Viscosity: Craftsman Cup – 43 to 46 seconds at 77°F
EPA VOC: 4.8 pounds per gallon

SURFACE PREPARATION: The service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 to an average profile of 1.5 mils and then coated before flash rusting occurs. For long term corrosion protection, a primer is recommended.

Steel: ICS Hammertone Silver Metallic may be applied over steel and other properly prepared substrates. Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing.
Aluminum/Galvanized: Aluminum and galvanized should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer or acrylic latex primer.

REDUCTION: ICS Hammertone Silver Metallic may be reduced with most aromatic solvents. Xylene N-3023 is the recommended “fast” reducer for application in cooler temperatures. D-100 N-3065 can be used as a “slow” reducer to help the applied coating flow during warmer conditions. For a larger hammer pattern, do not reduce.

APPLICATION: ICS Hammertone Silver Metallic may be used for one-coat, direct to metal applications; however a primer is required for long term corrosion protection. N-7019 Urethane Hardener can be used 8A:1B ratio for enhanced cure, gloss, and abrasion resistance. A 15 minute induction period is required before applying. The pot life will be approximately 24 hours. If a hardener is used, ICS Hammertone Silver Metallic must be applied over a primer.

Airless: For airless or air-assist airless application, apply ICS Hammertone Silver Metallic without reduction. Airless tip sizes should be in the .015 to .019 range.
Conventional Air: For air spray or conventional reduce sparingly. Viscosity should be in the 30 second plus range #2 Zahn cup with lower atomizing air pressures.
Dry Film Thickness: Dry film thicknesses required are 1.0 to 2.0 mils above profile. Recoat at tack free or up to approximately 4 hours. After 4 hours apply a small test patch to check for evidence of lifting before proceeding with a full recoat.

Product Name

- DRY TIMES:** ICS Hammertone Silver Metallic will dry to handle in about 30 minutes depending on film thickness, humidity, temperature, and air movement. Dry through times may take a day or more. Full adhesion will be gained after 2 to 3 days drying time. Always check for evidence of lifting before proceeding with a full recoat. Lifting will typically occur between 4 to 24 hours.
- CLEAN UP:** Use xylol to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.
- SAFETY PRECAUTIONS:** Contains aromatic solvents. Vapor and spray mist harmful. Use proper respiratory protection. Refer to SDS for specific information.