

Technical Data Sheet

Indofast 4025HT

Modified Alkyd based Rapid Drying Hammer Tone Finish

Product Description

This is a one component fast air drying Hammer Tone finish. It has a glossy finish with good gloss retention. To be used in internal areas or in low to mild industrial environments.

Recommended Use

This product is recommended as topcoat with suitable primers for better aesthetics and decorative looks. Indofast 4025HT is specially developed finish for fast productivity and better durability than conventional alkyd based hammer finishes. It is recommended on structural steels, casting and forging components such as Electrical Motors and Pumps, Furniture and General fabrication industries for protecting Steel.

Physical Data

Colour	: Limited Customized Shades
Finish	: Glossy
Soild by Volume	: 42 ± 3%
Supply Weight (Kg/ Ltr)	: 1.00±0.05
Flash Point	: 25° C
Dry Heat Resistance	: Intermittent : 60°C
Shelf Life	: 12 months

Film Thickness

Recommended film thickness per coat

Dry Film Thickness	: 30-50μ in single coat
Wet Film Thickness	: 70-120μ in single coat
Therotical Coverage Rate	: 14.00 sq.mt / lit at recommended DFT of 30μ

Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning. This product is suitable for use over phosphate washed steel.

Primed Surface: The primed surface should be dry and free from all contamination and Indofast 4025HT should be applied within the overcoating intervals specified in primer TDS. Area of damaged primer or rework etc should be prepared as per specified standards, either by power tool cleaning or other means.

Bare Steel: Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007). Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner. A surface profile of 30-40 microns is recommended.

Application Data

Application Method	: Conventional Spray, Brush only for small Areas
Mixing Ratio	: One Component Coating
Pot Life	: NA
Thinner and Cleaner	: Indokote Thinner (IK.708)
Airless Nozzle Orifice	: NA
Nozzle Pressure	: NA

Working Precautions: Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommences with freshly mixed units.

Maintenance: Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Drying Characteristics

Surface Dry	: 10 mins
Touch Dry (to Handle)	: 45 mins
Hard Dry	: 24 Hours
Overcoating Interval	: Minimum 24 Hours

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Compatibility

Previous Coating	: Epoxy, Epoxy MIO, Modified Alkyd
Subsequent Coating	: Only Self

Product Features

The gloss level is subject to application method, dry film thickness and environmental conditions within a controlled OEM painting facility. Gloss level achieved may differ if there is excessive variation in cure temperature and application thickness. The best results in terms of gloss and appearance will always be obtained by air spray application.

This product must only be thinned using the recommended thinner. The use of alternative thinners, might contains alcohols, can severely affect the curing mechanism of the coating. Indofast 4025HT should be applied at least 3°C temperatures above dew point. During winters or at low temperature areas, condensation occurring during or immediately after application may result in a matt finish and an inferior film.

All products based on modified alkyd are most suitable for the protection of light industrial steelwork in internal dry environments or on exposed steelwork which is situated in low corrosivity environments corresponding to ISO12944 C1, C2. and are subject to a degree of yellowing and chalking and this will result in the loss of gloss and fading of the specified colour over a period of time.

Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

Precaution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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