

| Introduction

Alka 415 or Hammer tone Finish is a decorative industrial coating formulated to produce a distinctive hammered metallic appearance with excellent durability and decorative protection. The product provides good adhesion, fast drying properties, and attractive metallic texture suitable for industrial and decorative metal surfaces.

Hammer Tone Finish is a decorative and protective industrial coating known for its distinctive textured, hammered-metal appearance. The finish creates a patterned surface that resembles hand-hammered metal, helping to hide minor surface imperfections such as scratches, dents, and unevenness. It is widely used on machinery, tools, electrical panels, metal furniture, automotive components, and industrial equipment.

This coating is formulated using special resins, metallic pigments, and silicone additives that produce the unique textured effect during drying. In addition to its decorative appearance, Hammer Tone Finish provides good resistance to moisture, wear, mild chemicals, and corrosion, making it suitable for both functional and aesthetic applications.

Hammer tone coatings are available in various colours such as silver, grey, blue, green, and bronze. They can be applied by spray application for the best visual effect. The finish is valued for its durability, attractive industrial look, and ability to maintain a clean appearance even under demanding operating conditions.

| Where it could be used.

Hammer Tone Finish is commonly used on metal surfaces where both protection and an attractive industrial appearance are required. Its textured pattern helps conceal minor surface defects, making it ideal for equipment and fabricated metal products.

- Industrial Machinery: Machine bodies, covers, compressors, pumps
- Electrical Equipment: Control panels, switchboards, transformer housings
- Automotive Parts: Toolboxes, chassis parts, workshop equipment
- Metal Furniture : Cabinets, lockers, office furniture
- Hand Tools & Equipment: Tool cabinets, benches, workshop tools
- Fabricated Metal Products: Steel enclosures, brackets, metal frames
- Home Appliances: Vintage or industrial-style metal appliances
- Garage & Workshop Items: Storage racks, trolleys, metal shelves
- Agricultural Equipment: Farm machinery and metal implements
- Decorative Metalwork: Railings, gates, industrial décor items

| Compatible Substrates

This coating system may be applied over:

- Zinc phosphate primers
- Etch primers for galvanised steel
- Existing aged coatings after compatibility testing
- Properly prepared steel and fabricated metal surfaces
- Outdoor / Corrosive Environments: Epoxy or Anti-Corrosive Primer

Where maintenance repainting is required, damaged or exposed metal areas should be spot-primed before topcoat application.

| How to Apply

Surface Preparation

- Remove all grease, oil, dirt, salts, and loose contaminants before coating,
- Abrade glossy or weathered coatings to promote adhesion,
- Ensure substrate is dry and free from surface contamination prior to application,
- Galvanised substrates should be treated with a suitable etching primer before top coating,
- Ensure repaired or exposed steel areas are appropriately primed.

Recommended Application Methods

- Conventional spray
- Airless spray
- Brush or roller for small areas and touch-up work
- Temperature: 10°C – 40°C
- Relative Humidity: Below 85%
- Thinner: Toluene / Xylene blend
- Equipment cleaning: Same as thinner

Drying Stage	Typical Time
Touch Dry	15 – 20 Minutes
Hard Dry	4 – 6 Hours
Recoating Interval	6 – 8 Hours
Full Cure	5 – 7 Days

Storage Conditions

Store in a cool, dry, and well-ventilated area away from direct sunlight and sources of ignition. Recommended storage temperature: 5°C – 35°C.

Shelf life

12 months in unopened original containers under recommended storage conditions

Health & Safety

Use only in well-ventilated areas. Wear appropriate PPE during application. Keep away from heat, sparks, and open flames. Refer to SDS before use.

Environmental Information

- Prevent coating materials and solvents from entering waterways or drainage systems.
- Dispose of waste coatings and solvents according to local environmental regulations.
- Clean application equipment using approved handling and disposal procedures.

| Important Notes

- Do not add any water.
- Do not apply Alka 415 on any substrates where significant vapor pressure may occur.
- Always ensure good ventilation when using Alka 415 in a confined space.
- Freshly applied Alka 415 should be protected from damp, condensation and water for at least 24 hours.
- If in doubt about the use or application of this product, or further information please contact our Alka Technical Department.
- Avoid contact with skin and eyes.
- Wear protective gloves and eye protection during work.
- If skin contact occurs, wash skin thoroughly.
- If in eyes, hold eyes open, flood with warm water and seek medical attention without delay.
- Avoid contact with foodstuffs and utensils.

Alka 415

Hammer tone Coating System



A full Material Safety Data Sheet is available from Alka on request.

Property	Typical Description / Value for Hammer Tone Finish
Appearance	Decorative hammered metallic textured finish
Colours	Silver, Charcoal, Blue, Green, Copper
Surface Hardness	Hard, durable, scratch-resistant finish
Solvent Resistance	Good resistance to mild solvents, oils, and grease
Dry Film Condition	Tough, textured, decorative protective film
Recommended Reducer	Synthetic enamel thinner or recommended reducer
Recommended Thinning	Typically, 10–20% for spray application
Theoretical Coverage	Approximately 8–12 m ² /L depending on film thickness
Initial Surface Dry	15–30 minutes at 25°C
Recoat Window	Usually 4–8 hours depending on temperature
Gloss Level	Semi-gloss to metallic sheen finish
Volume Solids	42 ± 2 %
Specific Gravity	0.95 – 1.10
Packaging	Available in 1 Litre, 4 Litre, 20 Litre, and 200 Litre containers.

Performance Notes:

- Actual spreading rate depends on surface texture, film build, and application losses.
- Increased coating thickness or adverse weather conditions may extend drying times.

All products are subject to Alka terms and conditions. Read the full version on our website prior to any purchase.

| Contact us

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