

## Hammer-effect coating, oxidatively drying, based on WorleeKyd SM 400

Formulation	Raw Material	Supplier	A	B
			% by wt.	% by wt.
1.	WorleeKyd SM 400, approx. 60% in xylen	(1)	77.00	77.00
2.	<b>Borchi® Gol LA 232</b>	(2)	0.10	0.10
3.	<b>Borchi® Gol 3451</b>	(2)	0.25	0.50
4.	<b>Octa-Soligen® 69</b>	(2)	0.40	0.40
5.	Xylen		4.00	4.00
6.	Solvesso 100		15.15	14.90
7.	Metal paste*		3.00	3.00
8.	<b>Borchi® Nox M2</b>	(2)	0.10	0.10
	<b>Total</b>		<b>100.00</b>	<b>100.00</b>
<i>Add const. 1.-7. one by one and homogenize for about 15 min at 1000 U/min. Then add const.8. and stir further for about 10 min. at 500 U/min.</i>				
Metal paste-formulation*	Stapa Hydroxal WH 1515 n.l.**	(3)		25.00
	Dowanol DPnB	(4)		75.00
	<b>Total</b>			<b>100.00</b>
A - fine structure				
B - widish structure				

## Data

		A & B
Flow time, DIN 53211-cup 4mm nozzle; at 23 °C		ap. 35 s
Solids content on application		ap. 47 %
Metallic pigment - content		ap. 0.75 %
Drying	dust-free:	ap. 30 min
	touch-free:	ap. 60 min
Pendulum hardness, (König method) DIN EN ISO 1522, after 24 h		ap. 120 s
Gloss Gardner (20°/ 60° angle), DIN 67530 / ISO 2813 after 7 days drying at room temperature		70 / 93

## Suppliers

- (1) Worlée ([www.worlee.de](http://www.worlee.de))
- (2) Borchers ([www.borchers.com](http://www.borchers.com))
- (3) Eckart Pigments ([www.eckart.de](http://www.eckart.de))
- (4) Reininghaus ([www.reininghaus.de](http://www.reininghaus.de))

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