

**PRODUCT:** 6ES1006  
**DESCRIPTION:** Clear Hammer Tone / Dew Effect  
**USE:** Interior furniture and cabinets  
**APPLICATION SYSTEM:** Traditional Spray Gun

**CHEMICAL - PHYSICAL CHARACTERISTICS**

**SPECIFIC GRAVITY:** 1.080 ± 0.100 (Kg/l at 68°)  
**DENSITY (WPG):** 9.01 ± 0.100 (lbs/gal US at 68° F)  
**WEIGHT SOLIDS:** 47% ± 1  
**VOLUME SOLIDS:** 36.37% ± 1  
**VISCOSITY:** 110" ± 2" (DIN6 at 68° F)  
**VOC (material):** 5.78 lbs/gal US or 572.40 g/l  
**VOC (coating):** 5.78 lb/ga US or 572.40 g/l  
**VOC Ratio:** 1.13 lbs VOC/lbs Solids  
**HAPS Ratio:** 0.047 lbs HAPS/lbs solids

**PREPARATION OF THE PRODUCT**

**6ES1006:** 100 parts by weight  
**6CTH3:** 100 parts by weight  
**DPU820** 20 parts by weight

**6ES1006** 100 parts by volume  
**6CTH3** 100 parts by volume  
**DPU820** 20 - 30 parts by volume

**Pot-Life:** 2 hours

**This product meets U.S.A. TSCA regulations.**

**APPLICATION CHARACTERISTICS**

**APPLICATION AMOUNTS:** 120-140 g/mq 5 – 7 (wet mils)  
**NUMBER OF COATS:** 1  
**At 68° F (4 wet mils)**

**- DUST FREE:** 15-20 minutes  
**- MARK-PROOF:** 40 minutes  
**- OVERCOATABLE:** 3 hours  
**-STACKABLE:** 24 hours

**Suggested painting system on MDF substrates**

Product	6CTH3	Polyurethane thinner	Note	Drying time (hours)
White pigmented polyester basecoat or polyurethane basecoat			2 coats as per TDS specifications	
Sanding				
Matt polyurethane topcoat			1 coat as per TDS specifications	
Flash off				4
6es1006	100wt	20	1 coat	
6es1006	100wt	20	apply at low pressure, drop by drop, on the previous layer, wet on wet	
Flash off				4
High gloss acrylic transparent topcoat			1 coat as specified in TDS	

**GENERAL PROPERTIES**

6ES1006 is a Special Hammer Tone / Dew Effect. This special effect is best applied over a polyester, polyurethane basecoat or PU pigmented topcoat. The appearance of the final coating can vary and can be random. It is best to practice on a sample piece before committing to your project.

If excessive pin holes are an issue, substitute DPU530 or DPU520. This coating should be topcoated within two hours without sanding.

**SHELF LIFE:** 12 months

Data refers to product stored in original, sealed packing.

**STORAGE:** Keep in a cool, well ventilated place; temperature should not exceed 77°- 82.4° F.

**Company Information:** SIRCA S.p.A. has a quality system certified by DNV GL ISO 9001



The information supplied are correct to the best of our knowledge. However, as the coating process depends on many variables and the present application takes place without our supervision, we cannot assume any responsibility for the final result. Sirca guarantees that chemical and physical characteristics of the products are within the reported range. Due to the large variety of substrates and application devices, the purchaser/user should test our products in his own application conditions and safety and environment circumstances. Sirca's technical and sales departments are at customer's disposal for any further information regarding correct application of our products.