

PRODUCT DATA

COMBICOLOR® METAL 7300/7400

DESCRIPTION

RUST-OLEUM® CombiColor Metal 7300/7400 coating is primer and topcoat in one, based on a urethane modified alkyd, providing good drying properties at low temperatures. The product contains rust-inhibitive pigments and is lead- and chromate free.

RECOMMENDED USES

RUST-OLEUM CombiColor Metal 7300/7400 should be applied on bare, manually derusted or with CombiPrimer Anti-Corrosion 3369/3380 primed steel. CombiColor Metal is intended for brush and roller application and can also be applied by air spray.

RUST-OLEUM CombiColor Metal 7300/7400 offers corrosion protection in a light industrial environment.

For metal structures in a more aggressive industrial environment, prior application of a RUST-OLEUM CombiPrimer Anti-Corrosion 3369/3380 is recommended.

TECHNICAL DATA

Appearance:	High gloss, Satin (black and white), Flat (black and white).
Colour:	See colour card. Satin and High gloss are also available as tint base.
Density:	High gloss/flat: 1.07 kg/l. ± 0.09 depending on colour Satin: 1,22 kg/l. ± 0,10 depending on colour
Solids Content:	High gloss/flat: 54.6% by volume ± 2.0 depending on colour Satin: 50,6 volume % ± 2,0 depending on colour
Viscosity:	High gloss/flat: 100 - 104 KU / Krebs Stormer Units at 20°C Satin: 86 - 91 KU /Krebs Stormer Units bij 20°C
Recommended film thickness:	55 µm dry, equals 100 µm wet
VOC-content:	439 g/l max.
Ready-to-use mixture:	495 g/l max.
Category:	A/i
EU Limit values:	600 g/l (2007) / 500 g/l (2010)

Drying times	20°C/50% r.h.	10°C/60% r.h.	30°C/50% r.h.
To touch:	2 hours	3 hours	1 ½ hours
To handle:	8 hours	16 hours	6 hours
To recoat:	After 16 hours	After 24 hours	After 8 hours
Full hardness	7 days	14 days	5 days

Heat resistance: 90°C (dry heat), at elevated temperatures discoloration may occur.

Coverage

Theoretical:	10.3 m ² /l at 55 µm dry, depending on colour.
Practical:	Practical coverage depends on many factors such as porosity and roughness of the substrate and material losses during application.

SURFACE PREPARATION

Remove oil, grease and all other surface contaminations by alkaline or high pressure (steam) cleaning in combination with appropriate detergents. Remove rust scale, loose mill scale, loose rust and loose coatings by scraping and wire brushing to St 3 (ISO 8501-1 : 1988), light blast cleaning or sanding. Sand intact coatings to roughen the surface slightly.

The surface must be clean and dry during application. Galvanised, Zinc and Aluminium surfaces have to be primed first with CombiPrimer Tack Coat 3302.

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DIRECTION FOR USE

To ensure homogeneity, coating materials should be thoroughly stirred prior to use.

APPLICATION & THINNING

- Brush: Up to 10 vol. %; RUST-OLEUM Thinner 7301.
Use natural bristles, long hair brushes.
- Roller: Up to 10 vol. %; RUST-OLEUM Thinner 7301.
Use short nap, poly-amid (Perlon) 6-12 mm rollers.
Roller application may require 2 coats to achieve recommended dry film thickness
- Air-atomised spray: 10-25 vol.%; RUST-OLEUM Thinner 7301.
Gravity cup and pressure cup.
Tip size: 1.0 -1.5 mm.
Atomising pressure: 2 - 4 bar.
- Cleanup: Use RUST-OLEUM Thinner 7301 or RUST-OLEUM Thinner 160.

APPLICATION CONDITIONS

Temperature of air, substrate and coating material between 5° and 35°C and relative humidity below 85%. The substrate temperature must be at least 3°C above dew point.

REMARKS

Maximum dry film thickness per coat: 75 µm dry, equals 135 µm wet.
To avoid inhomogeneous appearance with aluminum colored coatings it is recommended to spray 7311 with HVLP.
CombiColor Metal 7300/7400 can be recoated with 7300 Aerosols within 4 hours or after 72 hours.

SAFETY

Consult Safety Data Sheet and Safety Information printed on the can.

SHELLIFE / STORAGE CONDITIONS

5 years from date of production in unopened cans, if stored in dry, well ventilated areas, not in direct sunlight at temperatures between 5° and 35°C.

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