

RUST-OLEUM®
INDUSTRIAL



COMBICOLOR® HAMMERTONE GOLD-COPPER-BROWN

One coat system for metal protection, direct to rust

- Primer and topcoat in one
- For application onto rust, bare metal
- High coverage: 10.5 m² per litre
- Sag resistant, no brush strokes
- White spirit dilutable

KNOW-HOW TO PROTECT™

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COMBICOLOR® HAMMERTONE GOLD-COPPER-BROWN

DESCRIPTION

RUST-OLEUM® CombiColor Metal coating 7345/7362/7374 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 USE

CombiColor Hammertone 7300 can be applied directly on bare, manually derusted or with CombiPrimer Anti-Corrosion 3369/3380 primed steel. CombiColor Hammertone 7300 is intended for brush and roller application and can also be applied by air spray. On properly primed or previously coated surfaces CombiColor Hammertone 7300 offers corrosion protection in a light industrial environment. For metal structures in a more aggressive industrial environment, application of an additional CombiPrimer Anti-Corrosion 3369/3380 is recommended or a second coat of CombiColor Hammertone 7300 can be applied.

TECHNICAL DATA

Density: 1.0 kg/l
Gloss Level: Gloss
Solids content in volume: 41.5%
Heat Resistance: 90°C (dry heat), at 60 °C discoloration may occur.

DRYING TIMES AT 20°C/RH 50%

Touch dry: 1 ½ hours (20°C), 2 hours (10°C), ¾ hours (30°C)
Dry to handle: 5 hours (20°C), 10 hours (10°C), 3 hours (30°C)
Dry to recoat: 16 hours (20°C), 24 hours (10°C), 8 hours (30°C)
Fully cured: 7 days (20°C), 10 days (10°C), 5 days (30°C)

THEORETICAL CONSUMPTION

8.0 - 8.5 m²/l, depending on colour.

PRACTICAL CONSUMPTION

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 contamination 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 St3 (ISO 8501-1: 1988), light blast cleaning or sanding, followed by priming with the recommended CombiPrimer Anti-Corrosion 3369/3380. Sand previous coatings in good condition to provide a key for adhesion and check compatibility. The surface must be clean and dry during application. Galvanised, Zinc and Aluminium surfaces have to be primed first with CombiPrimer Tack Coat 3302.

DIRECTIONS FOR USE

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

APPLICATION CONDITIONS

Temperature of air, substrate and coating material between 10 and 35°C, relative humidity below 85%. The substrate temperature must be at least 3°C above dew point.

APPLICATION & THINNING: BRUSH

Up to 10 vol. % with 7301. Use natural bristles, long hair flat brushes for optimal hammertone appearance.

APPLICATION & THINNING: ROLLER

Up to 10 vol. % with 7301. Use short nap poly-amide (Perlon 6 - 12 mm) rollers.

APPLICATION & THINNING: AIR-ATOMISED SPRAY

10-25 vol.% Rust-Oleum Thinner 7302. Gravity cup and pressure cup. Tip size: 1.0 - 1.5 mm. Atomising pressure 2 - 4 bar.

CLEANING OF EQUIPMENT / SPILLS

Use Rust-Oleum Thinner 7301 or mineral spirits.

REMARKS

Brushes, rollers and cleaning solvents should only be used for hammertone application.

SAFETY DATA

VOC ready mix: 477 g/l
VOC category: A/i
VOC limit: 500 g/l
Grenelle: C
Remarks regarding safety: Brushes, rollers and cleaning solvents should only be used for hammertone application.

SHELF LIFE

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.

Date issued: 11/01/2019

Available colours & pack sizes : Please refer to the respective product page on www.rust-oleum.eu for an overview of actual available colours and pack sizes.

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