

**RUST-OLEUM®**  
— INDUSTRIAL —



## COMBICOLOR® ORIGINAL



# One coat system for metal protection, direct to rust.

- Primer and topcoat in one
- For application onto rust, bare metal
- High coverage: 10.5 m<sup>2</sup> per litre
- Sag resistant, no brush strokes
- Usable down to 5°C

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[WWW.RUST-OLEUM.EU](http://WWW.RUST-OLEUM.EU)

# COMBICOLOR® ORIGINAL

## 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 USE

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

Density (g/cm <sup>3</sup> ):	Gloss= 0.9-1.10 (Black - White), Satin=1.13-1.3 (Black - White)
Gloss Level:	Gloss, Matt, Metallic, Satin
Gloss level at 60°:	Gloss:95% Satin 30-50%
Solids Content in weight:	GLOSS 62,5± 3% SATIN: 64± 4% MATT: 73± 2%
Solids content in volume:	GLOSS and MATT 53-57%. SATIN 48-52%
Heat Resistance:	90°C (dry heat), at elevated temperatures discoloration may occur.

## DRY TIMES BY 20° C/RV 50%

Touch dry:	2 hours (20°C), 3 hours (10°C), 1 ½ hours (30°C)
Dry to handle:	8 hours (20°C), 16 hours (10°C), 6 hours (30°C)
Dry to recoat:	16 hours (20°C), 24 hours (10°C), 8 hours (30°C)
Fully cured:	7 days (20°C), 14 days (10°C), 5 days (30°C)

## RECOMMENDED WET FILM THICKNESS

100 µm

## RECOMMENDED DRY FILM THICKNESS

55 µm

## THEORETICAL CONSUMPTION

10.3 m<sup>2</sup>/l at 55 µm dry, 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 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.

## 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 5° and 35°C and relative humidity below 85%. The substrate temperature must be at least 3°C above dew point.

## APPLICATION & THINNING: BRUSH

Up to 10% volume RUST-OLEUM Thinner 7301. Use natural bristles, long hair brushes.

## APPLICATION & THINNING: ROLLER

Up to 10% volume RUST-OLEUM Thinner 7301. Use short nap, polyamide 6-12 mm rollers. Roller application may require 2 coats to achieve recommended dry film thickness

## APPLICATION & THINNING: AIR-ATOMISED SPRAY

10-25% volume RUST-OLEUM Thinner 7301. 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 RUST-OLEUM Thinner 160.

## 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 DATA

VOC level:	439 g/l
VOC ready mix:	495 g/l
VOC category:	A/i
VOC limit:	500 g/l
Remarks regarding safety:	Consult Safety Data Sheet and Safety Information printed on the can. Gold version contains a separate Safety Data Sheet.

## 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.

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**Available colours & pack sizes:** Please refer to the respective product page on [www.rust-oleum.eu](http://www.rust-oleum.eu) for an overview of actual available colours and pack sizes.

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