

PRODUCT DATA

COMBICOLOR® HAMMERTONE 7300

DESCRIPTION

CombiColor® Hammertone 7300 coatings are based on a urethane modified alkyd. The coatings are lead- and chromate-free and contain rust-inhibitive pigments for additional corrosion protection.

RECOMMENDED USES

CombiColor Hammertone 7300 can be applied directly on bare steel or manually derusted steel which is primed with CombiPrimer Anti-Corrosion 3369/3380. 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

Appearance:	Hammertone
Colour:	see colour card
Density:	1.0 kg/l. $\pm$ 0.1 depending on colour
Solids Content:	41.5 % by volume $\pm$ 1.0 depending on colour
Viscosity:	90 - 100 KU / Krebs Stormer Units at 20°C
Recommended film thickness:	N.a.
VOC-content:	325-350 g/l

Drying times	20°C/50% r.h.	10°C/60% r.h.	30°C/50% r.h.
To touch:	1 ½ hours	2 hours	¾ hours
To handle:	5 hours	10 hours	3 hours
To recoat:	After 16 hours	24 hours	8 hours
Full hardness	7 days	10 days	5 days

Heat resistance: 90°C (dry heat), at 60 °C discoloration may occur.

Coverage

Theoretical:	10.5 m²/l, 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 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.

DIRECTION FOR USE

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

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APPLICATION & THINNING

- Brush:** Up to 10 vol. % with 7301.
Use natural bristles, long hair flat brushes for optimal hammertone appearance.
- Roller:** Up to 10 vol. % with 7301.
Use short nap poly-amide (Perlon 6 - 12 mm) rollers.
- 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.
- Cleanup:** Use Rust-Oleum Thinner 7301 or mineral spirits.

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.

REMARKS

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

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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