

PRODUCT DATA

COMBIPRIMER ANTI-CORROSION 3369 Red/3380 Grey

Andrews Coatings Ltd
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DESCRIPTION

RUST-OLEUM® CombiPrimer Anti-Corrosion 3369 Red / 3380 Grey are fast drying primers based on an aromatic free short oil alkyd resin. The products contain rust-inhibitive pigments and are lead- and chromate free.

RECOMMENDED USES

RUST-OLEUM CombiPrimer should be used on new or rusted steel surfaces to provide and enhance protection against corrosion.

CombiPrimer Anti-Corrosion is primarily intended for brush application and can also be applied by roller and air spray.

CombiPrimer Anti-Corrosion should be used in general industrial exposures, normal humidity and interior applications and should be recoated with CombiColor Metal 7300.

TECHNICAL DATA

Appearance: Flat
Colour: 3369 Red and 3380 Grey
Density: 1.21 kg/ltr.
Solids Content: 44.8% by volume
Viscosity: 85 - 90 KU /Krebs Stormer Units at 20°C
Recommended film thickness: 35 µm dry, equals 80 µm wet

VOC-content: 424 g/l max.
Ready-to-use mixture: 490 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:	1 hour	2 hours	½ hours
To handle:	2 hour	4 hours	1 hours
To recoat:	After 2 hours	After 4 hours	After 1 hour
Full hardness	7 days	14 days	5 days

Heat resistance: 120°C (dry heat)

Coverage

Theoretical: 12.8 m²/l at 35 µm dry

Practical: Practical coverage depends on many factors such as porosity and roughness of the substrate and material losses during application.

SURFACE PREPARATION

Remove grease, oil 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 2/3 (ISO 8501-1 : 1988). Sand intact coatings to roughen the surface slightly. The surface must be clean and dry during application.

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. %; RUST-OLEUM Thinner 7301.
Use natural bristles, longhair brushes.
- Roller: Up to 10 vol. %; RUST-OLEUM Thinner 7301.
Use medium nap, perlon 8-12 mm. rollers.
Roller application may require 2 coats to achieve recommended dry film thickness.
- Air-atomised spray: 10-20 vol.%; RUST-OLEUM Thinner 7301.
Gravity cup and pressure cup.
Tip size: 1.2 -1.8 mm.
Atomizing pressure: 2 - 4 bar.
- Cleanup: Use RUST-OLEUM Thinner 7301 or white spirit.

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: 60 µm dry, equals 135 µm wet.

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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