

**RUST-OLEUM®**



**V7400 SYSTEM**

**340 VOC FAST RECOAT RUST-INHIBITIVE PRIMER**

**DESCRIPTION AND USES**

Rust-Oleum® V7400 System Fast Recoat Primers are rust-inhibitive alkyd primers designed for use with Rust-Oleum V7400 System 340 VOC DTM Alkyd Enamel topcoats.

Designed for use on clean, abrasive blasted, sound rusted or previously painted steel surfaces in mild to moderate industrial environments. Not for use on galvanized steel.

**PRODUCTS**

1-Gallon	5-Gallon	Description
V7086402	V7086300	Gray Primer
V769402	V769300	Red Primer
258887	—	White Primer

**COMPANION PRODUCTS**

**RECOMMENDED TOPCOATS**

V7400 System 340 VOC DTM Alkyd Enamel

**PRODUCT APPLICATION**

**SURFACE PREPARATION**

Clean surface with Krud Kutter® Cleaner Degreaser or suitable cleaner and water. Rinse with water and let dry.

**STEEL:** Remove loose rust, mill scale, and deteriorated coatings.

**PREVIOUSLY COATED:** Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding to create a surface profile.

For optimal protection, abrasive blast clean to a Commercial Grade, SSPC-SP-6, with a surface profile of 1-2 mils (25-50µ). Two coats of primer are required on blast cleaned surfaces. This primer is compatible with most alkyds, but a test patch is suggested.

**APPLICATION**

Apply only when air temperature is between 32-100°F (0-38°C) and surface temperature is at least 5°F (3°C) above the dew point.

**PRODUCT APPLICATION (cont.)**

**EQUIPMENT RECOMMENDATIONS**

(Comparable equipment also suitable)

**BRUSH:** Use a good quality synthetic bristle brush.

**ROLLER:** Use a good quality natural or synthetic cover.

**AIR-ATOMIZED SPRAY:**

Method	Fluid Tip	Fluid Delivery	Atomization Pressure
Pressure	0.055-0.070	12-16 oz./min.	25-60 psi
Siphon	0.055-0.070	—	25-60 psi
HVLP (var.)	0.043-0.070	8-10 oz./min.	10 psi (at tip)

**AIRLESS SPRAY:**

Fluid Pressure	Fluid Tip	Filter Mesh
1,600-2,400 psi	0.013-0.017	100

**THINNING**

**BRUSH/ROLLER:** #333402 Thinner: Normally not required.

**AIR ATOMIZED SPRAY:** #333402 Thinner: Use up to 15% as needed.

**AIRLESS SPRAY:** #333402 Thinner: Normally not required. Use 5-10% (approximately ½-2 pints per gallon, if needed).

**CLEAN-UP**

Use 333402 thinner or 254266 Exempt Thinner.

**PERFORMANCE CHARACTERISTICS**

**SYSTEM TESTED**

Primer: Quick Dry Enamel Primer

**PENCIL HARDNESS**

METHOD: ASTM D3363  
RESULT: F

**CONICAL FLEXIBILITY**

METHOD: ASTM D522  
RESULT: >33%

**GLOSS AT 60°**

METHOD: ASTM D4587  
RESULT: 5

For chemical and corrosion resistance, see the Rust-Oleum Industrial Brands Catalog (Form #275585).



**PHYSICAL PROPERTIES**

		<b>PRIMERS</b>
<b>Resin Type</b>		Phenolic Modified Alkyd
<b>Pigment Type</b>		Calcium Borosilicate
<b>Solvents</b>		Aliphatic Hydrocarbons
<b>Weight</b>	<b>Per Gallon</b>	12.8-13.0 lbs.
	<b>Per Liter</b>	1.5-1.6 kg
<b>Solids</b>	<b>By Weight</b>	78.4-79.1%
	<b>By Volume</b>	60.7-60.8%
<b>Volatile Organic Compounds</b>		<340 g/l (2.83 lbs./gal.)
<b>Recommended Dry Film Thickness (DFT) Per Coat</b>		1.5-2.5 mils (37.5-62.5µ)
<b>Wet Film to Achieve DFT (unthinned material)</b>		2.5-4.0 mils (62.5-100µ)
<b>Theoretical Coverage at 1 mil DFT (25µ)</b>		975 sq.ft./gal. (24.0 m <sup>2</sup> /l)
<b>Practical Coverage at Recommended DFT (assumes 15% material loss)</b>		300-550 sq.ft./gal. (7.4-13.5 m <sup>2</sup> /l)
<b>Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity</b>	<b>Tack-free</b>	1-2 hours
	<b>Handle</b>	4-5 hours
	<b>Recoat</b>	After 1 hour or before 4 hours and after 24 hours
<b>Dry Heat Resistance</b>		212°F (100°C)
<b>Shelf Life</b>		5 years
<b>Safety Information</b>		For additional information, see SDS

Calculated values are shown and may vary slightly from the actual manufactured material.

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