RUST-OLEUM® HIGH PERFORMANCE®

7400 SYSTEM
HIGH SOLIDS, QUICK DRY LOW VOC PRIMERS

DESCRIPTION AND USES

Rust-Oleum® Industrial High Solids, Quick Dry Low VOC Primers are high solids, fast drying, modified alkyd primers. Designed for use on clean, abrasive blasted or previously painted steel surfaces. These primers can be used with a variety of topcoats for general maintenance, transportation, and shop applications to comply with VOC requirements of 340 g/l. Can be exposed up to six months without topcoating. Not for use on galvanized steel.

MPI #79 Certified*

PRODUCTS

1-Gallon	5-Gallon	Description
2068402	—	Red
2082402	—	Light Gray

COMPANION PRODUCTS

RECOMMENDED TOPCOATS (for 340 g/l compliance)

3400 System DTM 340 VOC Alkyd Enamel
9700 System 250 VOC Acrylic Polyester Urethane
2500 System DTM 250 VOC Alkyd Enamel
9800 System DTM Urethane Mastic

ADDITIONAL TOPCOATS (for 420 g/l compliance)

Rust-Oleum Industrial High Gloss Urethane with HS9401402 Activator

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Pure Strength Cleaner/Degreaser, item #3599402, commercial detergent or other suitable cleaner. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings.

Abrasive blasting to a minimum Commercial Grade (SSPC-SP-6, NACE 3) with a 1-2 mils (25-50µ) surface profile is recommended for optimal performance. Abrasive blast cleaned steel requires two coats of primer.

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. The Rust-Oleum Industrial Enamel High Solids Quick Dry Low VOC Primers are compatible with most coatings, but a test patch is suggested.

***** Refer to the MPI website for the most current listing of MPI certified products.

PRODUCT APPLICATION (cont.)

APPLICATION

Apply only when the air and surface temperatures are between 32-100°F (0-38°C) and the surface temperature is at least 5°F (3°C) above the dew point. Apply two coats over abrasive blasted steel.

EQUIPMENT RECOMMENDATIONS

BRUSH: Use a good quality natural or synthetic bristle brush.

(For touch-up only)

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atomization
Pressure	0.055-0.070	16 oz./min.	40-60 psi
Siphon	0.055-0.070	—	40-60 psi
HVLP (var.)	0.043-0.070	—	10 psi (at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1600-2400 psi	0.013-0.017	100

THINNING

BRUSH: 333 Thinner*: Use 5-10% if needed (approximately ½ pt./gal.). (For touch-up only)

AIR-ATOMIZED SPRAY: 333 Thinner*: Use 10-20% as needed (~1½ pt./gal.).

AIRLESS SPRAY: 333 Thinner*: Normally not required. Use 5-10% if needed (~½ pt./gal.).

CLEAN UP

333402 Thinner.

*Adding 333402 Thinner will not raise the VOC of the coating. 333402 is exempt from VOC calculation.

Form: 2068990
Rev.: 111414

RUST-OLEUM HIGH PERFORMANCE

TECHNICAL DATA

7400 SYSTEM HIGH SOLIDS, QUICK DRY LOW VOC PRIMERS

PHYSICAL PROPERTIES

		2068402 RED PRIMER	2082402 LIGHT GRAY PRIMER
Resin Type		Modified alkyd	Modified alkyd
Pigment Type		Brown iron oxide, titanium dioxide, calcium carbonate, magnesium silicate, carbon black	Brown iron oxide, titanium dioxide, calcium carbonate, magnesium silicate, carbon black
Solvents		Esters, ketones	Esters, ketones
Weight	**Per Gallon**	13.94 lbs.	13.30 lbs.
	Per Liter	1.7 kg	1.6 kg
Solids	**By Weight**	80.2%	79.3%
	By Volume	60%	60.1%
Volatile Organic Compounds		<340 g/l (2.8 lbs./gal.)	<340 g/l (2.8 lbs./gal.)
Recommended Dry Film (DFT) Per Coat		1.5-2.5 mils (37.5-62.5µ)	1.5-2.5 mils (37.5-62.5µ)
Wet Film to Achieve DFT		2.5-4.0 mils (62.5-100µ)	2.5-4.0 mils (62.5-100µ)
Theoretical Coverage at 1 mil DFT (25µ)		960 sq. ft./gal. (23.6 m^2/l)	960 sq. ft./gal. (23.6 m^2/l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		325-550 sq. ft./gal. (8.0-13.5 m^2/l)	325-550 sq. ft./gal. (8.0-13.5 m^2/l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	**Set to touch**	15-30 minutes	15-30 minutes
	Tack-free	30-60 minutes	30-60 minutes
	Handle	1-2 hours	1-2 hours
	Recoat	After 1 hour	After 1 hour
Dry Heat Resistance		212°F (100°C)	212°F (100°C)
Shelf Life		5 years	5 years
Safety Information		**FLAMMABLE. LIQUID AND VAPOR HARMFUL IF INHALED. MAY AFFECT THE NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. MAY CAUSE NOSE, THROAT, EYE AND SKIN IRRITATION. FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN. SEE THE PRODUCT MATERIAL SAFETY DATA SHEET (MSDS) AND LABEL WARNINGS FOR ADDITIONAL SAFETY INFORMATION.**	

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

The technical data and suggestions for use contained herein are correct to the best of our knowledge, and offered in good faith. The statements of this literature do not constitute a warranty, express, or implied, as to the performance of these products. As conditions and use of our materials are beyond our control, we can guarantee these products only to conform to our standards of quality, and our liability, if any, will be limited to replacement of defective materials. All technical information is subject to change without notice.

RUST-OLEUM INDUSTRIAL BRANDS

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