RUST-OLEUM® HIGH PERFORMANCE®

7400 SYSTEM SHOP COAT PRIMER

DESCRIPTION AND USES

High Performance Industrial Shop Coat Primer is a quick-dry shop coat primer for structural steel.

Ideal for field or shop priming of structural steel. It may also be used for production operations. Designed for use on slightly rusted steel, clean steel and abrasive blasted steel in mild conditions. Not for use on galvanized steel.

PRODUCTS

1-Gallon	5-Gallon	Description
7069402	—	Red

COMPANION PRODUCTS

RECOMMENDED TOPCOATS

7400 System DTM 450 VOC Alkyd Enamel

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,NACE3) with a 1-2 mil (25-50µ) surface profile is recommended for optimal performance.

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 High Performance Industrial Enamel Shop Coat Primer is compatible with most coatings, but a test patch is suggested. WARNING! If you scrape, sand or remove old paint from any surface, you may release lead paint dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-approved respirator to contol lead exposure. Carefully clean up with a wet mop or HEPA vacuum.Before you start, find out how to protect yourself and your family by contacting the U.S.EPA/Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

Form: 1067990
Rev.: 111411

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. Abrasive blast clean steel requires two coats of primer.

EQUIPMENT RECOMMENDATIONS

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

ROLLER: Use a good quality natural or synthetic cover.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atom. Pressure
Pressure	0.055-0.070	10-16 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 (touch-up only): 633 Thinner: Normally not required. Use 5-10% if needed (approximately ½ pint/gallon).

AIR-ATOMIZED SPRAY: 641 Thinner: Use 10-20% or as needed (approximately 1½ pint/gallon).

AIRLESS SPRAY: 641 Thinner: Normally not required. Use 5-10% if needed (approximately ½ pint/gallon).

CLEAN-UP

633402 or 641402 Thinners.

7400 SYSTEM SHOP COAT PRIMER

PHYSICAL PROPERTIES

		SHOP COAT PRIMER
Resin Type		Modified alkyd
Pigment Type		Brown iron oxide, calcium borosilicate, magnesium silicate
Solvents		Xylene, mineral spirits
Weight	**Per Gallon**	11 lbs.
	Per Liter	1.3 kg
Solids	**By Weight**	65%
	By Volume	42%
Volatile Organic Compounds*		Approximately 450 g./l. (3.8 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1-2 mils (25-50µ)
Wet Film to Achieve DFT		2.5-5.0 mils (62.5-125µ)
Theoretical Coverage at 1 mil DFT (25µ)		675 sq. ft./gal. (16.6 m^2/l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		285-575 sq. ft./gal. (7-14 m^2/l)
Dry Times at 70-80°F (21-27°C) and 50% rel. hum.	**Tack-free**	15-30 minutes
	Handle	½-1 hour
	Recoat	24 hours
Dry Heat Resistance		212°F (100°C)
Shelf Life		5 years
Specifications		Can be used in USDA-regulated facilities based on FSIS Directive11,000.4 (Rev.4), November 24,1995.
Safety Information	**Contains**	Lead-free
	Warning!	**FLAMMABLE LIQUID AND VAPOR. HARMFUL IF INHALED. MAY AFFECT NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. CAUSES NOSE, THROAT, EYE AND SKIN IRRITATION. FOR INDUSTRIAL OR COMMERCIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN. SEE THE PRODUCT MATERIAL DATA SAFETY 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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