

<b>ALKYD</b>	<b>TECHNICAL DATA</b>	<b>RO-204</b>
		
<b>ROGALKYD DIRECT TO METAL</b> <b>ALKYD ENAMEL V7400</b>		

## DESCRIPTION AND USES

**ROCA**lkyd Direct-To-Metal Alkyd Enamel V7400 is Rust-Oleum's original rust preventive coatings for interior or exterior use. This product provides chemical and abrasion resistance for metal surfaces anywhere a smooth, hard, durable finish is desired, and corrosion protective performance is required. Available in Flat, Satin, Semi-Gloss and Gloss finishes. There is a metallic aluminum finish available as well. Not for use on galvanized steel.

If desired, **ROCA**lkyd Direct-To-Metal Alkyd Enamel V7400 can be applied direct-to-metal (DTM); however optimal corrosion protection is achieved when the finish coat is used in conjunction with one of the recommended primers. See Two-Year Rust Proof Guarantee Form on this product's web page.

Semi-gloss, satin, and flat finishes should be limited to interior and sheltered exterior use only.

**ROCA**lkyd Direct-To-Metal Alkyd Enamel V7400 complies with USDA FSIS regulatory sanitation performance standards for food establishment facilities.

MPI #9, #48, #81, #96 Certified\*

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

## PRODUCT FEATURES AND BENEFITS

- Easy to Apply, High Hide Formula
- Hard, Durable, Chemical and Abrasion Resistant
- Ultra-Smooth Finish That Resists Chipping, Fading and Weathering
- Excellent Adhesion Over Minimally Prepared Surfaces
- Dries Tack Free in 2 to 4 Hours
- Can be Applied in Temperatures as Low as 32°F
- Two Year Rust-Proof Guarantee\*

## PRODUCTS

### FLAT FINISHES

1-Gallon	5-Gallon	DESCRIPTION
245387	----	Flat Black
245533	----	Flat White

### METALLIC FINISHES

1-Gallon	5-Gallon	DESCRIPTION
245309	----	Aluminum

### SEMI-GLOSS FINISHES

1-Gallon	5-Gallon	DESCRIPTION
245483	----	Semi-Gloss White
323807	----	Semi-Gloss Black

## PRODUCTS (cont.)

### GLOSS FINISHES

1-Gallon	5-Gallon	DESCRIPTION
245308	----	Gloss Almond
245380	----	Gloss Chestnut Brown
245381	----	Gloss Clear (Clear-Sele®)
245382	----	Gloss Dunes Tan
245388	----	Gloss Forest Green
245403	245405	Gloss Black
245406	245407	Gloss White
245409	----	Gloss Machine Tool Gray
245443	245444	Gloss Navy Gray
245474	245475	Gloss Safety Blue
245476	----	Gloss Safety Green
245477	----	Gloss Safety Orange
245478	----	Gloss Safety Red
245479	245480	Gloss Safety Yellow
245484	245485	Gloss Silver Gray
245489	----	Gloss New Caterpillar Yellow
245500	----	Gloss Old Caterpillar Yellow

### TINT BASES

1-Gallon	5-Gallon	DESCRIPTION
245515	----	Gloss Red
245516	----	Gloss Yellow
245517	245530	Gloss Masstone
245518	245531	Gloss Deep
245519	245532	Gloss Light
323815	----	Semi-Gloss Masstone
323809	----	Semi-Gloss Deep
323813	----	Semi-Gloss Light
323816	----	Satin Masstone
323810	----	Satin Deep
323814	----	Satin Light

**RUST-OLEUM®**

HIGH PERFORMANCE

**ROCALKYD DIRECT TO METAL  
ALKYD ENAMEL V7400****PRODUCTS (cont.)****TINT BASE MAXIMUM COLORANT**

1-Gallon	5-Gallon	DESCRIPTION
16 oz.	----	Gloss Red
16 oz.	----	Gloss Yellow
16 oz.	80 oz.	Gloss Masstone
12 oz.	60 oz.	Gloss Deep
8 oz.	40 oz.	Gloss Light
16 oz.	----	Semi-Gloss Masstone
12 oz.	----	Semi-Gloss Deep
8 oz.	----	Semi-Gloss Light
16 oz.	----	Satin Masstone
12 oz.	----	Satin Deep
8 oz.	----	Satin Light

**COMPANION PRODUCTS**

358063	<b>ROCPrime</b> WB Hybrid 1K Epoxy Gray Primer
302140	Universal Alkyd White Primer
330142	Universal Alkyd Gray Primer
330143	Universal Alkyd Red Primer
239503	<b>ROCA</b> kyd Alkyd Accelerator (refer to Application section on this TDS for more information)
333402	Professional Solutions Acetone Thinner

**RUST PROOF GUARANTEE\***

\*Submitting the Two-Year Rust-Proof Guarantee form located on the **ROCA**kyd Direct-To-Metal Alkyd Enamel V7400 web page completely filled out, signed and with proof of purchase attached, no later than 30 days after project completion for projects using up to 50 gallons is required to qualify for the rust-proof guarantee. For projects larger than 50 gallons, please contact Rust-Oleum Technical Service Department at: Rust-Oleum Technical Service Department, 11 Hawthorn Pkwy, Vernon Hills, IL 60061, or email to: [technicalservice@rustoleum.com](mailto:technicalservice@rustoleum.com)

**PRODUCT APPLICATION****SURFACE PREPARATION**

**ALL SURFACES:** (SSPC-SP-1) Remove all dirt, grease, oil, salt, and chemical contaminants by washing the surface with Krud Kutter® PRO Cleaner Degreaser. Mold and mildew must be cleaned with Krud Kutter PRO One Step Cleaner & Disinfectant. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

**STEEL:** (Finishes) Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove loose rust, mill scale, and deteriorated previous coatings. If abrasive blasting cleaning is used, then two coats of primer are required.

**PRODUCT APPLICATION (cont.)****SURFACE PREPARATION (cont.)**

**STEEL:** (Primers) 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 **ROCA**kyd Direct-To-Metal Alkyd Enamel V7400 are compatible with most coatings, but a test patch is suggested.

**WARNING!** If you scrape, sand, or remove old paint, you may release lead 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 control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to [www.epa.gov/lead](http://www.epa.gov/lead).

**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. The relative humidity should not be greater than 85%.

**OPTIONAL:** For accelerated dry time and increased film hardness, use **ROCA**kyd Alkyd Accelerator up to 4 oz. per gallon. Add the **ROCA**kyd Alkyd Accelerator just prior to application of the coating. Mix well. Exceeding the recommended amount will not further enhance benefits. Apply the coating in the normal and recommended manner. Paint that is mixed with the **ROCA**kyd Alkyd Accelerator must be applied in 1-2 hours. Please refer to **ROCA**kyd Alkyd Accelerator TDS for more information.

**EQUIPMENT RECOMMENDATIONS**

(Comparable equipment also suitable)

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

**ROLLER:** Use a good quality lamb's wool or synthetic fiber. Use a short nap roller for smooth surfaces, and a medium nap roller for rough surfaces.

**RUST-OLEUM®**

HIGH PERFORMANCE

**ROCALKYD DIRECT TO METAL  
ALKYD ENAMEL V7400****PRODUCT APPLICATION (cont.)****EQUIPMENT RECOMMENDATIONS (cont.)****AIR-ATOMIZED SPRAY**

Method	Fluid Tip	Fluid Delivery	Atomized Pressure
Pressure	0.055-0.070	16 oz./min.	25-60 psi
Siphon	0.055-0.070	--	25-60 psi
HVLP (var.)	0.043-0.070	8-14 oz./min.	60-90 psi

\*10 psi maximum at tip

**AIRLESS SPRAY (Gloss)**

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

**AIRLESS SPRAY (All Others)**

Fluid Pressure	Fluid Tip	Filter Mesh
1,600-2,400 psi	0.013-0.019	60

**CAUTION:** Protect surrounding surfaces from over spray. Over spray can be wet or dry depending on height of work, weather, environmental conditions, and application equipment. Wet over spray can adhere to unwanted surfaces. Dry over spray may be removed by wiping or washing. Always clean dry over spray from hot surfaces before fusing occurs as surface temperatures can be higher than the air temperature.

**THINNING\***

BRUSH/ROLLER: Normally not required.

AIR ATOMIZED SPRAY: Up to 15% by volume with Professional Solutions Acetone Thinner.

AIRLESS SPRAY: Normally not required. If needed, Thin up to 5% by volume with Professional Solutions Acetone Thinner.

\*Adding Professional Solutions Acetone Thinner will not raise the VOC of the coating. Professional Solutions Acetone Thinner is exempt from VOC calculation.

**CLEAN-UP**

Professional Solutions Acetone Thinner.

**PERFORMANCE CHARACTERISTICS****IMPACT RESISTANCE**

METHOD: ASTM D2794 (Direct)

RESULT: &gt;60

**ACCELERATED WEATHERING (% gloss retention)**

METHOD: ASTM D4587, QUV Type A bulb, 450 hours

RESULT: 78% Gloss Retention (color-black)

**GLOSS at 60°**

METHOD: ASTM D523

RESULT: Gloss Finishes: 80-100

Semi-Gloss Finishes: 40-60

Satin Finishes: 20-35

Flat Finishes: 0-10

**PENCIL HARDNESS**

METHOD: ASTM D3363

RESULT: 5B

**TABER ABRASION**

METHOD: ASTM D4060, CS-17 Wheels, 500 gram load, 1000 cycles

RESULT: 21.2 mg loss

**SYSTEM TESTED- Quick Dry Enamel Primer****PENCIL HARDNESS**

METHOD: ASTM D3363

RESULT: F

**CONICAL FLEXIBILITY**

METHOD: ASTM D522

RESULT: &gt;33%

**GLOSS at 60°**

METHOD: ASTM D4587

RESULT: 5

For chemical and corrosion resistance see the Rust-Oleum Industrial Brands Catalog.

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<b>RUST-OLEUM®</b> HIGH PERFORMANCE	<b>ROCALKYD DIRECT TO METAL</b> <b>ALKYD ENAMEL V7400</b>	

## PHYSICAL PROPERTIES

		FINISHES	TINT BASES	FLAT	METALLIC
<b>Resin Type</b>		Modified Alkyd	Modified Alkyd	Modified Alkyd	Modified Alkyd
<b>Pigment Type</b>		Varies with color	Varies with color	Varies with color	Leafing and non-leafing aluminum
<b>Solvents</b>		Aliphatic and Aromatic Hydrocarbons	Aliphatic and Aromatic Hydrocarbons	Aliphatic and Aromatic Hydrocarbons	Aliphatic and Aromatic Hydrocarbons
<b>Weight</b>	<b>Per Gallon</b>	8.6-10.8 lbs.	9.7-10.9 lbs.	11.4-11.7 lbs.	7.9-8.3 lbs.
	<b>Per Liter</b>	1.0-1.3 kg	1.1-1.3 kg	1.4 kg	0.9-1.0 kg
<b>Solids</b>	<b>By Weight</b>	45.6-65.8%	61-66%	71-75%	49-51%
	<b>By Volume</b>	42.4-49.3%	48.5-50.0%	51-56%	37-39%
<b>Volatile Organic Compounds</b>		<340 g/l (2.83 lbs./gal.)	<340 g/l (2.83 lbs./gal.)	<340 g/l (2.83 lbs./gal.)	<500 g/l (4.20 lbs./gal.)
<b>Recommended Dry Film Thickness (DFT) Per Coat</b>		1.5-2.5 mils (37.5-62.5µ)	1.5-2.5 mils (37.5-62.5µ)	1.5-2.5 mils (37.5-62.5µ)	1.0-1.5 mils (25-37.5µ)
<b>Wet Film to Achieve DFT</b>		3.0-6.0 mils (75-150µ)	3.0-5.0 mils (75-125µ)	3.0-4.5 mils (75-112.5µ)	3.0-4.0 mils (75-100µ)
<b>Practical Coverage at Recommended DFT (assumes 15% material loss)</b>		230-450 sq. ft./gal. (5.7-11.1 m <sup>2</sup> /l)	285-450 sq. ft./gal. (6.5-11.1 m <sup>2</sup> /l)	275-510 sq. ft./gal. (6.8-12.5 m <sup>2</sup> /l)	330-530 sq. ft./gal. (8.2-13.0 m <sup>2</sup> /l)
<b>Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity</b>	<b>Tack-free</b>	2-4 hours	2-4 hours	2-4 hours	2-4 hours
	<b>Handle</b>	4-8 hours	4-8 hours	4-8 hours	5-9 hours
	<b>Recoat</b>	24 hours	24 hours	24 hours	24 hours
<b>Dry Heat Resistance</b>		212°F (100°C)	212°F (100°C)	212°F (100°C)	350°F (177°C)
<b>Shelf Life</b>		5 years	5 years	5 years	5 years
<b>Safety Information</b>		For additional information, see SDS			

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.



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