

**RUST-OLEUM®**  
**HIGH PERFORMANCE**  
 INDUSTRIAL COATINGS

**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 Gallons | DESCRIPTION  |
|----------|-----------|--------------|
| V7086402 | V7086300  | Gray Primer  |
| V769402  | V769300   | Red Primer   |
| 258887   | 295751    | White Primer |

### RECOMMENDED TOPCOAT

V7400 System 340 DTM Alkyd Enamel

### PRODUCT APPLICATION

#### SURFACE PREPARATION

**ALL SURFACES:** Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Krud Kutter® PRO Cleaner Degreaser, commercial detergent or other suitable cleaner. Mold and mildew must be cleaned with a chlorinated cleaner or bleach solution. 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 mil (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.

#### APPLICATION

Mix thoroughly to re-disperse any settled pigment. Apply only when air and surface temperatures are between 32-100°F (0-38°C), the relative humidity is not greater than 85%, and surface is at least 5°F (3°C) above dew point. Abrasive blast clean steel requires two coats of primer. Dry times may be affected by extremely high or low relative humidity.

### PRODUCT APPLICATION (cont.)

#### EQUIPMENT RECOMMENDATIONS

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

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

#### AIR-ATOMIZED SPRAY

| Method      | Fluid Tip   | Fluid Delivery | Atomized 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 1/2-2 pints per gallon, if needed).

#### CLEAN UP

Use #333402 thinner or #254266 Exempt Thinner.

### PERFORMANCE CHARACTERISTICS

#### PENCIL HARDNESS

METHOD: ASTM D3363

RESULT: F

#### CONICAL FLEXIBILITY

METHOD: ASTM D522

RESULT: >33%

#### GLOSS @ 60°

METHOD: ASTM D5487

RESULT: 5

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

|  |  |              |
|--|--|--------------|
| <b>PRIMER</b>  | <b>TECHNICAL DATA</b>  | <b>RO-85</b> |
| <b>RUST-OLEUM<sup>®</sup><br/>HIGH PERFORMANCE<br/>INDUSTRIAL COATINGS</b> | <b>V7400 SYSTEM 340 VOC<br/>FAST RECOAT RUST-INHIBITIVE PRIMER</b> |              |

### PHYSICAL PROPERTIES

|   |            | PRIMERS  |
|---|------------|--|
| Resin Type  |            | Phenolic Modified Alkyd                              |
| Pigment Type  |            | Calcium Borosilicate                                 |
| Solvents  |            | Aliphatic Hydrocarbons                               |
| Weight  | Per Gallon | 12.8-13.0 lbs.                                       |
|   | Per Liter  | 1.5-1.6 kg   |
| Solids  | By Weight  | 78.4-79.1%   |
|   | By Volume  | 60.7-60.8%   |
| Volatile Organic Compounds  |            | <340 g/l (2.83 lbs./gal.)                            |
| Recommended Dry Film Thickness (DFT) per Coat                     |            | 1.5-2.5 mils<br>(37.5-62.5μ)                         |
| Wet Film to Achieve DFT (unthinned material)                      |            | 2.5-4.0 mils<br>(62.5-100μ)                          |
| Practical Coverage at Recommended DFT (assumes 15% material loss) |            | 300-550 sq. ft./gal.<br>(7.4-13.5 m <sup>2</sup> /l) |
| Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity          | Tack-free  | 1-2 hours  |
|   | Handle     | 4-5 hours  |
|   | Recoat     | After 1 hour or before 4 hours and after 24 hours    |
| Dry Heat Resistance   |            | 212°F (100°C)  |
| Shelf Life  |            | 5 years  |
| Safety Information  |            | 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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Form: GDH-598  
Rev.: 063022