RUST-OLEUM® HIGH PERFORMANCE INDUSTRIAL COATINGS

7400 SYSTEM QUICK DRY PRIMERS

DESCRIPTION AND USES

Rust-Oleum® Industrial Enamel Quick-Dry Primers are fast-drying, modified alkyd primers for general maintenance and shop coat applications. Designed for use on clean, slightly rusted, abrasive blasted or previously painted steel surfaces where a ½–1 hour tack free dry time is desired. These primers are suitable for mild to moderate industrial environments. Not for use on galvanized steel.

PRODUCTS

1-Gallon	5-Gallon	DESCRIPTION
678402	678300	Red
7086402	7086300	Gray

COMPANION PRODUCT

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 Krud Kutter® Original Cleaner Degreaser, 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.

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 Quick Dry Primers are compatible with most coatings, but a test patch is suggested.

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.

PRODUCT APPLICATION (cont.)

APPLICATION

Apply only when air and surface temperatures are between 32-100°F (0-38°C) and surface temperature is at least 5°F (3°C) above the dew point. Abrasive blast clean steel requires two coats of primer.

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable)
BRUSH: Use a good quality natural or synthetic bristle brush. (For touch-up only)

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.	10 psi (at tip)

AIRLESS SPRAY

Pump Ratio	Fluid Pressure	Fluid Tip	Filter Mesh
30:1	1,600-2,400 psi	0.013-0.017	60

THINNING

BRUSH (for touch-up): 333 Thinner*: Normally not required. Use 5-10% if needed (approximately ½ pint per gallon).

AIR-ATOMIZED SPRAY: 333 Thinner*: Use up to 10-20% or as needed (approximately 1½ pints per gallon).

AIRLESS SPRAY: 333 Thinner*: Normally not required. Use 5-10% if needed (approximately ½ pint per gallon).

CLEAN-UP

333402 Thinner*

*Thinning with mineral spirits, VM&P Naphtha, or xylene will increase the VOC above the 450 g/l limit.

Form: GDH-599
Rev.: 063022

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PHYSICAL PROPERTIES

		678 RED PRIMER	7086 GRAY PRIMER
Resin Type		Modified Medium Oil Alkyd	Modified Medium Oil Alkyd
Pigment Type		Brown Iron Oxide, Titanium Dioxide, Calcium Borosilicate, Carbon Black, Talc	Titanium Dioxide, Calcium Borosilicate, Carbon Black, Talc
Solvents		VM&P Naphtha, Xylene	VM&P Naphtha, Xylene
Weight	**Per Gallon**	10.7 lbs.	10.3 lbs.
	Per Liter	1.3 kg	1.2 kg
Solids	**By Weight**	65%	64%
	By Volume	43%	44%
Volatile Organic Compounds		<450 g/l (3.8 lbs./gal.)	<450 g/l (3.8 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1-2 mils (25-50µ)	1-2 mils (25-50µ)
Wet Film to Achieve DFT		2.5-5.0 mils (62.5-125µ)	2.5-5.0 mils (62.5-125µ)
Theoretical Coverage at 1 mil DFT (25µ)		690 sq. ft./gal. (17.0 m^2/l)	705 sq. ft./gal. (17.4 m^2/l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		290-585 sq. ft./gal. (7.1-14.4 m^2/l)	300-600 sq. ft./gal. (7.4-14.8 m^2/l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	**Tack-free**	½-1 hour	½-1 hour
	Handle	1-2 hours	1-2 hours
	Recoat	Within 1 hour or after 24 hours	Within 1 hour or after 24 hours
Force Cure		20 minutes at 225°F (dry to handle after cooling)	20 minutes at 225°F (dry to handle after cooling)
Dry Heat Resistance		212°F (100°C)	212°F (100°C)
Shelf Life		5 years	5 years
Safety Information		For additional information, see SDS	

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