**DESCRIPTION AND USES**

Rust-Oleum® Industrial Food and Beverage Coatings are designed for use in food processing plants where resistance to constant humidity and repeated scrubbing with detergents is desired. This coating also helps prevent mold and mildew growth in the dried paint film. Ideal for food processing plants, showers and locker rooms, fresh and waste water treatment plants, tanneries and laundries. May be applied to surfaces at temperatures as low as 18°F (-8°C). Acceptable by USDA for incidental food contact. Has a high gloss white appearance.

Rust-Oleum® Industrial Food and Beverage Red Primer is a rust-inhibitive primer designed for rusted, clean or sandblasted steel surfaces. #8469402 can be applied to heavily rusted surfaces after minimum surface preparation of scraping and wire brushing. Designed for use in food processing plants where resistance to constant humidity and repeated scrubbing with detergents is desired. This primer also helps prevent mold and mildew growth in the dried paint film. Ideal for priming steel surfaces throughout food processing plants. Acceptable by USDA for incidental food contact. #8469402 has a flat red/brown appearance.

Rust-Oleum® Industrial Food and Beverage White Primer is a special blend of white rust-inhibitive pigments combined in a modified alkyd resin. Designed for use in food processing plants where resistance to constant humidity and repeated scrubbing with detergents is desired. This primer also helps prevent mold and mildew growth in the dried paint film. Ideal as a prime coat on clean or previously painted steel or as intermediate coat over #8469402 Red Primer where light-colored topcoats are planned. #8492402 may be used as a base coat for concrete or masonry surfaces and can be used with Industrial Enamel Finishes when a light-colored rust-inhibitive primer is desired. Acceptable by USDA for incidental food contact. #8492402 has a flat white appearance.

**COMPANION PRODUCTS**

**RECOMMENDED PRIMERS**

- 8469402 Red Primer
- 8492402 White Primer

**COMPATIBLE PRIMERS**

**INDUSTRIAL ENAMEL PRIMERS**

- 1573402 Speedy Dry Rust-Inhibitive Primer
- 3202504 Clear Blue Undercoat

**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. Mold and mildew areas 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: Apply finish coat to a properly primed or previously painted surface. See primer labels and technical data sheet for correct surface preparation and application procedures. 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 clean 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. 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 control 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.
APPLICATION (cont.)

Apply only when air and surface temperatures are between 18-100°F (-8-38°C). Surfaces must be frost-free and at least 5°F above dew point.

EQUIPMENT RECOMMENDATIONS

(Comparable Equipment Also Suitable)

BRUSH: Use good quality natural or synthetic bristle brush.
ROLLER: Use good quality natural or synthetic cover. Use a short nap roller for smooth surfaces, and a medium nap roller for rough surfaces.

AIR-ATOMIZED SPRAY:

Method Fluid Tip Fluid Delivery Atom. Pressure
Pressure 0.055-.070 10-16 oz./min. 25-60 psi
Siphon 0.055-.070 — 25-60 psi
HVLP (var.) 0.043-.070 8-10 oz./min. 10 psi at the tip

AIRLESS SPRAY:

Fluid Pressure Fluid Tip Filter Mesh
1,600–2,400 psi 0.013-.017 100

THINNING

BRUSH/ROLLER: #633402 Thinner.* Normally not required. Use 5-10% if needed (approximately ½ pint per gallon).

AIR ATOMIZED SPRAY: #641402 Thinner.* Use 10-20% or as needed (approximately 1½ pints per gallon).

AIRLESS SPRAY: #641402 Thinner.* Normally not required. Use 5-10% if needed (approximately ½ pint per gallon).

CLEAN UP

633402 or 641402 Thinners.

*#8469402 and #8492402 Primers: To maintain VOC compliance at 420 g./l., substitute #333402 Thinner for #641402. For VOC compliance at 450 g./l., use up to 6% (½ pt./gal.) of #633402 Thinner for brush and roller application, up to 6% (½ pt./gal.) of #641402 Thinner for airless spray and up to 10% (¼ pt./gal.) of #641402 Thinner for air-atomized spray. #333402 Thinner not recommended for brush/roller application.

PERFORMANCE CHARACTERISTICS

System Tested
Primer: N/A
Topcoat: Rust-Oleum® Industrial Food and Beverage Coating

PENCIL HARDNESS

METHOD: ASTM D3363
RESULT: 5B

CONICAL FLEXIBILITY

METHOD: ASTM D522
RESULT: >33%

CYCLIC PROHESION

Rating 1-10, 10=best
METHOD: ASTM D5894, 3 cycles, 1008 hours
RESULT: 10 per ASTM D714 for blistering
RESULT: 9 per ASTM D610 for rusting

IMPACT RESISTANCE (direct)

METHOD: ASTM D2794
RESULT: >160 in.–lbs.

TABER ABRASION

METHOD: ASTM D4060, CS-17 wheels, 1000 gram load, 1000 cycles
RESULT: 62 mg. loss

GLOSS (60°)

METHOD: ASTM D4587
RESULT: 93% (color–white)

For chemical and corrosion resistance, see the Rust-Oleum Industrial Brands Catalog (Form #206275).
### PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th></th>
<th>8469402 RED PRIMER</th>
<th>8492402 WHITE PRIMER</th>
<th>8494402 HIGH GLOSS DAIRY WHITE ENAMEL</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Resin Type</strong></td>
<td>Modified alkyd</td>
<td>Modified alkyd</td>
<td>Modified alkyd</td>
</tr>
<tr>
<td><strong>Pigment Type</strong></td>
<td>Iron oxide, zinc phospho oxide, talc, and calcium carbonate</td>
<td>Titanium dioxide, zinc phospho oxide, talc, calcium carbonate</td>
<td>Titanium dioxide</td>
</tr>
<tr>
<td><strong>Solvents</strong></td>
<td>Aliphatic hydrocarbons</td>
<td>Aliphatic hydrocarbons</td>
<td>Aliphatic hydrocarbons</td>
</tr>
<tr>
<td><strong>Weight</strong></td>
<td>Per Gallon</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>10.5 lbs.</td>
<td>11.3 lbs.</td>
<td>8.8 lbs.</td>
</tr>
<tr>
<td></td>
<td>Per Liter</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1.2 kg.</td>
<td>1.3 kg.</td>
<td>1.0 kg.</td>
</tr>
<tr>
<td><strong>Solids</strong></td>
<td>By Weight</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>67%</td>
<td>70%</td>
<td>56%</td>
</tr>
<tr>
<td></td>
<td>By Volume</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>45%</td>
<td>46%</td>
<td>39%</td>
</tr>
<tr>
<td><strong>Volatile Organic Compounds</strong></td>
<td>&lt;420 g./l. (3.5 lbs./gal.)</td>
<td>&lt;420 g./l. (3.5 lbs./gal.)</td>
<td>&lt;470 g./l. (3.8 lbs./gal.)</td>
</tr>
<tr>
<td><strong>Recommended Dry Film Thickness (DFT) Per Coat</strong></td>
<td>1-2 mils (25-50μ)</td>
<td>1-2 mils (25-50μ)</td>
<td>1-2 mils (25-50μ)</td>
</tr>
<tr>
<td><strong>Wet Film to Achieve DFT (unthinned material)</strong></td>
<td>2.5-4.5 mils (62.5-112.5μ)</td>
<td>2.0-4.5 mils (50-112.5μ)</td>
<td>2.5-4.5 mils (62.5-112.5μ)</td>
</tr>
<tr>
<td><strong>Theoretical Coverage at 1 mil DFT (25μ)</strong></td>
<td>720 sq. ft./gal. (17.7 m²/l)</td>
<td>740 sq. ft./gal. (18.2 m²/l)</td>
<td>625 sq. ft./gal. (15.3 m²/l)</td>
</tr>
<tr>
<td><strong>Practical Coverage at Recommended DFT (assumes 15% material loss)</strong></td>
<td>310-615 sq. ft./gal. (7.6-15.3 m²/l)</td>
<td>315-630 sq. ft./gal. (7.7-15.5 m²/l)</td>
<td>265-530 sq. ft./gal. (6.5-13.0 m²/l)</td>
</tr>
<tr>
<td><strong>Dry Times at 70-80°F (21-27°C) and 50% rel. hum.</strong></td>
<td>Tack-free 2-4 hours</td>
<td>2-4 hours</td>
<td>2-4 hours</td>
</tr>
<tr>
<td></td>
<td>Handle 4-6 hours</td>
<td>4-6 hours</td>
<td>4-67 hours</td>
</tr>
<tr>
<td></td>
<td>Recoat 24 hours</td>
<td>24 hours</td>
<td>24 hours</td>
</tr>
<tr>
<td><strong>Dry Heat Resistance</strong></td>
<td>212°F (100°C)</td>
<td>212°F (100°C)</td>
<td>212°F (100°C)</td>
</tr>
<tr>
<td><strong>Shelf Life</strong></td>
<td>5 years</td>
<td>5 years</td>
<td>5 years</td>
</tr>
<tr>
<td><strong>Specification and Performance Alternatives</strong></td>
<td>USDA acceptable</td>
<td>USDA acceptable</td>
<td>USDA acceptable</td>
</tr>
<tr>
<td><strong>Safety Information</strong></td>
<td>Flash Point 80°F (27°C)</td>
<td>80°F (27°C)</td>
<td>104°F (40°C)</td>
</tr>
<tr>
<td></td>
<td>Contains</td>
<td>No lead has been deliberately added</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Warning!</td>
<td>FLAMMABLE LIQUID AND VAPOR. HARMFUL IF INHALED. MAY AFFECT BRAIN OR NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. CAUSES 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.</td>
<td></td>
</tr>
</tbody>
</table>

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