

RUST-OLEUM®



7400 SYSTEM SHOP COAT PRIMER

DESCRIPTION AND USES

High Performance Industrial Shop Coat Primer is a quick-dry shop coat primer for structural steel. This primer is suitable 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 clean (SSPC-SP-2) or power tool clean (SSPC-SP-3) 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 (25-50 μ) surface profile is recommended for optimal performance. Abrasive blast cleaned steel requires two coats of primer. **Note:** To avoid confusion, 769 Damp Proof Red Primer is intended for sound rusted steel **only**. **Do not use** 769 Primer on clean or abrasive clean steel.

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 Rust-Oleum Industrial Enamel Primers are compatible with most coatings, but a test patch is suggested.

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	Atomization
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 the tip

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1600-2400 psi	0.013-0.017	100

THINNING

BRUSH/ROLLER: 333 Thinner: Normally not required. Use 5-10% if needed (approximately ½ pint per 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.

**TECHNICAL DATA****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 (25-50 μ)
Wet Film to Achieve DFT		2.5-5.0 mils (62.5-125 μ)
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% Relative Humidity	Tack-free	15-30 minutes
	Handle	½-1 hour
	Recoat	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.

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