

ALKYD	TECHNICAL DATA	RO-75
RUST-OLEUM HIGH PERFORMANCE INDUSTRIAL COATINGS	V7400 SYSTEM DTM 340 VOC ALKYD ENAMELS AND PRIMERS	

DESCRIPTION AND USES

V7400 System DTM 340 VOC Alkyd Enamels are designed for indoor and outdoor steel surfaces. They provide excellent resistance to general weathering, salt air, mild chemical fumes and light abrasion in industrial and marine environments above the water line. Available in high gloss, semi-gloss, flat, and metallic finishes. Not for use on galvanized steel.

If desired, the V7400 System DTM 340 VOC Alkyd Enamels 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.

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

V7400 System DTM 340 VOC enamels comply with USDA FSIS regulatory sanitation performance standards for food establishment facilities.

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

V7400 Quick Dry Primers are high solids, fast drying, modified alkyd primers.

Designed for use on clean, abrasive blasted or previously painted steel surfaces. These primers can be used with a variety of topcoats for general maintenance, transportation, and shop applications to comply with VOC requirements of 340 g/l. Can be exposed up to six months without topcoating. Not for use on galvanized steel.

MPI #79 Certified*

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.

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

PRODUCTS

FLAT FINISHES

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

METALLIC FINISHES

1-Gallon	5-Gallon	DESCRIPTION
245309	-----	Aluminum
245402	-----	Heavy-Duty Aluminum

PRODUCTS (cont.)

SEMI-GLOSS FINISHES

1-Gallon	5-Gallon	DESCRIPTION
245482	-----	Semi-Gloss Pleasant Green
245481	-----	Semi-Gloss Lt. Neutral Gray
245483	-----	Semi-Gloss White
323807	-----	Semi-Gloss Black
323811	-----	Semi-Gloss Gray

SATIN FINISHES

1-Gallon	5-Gallon	DESCRIPTION
323808	-----	Satin Black
323812	-----	Satin Gray
323817	-----	Satin White

GLOSS FINISHES

1-Gallon	5-Gallon	DESCRIPTION
245308	-----	Gloss Almond
245380	-----	Gloss Chestnut Brown
245381	-----	Gloss Clear (Clear-Sele®)
245382	245383	Gloss Dunes Tan
245385	245386	Gloss Fire Hydrant Red
245388	245389	Gloss Forest Green
245400	245401	Gloss JD Green
245403	245405	Gloss Black
245406	245407	Gloss White
245408	-----	Gloss International Orange
245409	-----	Gloss Machine Tool Gray
245440	-----	Gloss Marlin Blue
245441	245442	Gloss National Blue
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
245486	-----	Gloss Tile Red
245487	-----	Gloss Vista Green
245488	-----	Gloss Yellow
245489	-----	Gloss New Caterpillar Yellow
245500	-----	Gloss Caterpillar Yellow

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PRODUCTS (cont.)

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

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

V7400 QUICK DRY, LOW VOC PRIMERS

1-Gallon	5-Gallon	DESCRIPTION
2068402	-----	Red Primer
2082402	-----	Light Gray Primer

FAST RECOAT PRIMERS

1-Gallon	5-Gallon	DESCRIPTION
V7086402	V7086300	Gray Primer
V769402	V769300	Red Primer
258887	-----	White Primer

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[®] Original 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.

PRODUCT APPLICATION (cont.)

SURFACE PREPARATION (cont.)

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.

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 V7400 System Alkyds are compatible with most coatings, but a test patch is suggested.

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%.

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable)

BRUSH: Use a good quality natural or synthetic bristle brush. **Note:** Primers for touch-up only.

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.

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 and Primers)

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

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PRODUCT APPLICATION (cont.)

THINNING*

BRUSH/ROLLER: (Finishes) Normally not required.
BRUSH/ROLLER: (Primers) 333402 Acetone Thinner: Up to 5-10% if needed with 333402 Acetone Thinner. (For touch-up only)

AIR ATOMIZED SPRAY: (Finishes) Up to 15% by volume with 333402 Acetone Thinner.

AIR ATOMIZED SPRAY: (Primers) Up 10-20% by volume as needed with 333402 Acetone Thinner.

AIRLESS SPRAY: (Finishes) Normally not required. If needed, Thin up to 5% by volume with 333402 Acetone Thinner.

AIRLESS SPRAY: (Primers) Normally not required. If needed, Thin up to 5-10% by volume with 333402 Acetone Thinner.

*Adding 333402 Acetone Thinner will not raise the VOC of the coating. 333402 Acetone Thinner is exempt from VOC calculation.

CLEAN-UP

333402 Acetone Thinner.

PERFORMANCE CHARACTERISTICS

SYSTEM TESTED- V7400 System Enamels

IMPACT RESISTANCE

METHOD: ASTM D2794 (Direct)
RESULT: >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: >33%

GLOSS at 60°

METHOD: ASTM D4587
RESULT: 5

For chemical and corrosion resistance see page 6 of the Rust-Oleum Industrial Brands Catalog Form #275585.

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PHYSICAL PROPERTIES

		FINISHES	TINT BASES	FLAT
Resin Type		Modified Alkyd	Modified Alkyd	Modified Alkyd
Pigment Type		Varies with color	Varies with color	Varies with color
Solvents		Aliphatic and Aromatic Hydrocarbons	Aliphatic and Aromatic Hydrocarbons	Aliphatic and Aromatic Hydrocarbons
Weight	Per Gallon	8.6-10.8 lbs.	9.7-10.9 lbs.	11.4-11.7 lbs.
	Per Liter	1.0-1.3 kg	1.1-1.3 kg	1.4 kg
Solids	By Weight	45.6-65.8%	61-66%	71-75%
	By Volume	42.4-49.3%	48.5-50.0%	51-56%
Volatile Organic Compounds		<340 g/l (2.83 lbs./gal.)	<340 g/l (2.83 lbs./gal.)	<340 g/l (2.83 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		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)
Wet Film to Achieve DFT		3.0-6.0 mils (75-150μ)	3.0-5.0 mils (75-125μ)	3.0-4.5 mils (75-112.5μ)
Practical Coverage at Recommended DFT (assumes 15% material loss)		230-450 sq.ft./gal. (5.7-11.1 m ² /l)	285-450 sq.ft./gal. (6.5-11.1 m ² /l)	275-510 sq.ft./gal. (6.8-12.5 m ² /l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	Tack-free	2-4 hours	2-4 hours	2-4 hours
	Handle	4-8 hours	4-8 hours	4-8 hours
	Recoat	24 hours	24 hours	24 hours
Dry Heat Resistance		212°F (100°C)	212°F (100°C)	212°F (100°C)
Shelf Life		5 years	5 years	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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PHYSICAL PROPERTIES (cont.)

		METALLIC	V7400 QUICK DRY, LOW VOC PRIMERS	FAST RECOAT PRIMERS
Resin Type		Modified Alkyd	Modified Alkyd	Phenolic Modified Alkyd
Pigment Type		Leafing and non-leafing aluminum	Brown Iron Oxide, Titanium Dioxide, Calcium Carbonate, Magnesium Silicate, Carbon Black	Calcium Borosilicate
Solvents		Aliphatic and Aromatic Hydrocarbons	Esters, ketones	Aliphatic Hydrocarbons
Weight	Per Gallon	7.9-8.3 lbs.	13.3-13.9 lbs.	12.8-13.0 lbs.
	Per Liter	0.9-1.0 kg	1.6-1.7 kg	1.5-1.6 kg
Solids	By Weight	49-51%	79.3-80.2%	78.4-79.1%
	By Volume	37-39%	60-60.1%	60.7-60.8%
Volatile Organic Compounds		<500 g/l (4.20 lbs./gal.)	<340 g/l (2.8 lbs./gal.)	<340 g/l (2.8 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1.0-1.5 mils (25-37.5μ)	1.5-2.5 mils (37.5-62.5μ)	1.5-2.5 mils (37.5-62.5μ)
Wet Film to Achieve DFT		3.0-4.0 mils (75-100μ)	2.5-4.0 mils (62.5-100μ)	2.5-4.0 mils (62.5-100μ)
Practical Coverage at Recommended DFT (assumes 15% material loss)		330-530 sq.ft./gal. (8.2-13.0 m ² /l)	325-550 sq. ft./gal. (8.0-13.5 m ² /l)	300-550 sq.ft./gal. (7.4-13.5 m ² /l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	Tack-free	2-4 hours	30-60 minutes	1-2 hours
	Handle	5-9 hours	1-2 hours	4-5 hours
	Recoat	24 hours	After 1 hour	After 1 hour or before 4 hours and after 24 hours
Dry Heat Resistance		350°F (177°C)	212°F (100°C)	212°F (100°C)
Shelf Life		5 years	5 years	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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