

RUST-OLEUM®**V8400 SYSTEM
340 VOC FOOD AND BEVERAGE
ALKYD ENAMEL****DESCRIPTION AND USES**

V8400 System 340 VOC Food and Beverage Alkyd Enamels are designed for use in food processing plants and other areas where mold and mildew are a concern. This modified alkyd coating contains additives to prevent mold and mildew growth in the dried paint film. May be applied to surfaces at temperatures as low as 18°F (-8°C). Acceptable by USDA for incidental food contact. Not for use on galvanized steel.

PRODUCTS

1-Gallon	5-Gallon	Description
259157	—	White Clean Metal Primer
259158	—	High Gloss Dairy White

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 must be removed with a chlorinated cleaner, bleach solution or Zinsser Perma-Wash™. 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 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.



PRODUCT APPLICATION (cont.)

APPLICATION

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

BRUSH: Use a good quality natural or polyester bristle brush.

ROLLER: Use a good quality natural or polyester 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	0.055-0.070	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 max.at tip

AIRLESS SPRAY (HIGH GLOSS):

Pump Ratio	Fluid Pressure	Fluid Tip	Filter
Mesh			
30:1	1,600-2,400 psi	0.013-0.019	60

THINNING

BRUSH/ROLLER: Normally not required.

AIR-ATOMIZED SPRAY: 333402 Thinner: Use up to 15% by volume.

AIRLESS SPRAY: 333402 Thinner: Normally not required. If needed use up to 5% by volume.

CLEAN-UP

333402 Thinner or 254266 Thinner.

PERFORMANCE CHARACTERISTICS

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: >60 in.-lbs.

TABER ABRASION

METHOD: ASTM D4060, CS-10 wheels, 500 gram load, 1000 cycles

RESULT: 4.2 mg loss

GLOSS (60°)

METHOD: ASTM D4587

RESULT: 91% (color-white)

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

**TECHNICAL DATA****V8400 SYSTEM 340 VOC FOOD AND BEVERAGE ALKYD ENAMEL****PHYSICAL PROPERTIES**

		259157 WHITE CLEAN METAL PRIMER	259158 HIGH GLOSS DAIRY WHITE
Resin Type		Phenolic alkyd	Modified alkyd
Pigment Type		Titanium dioxide, zinc phospho oxide, calcium carbonate	Titanium dioxide
Solvents		Aliphatic hydrocarbons	Aliphatic hydrocarbons
Weight	Per Gallon	13.5 lbs.	9.8 lbs.
	Per Liter	1.3 kg	1.0 kg
Solids	By Weight	79%	58%
	By Volume	61%	47%
Volatile Organic Compounds		<340 g/l (2.8 lbs./gal.)	<340 g/l (2.8 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)
Wet Film to Achieve DFT (unthinned material)		2.5-4.0 mils (62.5-100µ)	3.5-5.5 mils (87.5-137.5µ)
Theoretical Coverage at 1 mil DFT (25µ)		975 sq. ft./gal. (24.0 m ² /l)	750 sq. ft./gal. (18.5 m ² /l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		330-550 sq. ft./gal. (8.1-13.5 m ² /l)	250-425 sq. ft./gal. (6.2-10.5 m ² /l)
Dry Times at 70-80°F (21-27°C) and 50% rel. hum.	Tack-free	30 minutes	2-4 hours
	Handle	4-5 hours	4-8 hours
	Recoat	1 hour	24 hours
Dry Heat Resistance		212°F (100°C)	212°F (100°C)
Shelf Life		5 years	5 years
Specifications		Can be used in USDA-regulated facilities based on FSIS Directive 11,000.4 (Rev.4), November 24, 1995.	Can be used in USDA-regulated facilities based on FSIS Directive 11,000.4 (Rev.4), November 24, 1995.
Safety Information	Flash Point	98°F (37°C)	-4°F (-20°C)
	Contains	No lead has been deliberately added	
	Warning!	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.	

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: 1033990
Rev.: 031811