STAINLESS STEEL CORROSION-RESISTANT COATINGS

The STEEL IT Epoxy System

The STEEL IT Epoxy Coating System utilizes a unique stainless steel leafing pigment. This catalyzed system creates a hard, non-toxic, metallic finish that safeguards a wide variety of materials from the effects of ultraviolet rays, chemicals, oils, alkalis, food acids, water immersion, abrasion, and high-pressure washdowns.

Consisting of STEEL IT Epoxy Coating #4907 applied over lead-free STEEL IT Epoxy Primer #4210, the system adheres aggressively to metal surfaces. Although designed primarily for the protection of ferrous metals, the coating may be applied directly to non-metallics such as wood, tile, glass, masonry, porcelain, plaster, fiberglass, masonite, and many other non-porrous surfaces.

USDA-approved for use in food processing and handling industry where incidental food contact may occur, STEEL IT Epoxy Coating #4907 is a two-part polyamide epoxy composition that incorporates a #316L stainless steel leafing pigment to create a durable, non-toxic metallic finish. STEEL IT Epoxy Primer #4210 is also a two-part polyamide epoxy featuring the stainless steel leafing pigment. The two parts of each coating mix in ratios of 1:1. Available in quart and gallon kits. May be applied by brush, roller, or spray gun. Conventional or airless spraying is the preferred method.

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Protects Steel from:
- Impact and abrasion
- Solvents and chemical spillage
- Mild and strong alkalies
- Moisture (fresh and salt)

System Recommendations:
1 coat — STEEL IT Lead Free Epoxy Primer #4210
2 coats — STEEL IT Epoxy Coating #4907

Surface Preparation:
General use — Sandblast to an SSPC-SP-6 (commercial) or an SSPC-SP-10 (near white) blast quality.

Immersion or Chemical Exposure — Sandblast to an SSPC-SP-5 (white) blast quality.

Anchor Pattern — Cut and angular 1.5 – 2.5 mils deep.

Film Thickness:
- Atmospheric Service and Light Chemical Exposure — 3 dry mils primer and 3 dry mils of finish.
- Immersion and heavy-duty chemical exposure — 3 dry mils of primer and 2 coats of finish (3 dry mils each).

Mixing:
Thoroughly agitate each part separately, then blend one to one by volume (Part A and Part B). Allow 30 – 45 minutes induction time. Re-agitate and strain through filter before use.

Pot Life:
6 – 8 hours

Application:
- For spray application use a DeVilbiss JGA and MBC gun with a 705FF Aircap/Fluid Tip Combination.
- For airless application use a 28:1 pump (minimum) with a DeVilbiss JGB-501 Gun. Fluid Tip Orifice of .015 – .021 is recommended. May also be applied by brush or roller.

Drying Time:
Dry to touch in 2 hours. Allow 12 hours between coats. Subsequent coats will be tack free to handle in 24 hours. Light service in 36 hours.
For complete cure (full protection and hardness) allow 6-7 days.
Lower temperatures delay curing time.

Coverage:
- Theoretical coverage, Epoxy Primer #4210: 250-275 sq. ft. per gallon at 3 mils DFT (dry film thickness)
- Theoretical coverage, Epoxy Finish #4907: 200 sq. ft. per gallon at 3 mils DFT (dry film thickness)

In practice, these values can be reduced by at least 25% by loss factors.

Thinning and Clean Up:
Thin only if necessary, using STEEL IT #6811 Epoxy Reducer or small amounts of aromatic, glycol ether based solvents.

Clean-Up with STEEL IT #6811 Epoxy Reducer, aromatic, glycol ether based solvents, ketones or mixtures of the same.

Limitations:
- Apply only when surface and ambient temperatures are above 50°F.
- Relative humidity must be less than 86%.
- Surface temperature must be at least 5°F above the dew point.
- Recommended for surfaces where the operating temperatures will not exceed 200°F.

		STEEL IT Epoxy Primer #4210	STEEL IT Epoxy Finish #4907
Color:		Grey	Metallic
Sheen:		Low Gloss	Satin
Total Solids:	by weight —	60%	50%
	by volume —	50%	36%
Viscosity K.U.:		70-75	80
Weight per Gallon:		10.6 lbs.	9.5 lbs.
Shelf Life: (Unmixed Components)		1 year	1 year