

Instructions STEEL IT 1002 and PRIMER 2203

Recommended:

as protection against Atmospheric Service in Light-Moderate Duty areas:

1 coat – STEEL IT Alkyd Primer #2203, 1 Coat of STEEL IT Polyurethane Finish #1002.

For Heavy Duty Service: 1 coat STEEL IT Alkyd Primer #2203, and 2 coats STEEL IT Polyurethane Finish #1002.

Preparation:

For general use in Light atmospheric service:

Hand or power tool clean (SSPC-SP-2 and -3) after thoroughly removing all oils, salts, and other contaminants.

For Heavy Duty Service: Sandblast to an SSPC-SP-6 (Commercial Blast).

Anchor pattern should be cut and angular (0,4 – 0,5 mm deep)

Surface must feature a sharp-edged and angled roughness (depth. 0,4 – 0,5 mm)

Coating thickness:

General use:

1 Coat STEEL IT Alkyd Primer #2203 (63 µm dry)

1 coat STEEL IT Polyurethane Finish #1002 (63µm dry)

Heavy Duty use:

1 Coat STEEL IT Alkyd Primer #2203 (63 µm dry)

2 Coats STEEL IT Polyurethane Finish #1002 (63µm dry per coat)

Film thickness on sandblasted surfaces is measured up from the peaks of the anchor pattern.

Application:

Conventional Spray techniques using either air, airless, or HVLP type spray equipment.

Diameter spray valve recommended: 1,2 – 1,4 mm

Pression: 4 – 4,5 bar

Dry time:

#2203 is dry to touch in 1 hour and can be recoated after 4 hours.

#1002 is dry to touch in 2 hours and can be recoated within 24 hours.

The system will continue to cure to maximum hardness and protection for 5- 7 days.

Coverage:

#2203: theoretical coverage 6 m² per L for a film thickness of 63 µm dry.

#1002: theoretical coverage of 4,5 m² per L for a film thickness of 63 µm dry.

Thinning and clean-up:

Thinning is not recommended – only when necessary.

Air spraying may require small amounts of mineral spirits, high flash naphta or Xylene.

Clean up with mineral spirits or Xylene.

Limitations:

Apply the product only when surface and ambient temperatures are higher than 10°C. The relative humidity must be less than 86%. The surface temperature must be at least 9°C above condensation point.

Temperature:

Maximum service temperature: 94° C