

# STEEL IT

Stainless Steel Coatings, Inc.



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-porous 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.



## Protects Steel from:

- Impact and abrasion
- Mild and strong alkalis
- Solvents and chemical spillage
- 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 Air-cap/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.

**Dry 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:**

- Thinning is not recommended- thin only when required, using STEEL-IT #6811 Epoxy Reducer or small amounts of aromatic, glycol ether based solvents.
- Clean-Up with aromatic, glycol ether, 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.

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

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