



Application Instructions

STEEL-IT 1030D Polyurethane Aerosol – White

System	<ul style="list-style-type: none">4 coats STEEL-IT 1030D Polyurethane Aerosol – WhiteFor harsh conditions, an additional 2 coats are recommended.A single coat is 8 mils (0.008"; 205 microns) Wet Film Thickness (WFT) and dries to 1.5 mils (0.0015"; 38 microns) Dry Film Thickness (DFT) when applied at a swift moving speed across the surface.				
Surface Preparation	<p>STEEL-IT coatings adhere to metal surfaces through mechanical adhesion and require a rough profile on the bare metal – ideally achieved by grit-blasting or power-sanding. The surface once properly prepared should feel like the striking area on a matchbox.</p> <ul style="list-style-type: none">Surfaces should be clean and free of all rust, paint, greases, waxes, salts, dirt, scale, etc.For best results, grit-blast to SSPC SP-6 (Commercial Blast).Anchor pattern should be cut and angular at 1.5 - 2.0 mils deep (0.0015" – 0.0020"; 38-50 microns).Power-sanding with a dual-action sander or random orbital sander using #36 grit sandpaper will achieve similar results on steel. After grit-blasting, blow any remaining grit material off using an air hose and/or solvent clean the surface with acetone or alcohol. Avoid using products that leave behind an oily residue (such as mineral spirits).				
Ambient Conditions	<ul style="list-style-type: none">Apply when ambient and substrate surface temperatures are 50 °F - 120 °F (10 °C - 49 °C)Relative humidity less than 85%Temperature of substrate surface and coating are at least 5 °F (2.75 °C) above the dew point.Climate conditions (e.g. high humidity or high aridity) will impact coating dry/cure time. Longer cure times may be necessary for higher humidity or colder climates. Spraying speed and technique may need to be adjusted.				
Agitation	<ul style="list-style-type: none">Shake the can vigorously for 2 minutes, ideally with a power shaker.Shake the can continuously throughout the application.				
Application Method	<ul style="list-style-type: none">Spray from a distance of 12-16" (30-40 cm) making multiple passes to achieve proper coating wet film build.Overlap the spray paint pattern by 50%.Adjust the application speed according to climate conditions.				
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Additional Coats	If applying optional additional coats for enhanced durability: <ul style="list-style-type: none"> Allow 4th coat to cure for 4-6 hours Apply 5th and 6th coats with one-hour dry time in between After applying 6th coat (final coat), air cure for 5-7 days
Wet/Dry Film Build	<ul style="list-style-type: none"> For each coat, apply 8 mils (0.008"; 205 microns) Wet Film Thickness (WFT) to achieve 1.5 mils (0.0015"; 38 microns) Dry Film Thickness (DFT) per coat. Use a Wet Film Thickness Gauge when the coating is wet to measure film build per coat during application. For proper performance, the end total DFT of STEEL-IT coating applied should be 6 mils (0.006"; 150 microns) DFT. For parts exposed to harsher conditions, we recommend achieving 9 mils (0.009"; 225 microns) total DFT. We do not recommend using an electronic gauge to measure Dry Film Thickness. For an explanation, please refer to the FAQs on STEEL-IT.com
Dry Time and Recoat Windows	<ul style="list-style-type: none"> Dry to touch: 1-2 hours Tack-free to handle: 2 hours Dry to recoat window: 4-24 hours If more than 24 hours passes between coats, a light scuff-sanding using #400-600 grit sandpaper is required before applying an additional coat
Curing	<ul style="list-style-type: none"> Full cure in 5-7 days after final coat Recommended cure time can vary based on ambient temperature and humidity. Air cure with ambient and substrate surface temperatures of 50 °F -120 °F (10 °C - 49 °C) Heating to expedite curing time is not recommended and may interfere with proper cure. Cure time required before part can be packaged or put into service depends on how the part will be used. Please refer to FAQs on STEEL-IT.com for details. Cure and corrosion resistance is accelerated initially and will continue to improve over 4-6 week period.
Welding	<ul style="list-style-type: none"> Allow a full 7-days cure before welding TIG or MIG welding Seamless touch-up with STEEL-IT Polyurethane Aerosol
Safety	<ul style="list-style-type: none"> Wear a NIOSH-approved respirator with an organic vapor cartridge Use nitrile gloves Apply STEEL-IT in a well-ventilated area
Cleanup	<ul style="list-style-type: none"> Use mineral spirits for clean up

Physical Properties

Property	STEEL-IT 1030D Aerosol
Color	White, satin finish
Weight (calculated)	12 oz/can (340 g/can)
Coverage @ 3 mil (0.003"; 75 microns) DFT*	6.5 sq ft/can (0.6 sq m/can)

* Values assume 20% loss due to overspray.

Safety Data Sheets (SDS) and Technical Data Sheets (TDS) are available online at: STEEL-IT.com

Please contact us to discuss your specific application needs: contactus@steel-it.com

All users are responsible for conducting testing to determine the suitability of STEEL-IT Brand Coatings for the specific requirements of their applications.

STEEL-IT® is a registered trademark of Stainless Steel Coatings, Inc.

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