



The STEEL IT High Solids, Low VOC Epoxy System

The STEEL IT High Solids, Low VOC Epoxy System is a high-performance, two-coat barrier coating system that complies fully with the latest environmental regulations while maintaining the same high-performance profile and superior application characteristics associated with more traditional STEEL IT compositions. Free of lead and chromium salt-based pigmentations, the system has VOC levels substantially less than all current regulated thresholds.

Both the primer and the finish afford optimal physical

properties that improve adhesion and help the system withstand flexing and stretching. The cured film — pigmented with 316L stainless steel flakes for enhanced performance — is highly durable and resistant to the corrosive effects of oils, fats, spilled solvents, solvent fumes, alkalis and many dilute organic and inorganic acids. The system is suitable for use on ferrous and nonferrous substrates.

Engineered from the latest generation of low molecular weight epoxy, the system consists of a “high solids, low VOC” barrier primer #4220 and a “high solids, low VOC” stainless steel pigmented finish #4908. Available in a choice of two gallon or two quart kits, both the primer and finish are user-friendly coatings with excellent wetting characteristics and long pot life. They may be applied by a wide variety of techniques, including brush, roller, conventional airspray, airless and air-assisted airless applications.



- Protects Steel From:**
- Impact and abrasion.
 - Moisture (fresh and salt).
 - Solvents and chemical spillage.
 - Mild acids, and mild and strong alkali.
- System Requirements:**
- 1 Coat: STEEL IT High Solids Epoxy Primer #4220.
 - 1 or 2 Coats: STEEL IT High Solids Epoxy Finish #4908.
- Surface Preparation:**
- General Use: Sandblast to an SSPC-SP-6 (commercial) or SSPC-SP-10 (near white).
 - Immersion or Chemical Exposure: Sandblast to an SSPC-SP-5 (white metal) blast quality.
- Film Thickness:**
- Atmospheric Service and Light Chemical Exposure: 3 dry mils or primer followed by 3 dry mils of finish.
 - Immersion and Heavy Duty Chemical Exposure: 5 dry mils of primer followed by 2 coats of finish (4 dry mils each).
- Mixing:**
- Stir both components separately. Combine equal parts by volume and mix thoroughly. Allow newly combined paints to stand for 15 minutes prior to use.
- Application:**
- Conventional Spray: Use Binks #95 gun with 66SS/66SK fluid tip/air cap or similar equipment.
 - Airless Application: Use a DeVibiss JBG-501 gun with a fluid tip orifice between 0.015 and 0.021. Pump should be at least 28.1 or other compatible combinations.
- Dry Time:**
- #4220 Primer: Dry to touch in 3 hours. Allow to dry 12 hr. between coats.
 - #4908 Finish: Dry to touch in 4 hours. Allow to dry 12 hr. between coats. Cure continues to advance for 2 weeks until full hardness and chemical resistance is achieved. Lower temperatures delay curing time.
- Coverage:**
- Theoretical Epoxy Primer #4220: At 3 dry mils is 380 sq. ft./gal.
 - Theoretical Epoxy Finish #4908: At 3 dry mils is 365 sq. ft./gal. In practice, their values will be reduced by at least 25% by loss factors.
- Thinning and Cleanup:**
- Thinning is not normally necessary. If required, you may use STEEL IT 6811 Epoxy Reducer; or up to 5% xylene or aromatic naphtha may be added to facilitate application without exceeding VOC thresholds.
- Limitations:**
- Apply only when relative humidities are below 85%.
 - Apply only when surface temperature is more than 5°F above dewpoint.
 - Apply at temperatures above 50°F and less than 100°F.
 - The maximum service temperature is 250°F.

STEEL IT
HS/LVOC Epoxy Primer #4220

STEEL IT
HS/LVOC Epoxy Finish #4908

Color:	Red	Metallic Grey
Sheen:	Satin	Satin
Total Solids: By Weight	84%	78%
By Volume	72%	68%
Viscosity:	550 cps	800 cps
Weight per Gallon:	12.9 lb. (mixed)	10.2 lb. (mixed)
Pot Life after Mixing:	6 Hours	6 Hours
Shelf Life:	1 Year	1 Year
VOCs:	248 grams/liter (2.1 lb./gal.)	225 grams/liter (1.9 lb./gal.)