

- Protects Steel from:**
- Severe atmospheric environments
 - Water (fresh and salt)
 - Abrasion and impact
 - High pressure wash downs
- Uses:**
- Structural steel, food processing and packaging equipment
 - Industrial equipment metal parts, air conditioning, refrigeration equipment, etc.
 - Maintenance of trucks, auto parts, trailers
 - Bridges, tanks, towers
- System Recommendations:**
- Atmospheric Service in Light-Moderate Duty Areas. —
- 1 coat — STEEL IT Alkyd Weathering Primer #2203
 - 1 coat — STEEL IT Polyurethane #1002
- Heavy Duty Service. —
- 1 coat — STEEL IT Alkyd Weathering Primer #2203
 - 2 coats — STEEL IT Polyurethane #1002
- Surface Preparation:**
- 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.
- Heavy duty service. —
- Sandblast to an SSPC-SP-6 (commercial blast)
 - Anchor pattern should be cut and angular (1.5–2.0 dry mils deep).
- Film Thickness:**
- General use. —
- 1 coat of #2203 (2.5 dry mils)
 - 1 coat of #1002 (2.5 dry mils)
- Heavy duty use. —
- 1 coat #2203 (2.5 dry mils)
 - 2 coats of #1002 (2.5 dry mils per coat)
 - Film thickness on blasted surfaces should be measured up from the peaks of the anchor pattern.
- Application:**
- Conventional spray techniques use a Binks #62 Gun with a 68PB Air Cap and a 66 Fluid Tip or similar equipment.
 - Airless application use a DeVilbiss JGB-501 airless gun combination with a fluid tip orifice between 0.015 and 0.021. Pump ratio should be at least 28:1 or other compatible combinations.
- Drying Time:**
- #2203 Primer is a fast drying material that is touch dry in 1 hour and may be recoated in 4 hours.
 - #1002 is dry to touch in two hours and should be recoated within 24 hours.
 - The finished system can be put into light service in 24 hours. The system will continue to cure to maximum hardness and protection for 5-10 days.
- Coverage:**
- #2203 Red Primer: theoretical coverage — 250 sq. ft./gallon at 2.5 dry mil.
 - #1002 Finish: theoretical coverage — 180 sq. ft./gallon at 2.5 dry mil.
- In practice their values will be reduced at least 25% by loss factors.
- Thinning and Clean Up:**
- Thinning is not recommended — only when mandatory.
 - Air spray may require small amounts of mineral spirits, high flash naphtha, xylene or toluene.
 - Clean up with mineral spirits or xylene.
- Limitations:**
- Apply only when surface and ambient temperatures are above 40°F.
 - Relative humidity must be less than 86%.
 - Surface temperature must be at least 5°F above dew point.

	STEEL IT Alkyd Primer #2203	STEEL IT Polyurethane Finish #1002
Color:	Red	Metallic
Sheen:	Low Gloss	Low Gloss
Total Solids:		
by weight —	65%	49%
by volume —	38%	28%
Weight per Gallon:	11.8 lbs.	9.4 lbs.
Shelf Life:	1 year	1 year