MILD STEEL SURFACE PREPARATION GUIDE FOR APPLICATION OF SPI SPRAY PURE POLYUREA PRODUCTS

1. FOR A NON-WORKING SUBSTRATE: achieve a 2 mil anchor profile white blast using “Kleen Blast” #35 or equal.

2. FOR A WORKING SUBSTRATE: such as pick-up beds, dump trucks, redimix trucks, hoppers, traffic decks, etc. achieve a 4 mil anchor profile white blast using “Kleen Blast” #1630 or equal.

3. EQUIPMENT: use an air compressor with 175 CFM (min.) (0.08 m/s) at a minimum of 90 PSI (620.5 kPa). Use a 7/16-1/2” (11-13mm) nozzle.

4. Profile depth to be confirmed with comparators, replica tape or depth micrometers.

5. Surface temperature must be at least (3° C) 5 ºF Above the dew point for dry blast.

6. Surface must be coated before RUST-BACK occurs.

7. The adhesion of SPI SPRAY POLYUREA PRODUCTS to mild steel can be enhanced with penetrating bonding agents. Please consult technical service personnel for specific primer recommendation.

8. Use this information as a condensed guide only. For complete specifications refer to SSPC Publication # 95-03 and #91-08.


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