

PREPARATION GUIDE FOR MILD STEEL



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 °F 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.
- 9.** Also refer to NACE publications: 6G191, 6G175, and NACE standard RP0892-92.

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