



# SPI COATINGS

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## MOIST METAL GRIP

### Application Instructions (10/12/16)

MOIST METAL GRIP is a two-part epoxy coating system that has been specifically designed with specific additives to promote adhesion when used on metal. MOIST METAL GRIP was developed to be applied to metal surfaces that cannot be dry enough to use RUST GRIP®. It can be used directly to wet or damp metal surfaces and maintain excellent adhesion to prevent further surface corrosion. It is a water repelling epoxy for use under water or in areas where constant splashing or condensation is a problem. It is resistant to chemicals and solvents, and is designed to can be applied directly to concrete, masonry and wood.

#### SURFACE PREPARATION

Surface must be clean from oil, tar, rust, grease, salts, and films.

- 1) Follow SP6 or SP7 guidelines.
- 2) Clean surface using TSP (tri-sodium-phosphate) or a citrus cleaner to release dirt and degreaser residue.
- 3) Pressure-wash if possible @ 3500 psi.
- 4) Salt contamination on a surface can come as a result of salt water, fertilizers, and car exhaust. Use Chlor\*Rid or equivalent to decontaminate surface, if salts are present. Acceptable levels: Nitrates: 5-10 mcg/cm<sup>2</sup>, Sulfates: 5-10 mcg/cm<sup>2</sup>, Chlorides: 3-5 mcg/cm<sup>2</sup>.

#### Surface may be damp.

- 1) MOIST METAL GRIP must be applied during proper temperatures (below), and at the prescribed overcoat window of the coating over which it will be applied.
- 2) If applied over an existing coating having a glossed or shiny finish, it must be sanded and roughed to remove gloss before application--to improve the profile.
- 3) Additional coats of MOIST METAL GRIP can only be applied when the 1<sup>st</sup> coat becomes tacky to the touch and has little-to-no transfer of coating. If the first coat is allowed to cure more than 3 days to where it is no longer tacky, the surface must be lightly sanded to make it rough before the second coat is applied.

#### MIXING

- 1) Open pail, mix base with curing agent (4 parts base : 1 part curing agent); ratio by volume, not by weight
- 2) Mix by hand for two minutes, or use a drill and mixing blade for a minimum of 30 seconds with NO vortex.

#### TEMPERATURE

- 1) Apply between 40°F (4°C) and 150°F (65°C).
- 2) Maximum temperature for continuous use when cured is 300°F (149°C).
- 3) Store unmixed product between 40°F (4°C) and 100°F (38°C) according to hazmat standards on MSDS.
- 4) Mix base and curing agent and use immediately if ambient temperature is above 70°F (21°C). If below 70°F (21°C), allow mixed product to stand for 30 minutes before using.
- 5) Vertical surfaces: allow extra conduction time (base added to cure), up to one hour before use to allow the coating to thicken for better hang without sag.

#### POT LIFE

4-6 hours at 70°F (21°C) on horizontal surfaces. Shorter pot life may occur as temperature increases according to climate/ambient conditions.

#### APPLICATION

MOIST METAL GRIP can be applied by brush, roller or spray; however, the preferred method is by air or airless sprayer.

- 1) If application is by brush, use a soft bristle brush.
- 2) If application is by roller, use a 1/4 inch (6m-8m) nap roller.
- 3) If application is by spray, use a standard airless sprayer (2 gallons/minute at 3,300 psi) with a .017-.021 tip.
  - **NOTE:** The number of applications and the thickness of each should be in accordance with the job specifications.

#### MINIMUM SPREAD RATES (mil thickness)

**All Surfaces** – Apply 1<sup>st</sup> application at 200 sq ft/gallon (18 sq mtr/gallon; use a roller to force coating into pores); 8 mils wet/4 mils dry (to penetrate into pores.) Allow 4 hours to dry and ventilate well, then apply 2<sup>nd</sup> application of 100% MOIST METAL GRIP at 200 sq ft/gallon; 8 mils wet, 4 mils dry. Wait 24 hours, and apply the last coat of MOIST METAL GRIP at 200 sq ft/gallon.

#### CURE TIME

**Note:** Surface and ambient temperatures will determine cure time which is normally 14 full days. Introduction of heat over surface will enhance the cure time. Potable water must allow full cure before filling tanks.

**Induction Period:** 30 minutes at 70°F (21°C); No induction time is necessary over 90°F (32°C). **EXCEPTION:** See Temperature #5 for vertical surface application.

**Note:** It is critical that each coat of MOIST METAL GRIP be firmly adhered to the substrate before the next coat is applied. Depending on ambient and surface temperatures, it may take longer than a 24-hour recoat application window.

#### CLEAN-UP EQUIPMENT

- 1) After completion, spray systems should be flushed and cleaned with MEK or other comparable solvents.
- 2) After completion, brushes and rollers can be cleaned with MEK or comparable solvents, stored and reused.