

Stainless Steel

NOTE:

An important aspect for a coating systems successful performance is matching the surface preparation with the primers, primer surfacers and primer sealers being applied. The primer coat must have a minimum amount of material above the abrasion profile to perform properly. Consult the Technical Data Sheet of the primer being used or if you have further questions consult your Endura representative.

For other substrates, refer to the Endura recommended surface preparation instruction sheets or contact your Endura Representative or contact us at 1-800-661-9930 or online at www.endurapaint.com.

THIN WALL STAINLESS STEEL

Thin wall Stainless Steel is generally any panel that is $\frac{3}{16}$ inch (4.7 mm) in thickness or less. These panels should not be sandblasted as they may become damaged during the sandblasting process.

Cleaning:

Cleaning is an important part of the surface preparation process and should be performed first. Cleaning removes any grease, release agents or any surface contaminants which may interfere with the optimal adhesion of the coating system. These surfaces contaminants can be driven deeper into the metal by the preparation processes of sanding or sandblasting and may affect future adhesion.

Degreaser 10

1. Read the Technical Data Sheet and Safety Data Sheet before using Degreaser 10 and assure that you have and are wearing all the recommended Personal Protective Equipment (PPE) prior to commencing use.
2. If the surface is hot, wet, and cool down before applying Endura Degreaser 10.
3. Apply the Degreaser 10 liberally to the surface with brush or low-pressure spray, keep the surface wet for 5 -10 minutes and using a maroon nylon scuffing pad scrub the surface during this time.
4. Rinse with plenty of clean water and do not let the Degreaser 10 dry on the surface while you are cleaning. For larger surfaces, rinsing with a power washer (1500psi minimum) is recommended.
5. Once well rinsed, any seams, crevices or rivet areas should be blown down with clean compressed air.
6. Once the surfaced has been properly rinsed and dry the final part of the preparation process can be completed.

Surface Preparation:

Mechanical Sanding

1. Once the Stainless-Steel surface has properly dried from using degreaser 10, mechanically sand the surface with 80-120 grit for primers or primer surfacers or 180 grit-240 grit for low build primer sealers. A maroon nylon scuffing pad can be used in hard to reach areas.
2. Assure that all surface gloss has been removed. A stainless-steel surface that is not properly prepared will have adhesion problems.
3. Once sanded, blow off all sanding dust with clean compressed air.

Stainless Steel

THICK WALL STAINLESS STEEL

Thick wall stainless steel is generally any panel that is $\frac{3}{16}$ inch (4.7 mm) in thickness or more. These panels can be either sandblasted or sanded as outlined below.

Cleaning:

Cleaning is an important part of the surface preparation process and should be performed first. Cleaning removes any grease, release agents or any surface contaminants which may interfere with the optimal adhesion of the coating system. These surface contaminants can be driven deeper into the metal by the preparation processes of sanding or sandblasting and may affect future adhesion.

Degreaser 10

1. Read the Technical Data Sheet and Safety Data Sheet before using Degreaser 10 and assure that you have and are wearing all the recommended Personal Protective Equipment (PPE) prior to commencing use.
2. If the surface is hot, wet, and cool down before applying Endura Degreaser 10.
3. Apply the Degreaser 10 liberally to the surface with brush or low-pressure spray, keep the surface wet for 5 -10 minutes and using a maroon nylon scuffing pad scrub the surface during this time.
4. Rinse with plenty of clean water and do not let the Degreaser 10 dry on the surface while you are cleaning. For larger surfaces, rinsing with a power washer (1500psi minimum) is recommended.
5. Once well rinsed, any seams, crevices or rivet areas should be blown down with clean compressed air.
6. Once the surface has been properly rinsed and dry the final part of the preparation process can be completed.

Surface Preparation:

Option 1: Mechanical Sanding

1. Once the Stainless-Steel surface has properly dried from using degreaser 10, mechanically sand the surface with 80-120 grit for primers or primer surfacers or 180 grit-240 grit for low build primer sealers. A maroon nylon scuffing pad can be used in hard to reach areas.
2. Assure that all surface gloss has been removed. A stainless-steel surface that is not properly prepared will have adhesion problems.
3. Once sanded, blow off all sanding dust with clean compressed air.

Option 2: Sandblasting

1. Stainless Steel surfaces (Thick Wall) can be grit blasted as per Steel Structures Painting Council SSPC-SP6 Commercial Blast cleaning. **Do not use steel shot or grit.**
2. Remove any high profiles on the sandblasted stainless by scuff sanding with 80 – 100 grit sandpaper prior to application of the primer.

Adhesion loss of paint finishes are generally the result of poor surface preparation.