Technical Data
Sheet Rev: 2.05.22

401 Growth Parkway
Angola, IN 46703

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SteelKote 825

2K Fast-Dry Zinc Fortified Epoxy Primer

Description:

Steelkote 825 is a high performance VOC compliant, fast cure epoxy primer designed to provide excellent corrosion control by using corrosion resistant, zinc enhanced pigments. This engineered formulation provides superior hide, hold out and excellent protection on sharp edges. SteelKote 825 offers fast recoat and cure schedule, optimizing production and lowering costs. It is a DTM surface tolerant epoxy primer that offers excellent adhesion to a variety of surfaces due to its specially engineered curing agent. An excellent primer for commercial, industrial and marine use where extreme durability and fast recoat is required. Superior resistance to fresh and salt water, detergents, solvents and corrosive chemicals.

Advantages:

- Fast Cure Schedule
- Excellent corrosion resistance
- Superior chemical resistance
- VOC Compliant
- High Abrasion Resistance

Uses:

- Heavy-Duty Machinery
- Trailers
- Containers
- Implements
- Exterior Steel Structures

Material Properties	
Gloss Level	Satin
Density	11.02 lbs/gal mixed
Volume Solids	63% (mixed)
VOC	3.27 lbs./gal (390 grams/ltr) mixed
Dry Film Thickness	3.0 - 6.0 mils
Colors Available	Gray,Tile Red, Buff
Pot Life (68°F/20°C)	1.5 Hours
Theoretical Coverage	336 ft2 / gal @ 3.0 mils dry film thickness
Practical Coverage	As a guideline for airless spraying on large dimensions: 70% of theoretical coverage. For small dimensions: 50%

Surface Preparation:

New or Unfinished Surfaces:

Ferrous Metal: For best performance, application to abrasive blasted surface is recommended. "Commercial Blast Cleaning" (SSPC-SP6) is recommended as the minimum for blast cleaning. Proper blast media and blasting equipment shall be used to produce a minimum profile depth of 1.5 mils or 2.5 maximum. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. If blasting is not possible, use "Hand or Power Tool Cleaning: (SSPC-SP2 or -SP3). At minimum the surface should be clean of all grease, dirt, oil, rust, and foreign material that would be detrimental to proper adhesion and desired performance of the coating system being applied.

Galvanized Metal: Clean all contamination by scrubbing with a cleaning soap solution. Rinse clean with water and allow to dry.

Aluminum: Brush blast, sand or abrade surface. Clean all contamination by scrubbing with a with a cleaning soap solution. Rinse clean with water and allow to dry. Otherwise prime with a Wash Primer or etch with a phosphoric acid pretreatment solution is recommended for maximum adhesion.

Previously Painted Surfaces: Repair all damaged areas. Remove gloss from previous paint by sanding or "Brush Blasting" (SSPC-SP7) Remove any rust, heavy chalk and loose or peeling paint by "Hand or Power Tool Cleaning." (SSPC-SP2 or -SP3). If doubt exists concerning compatibility of this coating with the previous system, apply coating to a representative area (25 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any or any other sign of incompatibility. If there are no issues, coating work can proceed..

Mixing Instructions:

Thoroughly mix product , preferably using a mechanical mixing device. The temperature of the mixed product should be at least 45°F during application. Mix 3 parts of SteelKote 825 Part A with 1 part of SteelKote Activator Part B ACT-9470 or ACT-9144.

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Application Instructions

Spray Method	Airless	Air Assisted Airless	Air Spray / HVLP
Thinner	Not recommended	Not recommended	Xylene
Quantity	N/A	N/A	0-10%
Nozzle or Tip Size	.013-.015	.011-.015	1.2 to 1.4
Fluid Pressure	1500 - 3000 PSI	800 -1300 PSI	20-40 PSI
Air Pressure	50 PSI	30 PSI	30-60 PSI
Dry Film Thickness	2.0 - 4.0 Mils	2.0 - 4.0 Mils	2.0 - 4.0 Mils

Performance Characteristics

Impact (Direct & Indirect) ASTM D-2794	160 in lbs direct 80 lbs indirect
Chemical Resistance	100 MEK Double Rubs
Flexibility: ASTM D522 Conical Mandrell	No cracking - .25 inch
Adhesion (Cross Hatch) ASTM D 3359:	Excellent - 5A
Salt Spray ASTM B-117	1500 hours
Temperature Resistance Intermittent	400º F
Temperature Resistance Constant	350º F

Dry Times: 70ºF @ 2-4 mils DFT

To Touch:	30 Minutes
To Handle:	6-hours
To Re-Coat:	1 Hour minimum 7 Days maximum
Force Cure:	20 Minutes @ 150ºF

Health & Environmental:

In accordance with OSHA regulations on hazardous materials, harmful and irritating if in contact with skin, eyes and by inhalation. Observe safety information from MSDS sheets. Always wear proper protective suits, gloves and eye protection. In case of eye contact, immediately wash with large amounts of water and contact a medical expert. If spraying, always wear proper NIOSH approved respirators. Fresh air fed respirators are preferred. Do not eat, drink or smoke during application. Discharge, treatment or disposal is subject to federal, state, commonwealth, provincial and local laws. Since empty containers retain product residue, follow label warnings even after container is emptied. Residual vapors may explode on ignition; do not cut, drill, grind or weld on or near this container.

Cleaning Instructions:

Cleaning tools: Clean immediately after application using MEK or Lacquer Thinner.

Warranty / Disclaimer:

The technical data and other printed information furnished are true and accurate to the best of our knowledge. The products are warranted pursuant to acceptance of limited warranty. A copy of which can be obtained from Baril Coatings, which is the exclusive warranty with respect to the sale of this product. The modification of any component or uses not outlined in this bulletin nullifies the warranty unless advance written confirmation is obtained from Baril Coatings. No other warranties expressed or implied shall apply. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, shall be to supply replacement materials as set forth in the limited warranty.

SteelKote
designed to endure

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