



SPI COATINGS

PROVEN PERFORMANCE • REAL WORLD SOLUTIONS

ENAMO GRIP SERIES

INSULATION
AND
CORROSION
SPECIALISTS

Application Instructions (07/10/19)

ENAMO GRIP is a two-part polyurethane enamel that forms a uniquely hard and durable coating film.

SURFACE PREPARATION

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

- 1) Use general degreaser if needed.
- 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/cm², Sulfates: 5-10 mcg/cm², Chlorides: 3-5 mcg/cm²

Surface must be completely dry before applying.

- 1) ENAMO GRIP must be applied during proper temperatures (below) and 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 ENAMO GRIP can only be applied when the 1st coat becomes tacky to the touch and has little to no transfer of coating. After this stage, the surface must be lightly sanded to improve the profile.

MIXING

- 1) Open pail, mix base with curing agent (3 parts base : 1 part curing agent) (ratio by volume, not by weight)
- 2) Mix by hand for two minutes, or using drill and mixing blade for a minimum of 30 seconds with NO vortex.

APPLICATION

ENAMO 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 nap roller.

NOTE: If rolling/brushing, add 2 oz. Bubble Breaker per gallon.

- 3) If application is by spray, use a standard airless sprayer (1.5 gallons/minute at 3,300 psi.) with a .011-.015 tip.
 - **NOTE:** The number of applications and the thickness of each should be in accordance with the job specifications.
 - **NOTE:** It may be necessary to use a "bubble breaker" when using a brush or roller.
 - **NOTE:** Temperatures must always be a minimum of 5 degrees above the dew point during application.
 - **NOTE:** In hot (90°F) temperatures and 85% humidity climates, cut the ENAMO GRIP 4-gallon kit with one quart of MAK solvent (Methyl n-Amyl Ketone) to slow down the flash off and skinning of the surface film.

APPLICATION OVER CAULK

Only use a high performance, solvent-borne, polyurethane caulk. (Do not use a water-borne caulk or one that is water soluble.)

TEMPERATURE

- 1) Apply between 40°F (4°C) and 100°F (38°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 60°F (16°C). If below 60°F (16°C), allow mixed product to stand for 30 minutes before using.

MINIMUM SPREAD RATES (mil thickness)

Porous Surfaces – Apply 1 application of RUST GRIP® or ENAMO GRIP @ 200 sq ft/gallon (18 sq mtr/gallon); 8 mils wet / 3.92 mils dry (200 microns wet / 98 dry) to absorb into substrate. Apply 2 additional coats of ENAMO GRIP @ 200 sq ft/gallon; 8 mils wet / 3.92 mils dry, each application.

Non-Porous Surfaces – First apply RUST GRIP® as a primer; then apply 1 coat of ENAMO GRIP @ 200 sq ft/gal. (18 sq mtr/gal.); 8 mils wet (200 microns)/3.92 mils dry (98 microns), as an architectural coating. Apply a 2nd coat of ENAMO GRIP in areas that may have machine or foot traffic, handrails, or anywhere there is consistent wear on the surface.

ENAMO GRIP CLEAR SPREAD RATE

High-Gloss- at 406 sq.ft./gal (36 mtr/gal) 3.9 mils wet (99 microns) 1.5 mils dry (37 microns).

Semi-Gloss- as 395 sq.ft./gal (36.6 mtr/gal) 4 mils wet (102 microns) 1.6 mils dry (40 microns).

Matt- at 386 sq.ft./gal (35.8 mtr/gal) 4.1 mils wet (104 microns) 1.7 mils dry (43 microns).

POT LIFE

4-6 hours at 70°F (21°C) - 1 hour at 90°F (32°C)

CURE TIME

- 1) 30-60 minutes to tack free at 70°F (21°C).
- 2) Overcoat window is three hours or less at 70°F (21°C).
- 3) If temperature is over 90°F (32°C), overcoat window and pot life is shortened to 1 hour.
- 4) Fully cures in ten days.

CLEAN-UP EQUIPMENT

- 1) During breaks, spray system should be flushed with solvent.
- 2) After completion, spray systems should be flushed and cleaned with MEK or other comparable solvents.
- 3) After completion, brushes and rollers should be cleaned with MEK or other comparable solvents, stored and re-used.