Technical Data
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401 Growth Parkway
Angola, IN 46703

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SteelKote 154

High Solids High Gloss
Aliphatic Polyester Urethane Field Coating

Description:
SteelKote 154 is a high performance, low-VOC acrylic polyester urethane enamel. This fast-drying formulation has been engineered to offer excellent long-term protection in moderate to severe environments. Designed for application by spray, brush or roll, SteelKote 154 is an excellent choice for field-applied coatings. It offers superior protection against fresh water, salt-water, most chemicals, solvent fumes and spills, acids and alkalies. SteelKote 154 can be applied over previously primed & painted surfaces.

Advantages:
- Long-term color and gloss retention
- Application of multiple back to back coats without runs
- Excellent chemical resistance
- Superior flexibility
- High UV resistance
- Long working times and user-friendly application

Uses:
- Commercial Vehicles
- Marine
- Machinery
- Trailers
- Implements
- Structures
- Containers

Material Properties	
Gloss Level	90° + High Gloss
Density	9.75 lbs./gal 1.17 kg/ltr (mixed)
Volume Solids	63% (mixed)
VOC	3.5 lbs./gal. 419 grams/ltr. (mixed)
Dry Film Thickness	1.5-3.0 mils
Pot Life	1- hours (mixed) @ 68°F / 20°C
Theoretical Coverage	2.0 DFT @ 506 ft^2/gal.
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 blast-ed 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 an

average profile depth of 1.5 mils minimum to 2.5 mils 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)..

Galvanized Metal: Clean all contamination by scrubbing with a cleaning soap solution. Rinse clean with water and allow to dry. Prime with SteelKote™ recommended primers prior to using 154; consult with your Baril technical services representative for more information.

Aluminum or Stainless Steel: 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 recom-mended for maximum adhesion. Prime with SteelKote™ recommended primers prior to using 154; consult with your Baril technical services representative for more information.

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 2 parts SteelKote 154 with 1 part of ACT-931 Activator

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Application Instructions

Spray Method	Airless	Air Assisted Airless	Air Spray / HVLP
Thinner	N/A	N/A	MAK
Quantity	N/A	N/A	0-10%
Nozzle or Tip Size	0.011-0.013	0.011-0.013	1.0-1.5
Fluid Pressure	2000 - 3000 PSI	1000 - 1500 PSI	8-10 PSI
Air Pressure	N/A	50 PSI	24-28 PSI
Dry Film Thickness	3.0 - 6.0 Mils	3.0 - 6.0 Mils	3.0 - 6.0 Mils

Performance Characteristics

Accelerated Weathering: ISO 11507 / ASTM G154 ISO 2813 / ASTM D523	 3500 hours gloss retention @ 60° > 80%
Florida Black Box Exposure	Pass 48 months < 20% gloss loss, < .5 ΔE color change
Impact (Direct & Indirect) ASTM D-2794	140 in lbs Direct 50 in lbs Indirect
Chemical Resistance	50 Double MEK Rubs
Flexibility: ISO 1519 / ASTM D522	Cylindrical Mandrel 10mm ISO 1520 Cupping 5-7 mm
Abrasion Resistance: ASTM D4060	Taber CS-17 / 1kg 400 cycles: 150 mg loss

Dry Times: 70°F @ 2-4 mils DFT

To Touch:	1-hour
To Handle:	3-hours
To Re-Coat:	14 hours to 24 hours without sanding
Force Cure:	10-30 mins @ 110ºF to 150ºF

Cleaning Instructions:
Cleaning tools: Clean immediately after application using MEK.

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 SDS 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.

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 warran unless advance written confirmation is obtained from Baril Coatings. No other warranties expressed or implied shall appl . 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.

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