



ITC 213 Ceramic Coating for Metals Mixing and installation Instructions for Metal Surface Coating Procedure

STORAGE

ITC products must be stored on pallets or shelves and be kept between 40° F and 90° F (5° C and 30° C). Warm storage is recommended in extreme cold conditions. All excess mixed material can be stored in the original airtight ITC containers and re-shelved. The containers must be sealed tightly to prevent material from hardening. Label all premixed material so that additional water is not added and remixed.

EQUIPMENT

The following is a list of equipment that is required for the veneering process:

1. 1 gallon or larger bucket/rubber container to mix the ITC material.
2. ½" drill motor or larger with long mixing attachment.
3. Rubber gloves
4. Clean rags or paintbrush (spray guns can be used for applications on large surfaces)
5. Eye protection

Note: Most equipment can be purchased at any home improvement store.

MIXING

To mix, simply add 1/3 container of water to one full container of ITC 213. Use only clean potable water with temperatures between 40° F and 85° F (5° C and 30° C). Mixing time needs to be sufficient to produce a uniform consistency. Do not add additional water. During application, additional mixing may be required to prevent settling.

WARNING

The following will adversely affect the properties of ITC products:

- Excessive water
- Dirty mixing equipment
- Cement contamination
- Dirty and/or hot water
- Admixtures
- Dirty spraying equipment

INSTALLATION

1. Metal surfaces should be thoroughly degreased and cleaned using a dilute Clorox bleach and water solution. Very smooth surfaces should be scratched up using a grinder.
2. For optimum adhesion the metal surface should be heated to around 100° F allowing the pores of the metal to expand and accept the ITC 213.
3. Prepare the ITC 213 for application per the mixing instructions by adding 1/3" container of water to one full container of ITC 213.
4. Using a clean rag or sponge, dip it into the coating and vigorously rub the coating onto the surface applying an even thin coating approximately 1/32" to 1/16" thick. For large surfaces, spray entire surface with ITC 213 using a minimum of 80 psi of air pressure. DO NOT RUSH and do not leave any areas uncoated. The thickness of the sprayed coating should be approximately 1/32" to 1/16" thick. The distance of the spray nozzle to the surface should be approximately 16".
5. DO NOT OVER SPRAY. Too thick of an application will cause material to fail prematurely. Any over sprayed material that begins to run must be wiped off immediately.
6. Allow to dry overnight.
7. Before any ITC topcoat can be applied (ITC 100HT or ITC 296A), ITC 213 must be fired and baked onto the metal substrate to a minimum of 250° F.

NOTE: Do not use excessive heat to dry the coating during the first 24 hours after installation. Either use fans to move the air or simply leave it to dry overnight.