

# METAL Tek

MetalTek is a single component moisture cured Polyurethane Coating. It was designed and developed for the treatment, encapsulation and coating of structural steel, bridges and rusted surfaces.

### Product Features

- ◆ Low temperature cure
- ◆ Provides excellent adhesion to steel surfaces
- ◆ Temperature Resistance: 200°C (390°F)

**Color:**  
Metallic Aluminum

**Theoretical Solids Content:**  
Volume: 61%

**Shelf Life\***  
Single Component:  
(1) Year\*

\*For unopened product.

**Pot Life of Mixed Product:**  
1-2 Hours\* @ 77°F (25°C) and 50% RH



### Suitability

Endura MetalTek provides outstanding corrosion resistance with excellent adhesion to marginally prepared steel surfaces. MetalTek is a self priming metallic pigmented one step finish coat that penetrates and seals pores, cracks and voids in the substrate or old paint film.

MetalTek can be use to encapsulate insulation and other materials that require some form of repair or replacement.



### Surface Preparation

MetalTek can be used where conditions are difficult and normal surface preparation is not feasible.

### How it Works

As the product cures it gasses off and expands. The metallic pigment is pushed into the voids and encapsulates the surface rust to create an extremely durable, chemical resistant, metal reinforced urethane surface. MetalTek can be applied below freezing as the moisture cured resin system will provide satisfactory rate of cure.



### Mixing Ratio

Endura MetalTek is a single component product.

Use Endura EX-2C Thinner to suit application equipment. (Usually from 5-15% conventional spray.)

### Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be between 20°C-25°C\* (68°F-77°F). To prevent condensation during application the surface temperature must be 3°C (5°F) or more above the dew point at all times.

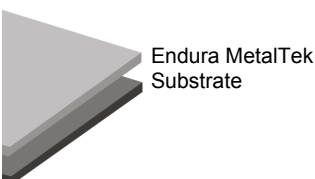
\*for use outside this range please contact your Endura representative.



### Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures ( heel of gun )	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-2.0 mm	50-60 psi	10-14 oz/min
Air Assist Airless	9-17 Thou	1,000-1,800 psi	
Airless	13-17 Thou	1,700-3,000 psi	

**Electrostatic spray is NOT recommended.**



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### Recommended Film Build Thickness and Cover Rate

Endura MetalTek has a recommended film thickness of 6 - 7 mils dry (150 - 175 microns) applied 2 - 3 coats (Avoid excess film).

Theoretical coverage at 1.0 mil (25 microns) DFT: 976 ft<sup>2</sup> per gallon @ 100% transfer efficiency.



### Drying Time\*

Handle: 1 - 2 hours at 25 °C (77°F) and 50%RH

Recoat time with MetalTek at 25°C (77°F) and 50% R.H. is 2 – 72 hours. Please contact your Endura Representative for recoat times at lower temperatures.

Since Endura MetalTek is a single component, moisture cure type, curing time varies depending on temperature and relative humidity.

### Specifications

Hardness	ASTM D3363	4H
Solvent resistance	ASTM D4752	100 MEK rubs; NO Failure
Abrasion resistance (1000 cycles CS-17)	ASTM D4060	25 mg loss
Impact resistance	ASTM D2794	30 in. lbs: NO failure
Flexibility	ASTM D522	1/8 mandrel bend; NO failure
VOC	For VOC amounts please refer to the product MSDS	

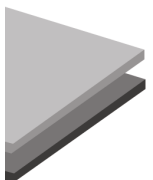


### Clean Up

Endura high strength gun wash, Endura epoxy reducer or Endura EX-2C thinner.

### Notes

Mechanical mixing or agitation is not recommended. Stir thoroughly by hand using an appropriate mixing stick. Shaking the container prior to application may cause the formation of bubbles (air entrapment) in the coating film.



Endura MetalTek  
Substrate