



# SPI COATINGS

PROVEN PERFORMANCE • REAL WORLD SOLUTIONS

## **SUPER THERM Bake System (S.T.B.S.)**

**INSULATION  
AND  
CORROSION  
SPECIALISTS**

### **Application Instructions** (1-25-21)

S.T.B.S. is a water-borne combination of high-performance acrylic resin which produces a tough, yet flexible coating film. It combines four different ceramics that provide both heat reflectivity and heat-blocking properties. S.T.B.S. is a flexible membrane with low permeability that can greatly reduce expansion and contraction of a roof. S.T.B.S. is designed to be applied over cold roll steel in the coating process.

#### **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) Degrease and then remove all residue from surface before application.

**Surface must be completely dry before applying.**

- 1) S.T.B.S. must be applied during proper temperatures (below) and the prescribed overcoat window of the coating over which it will be applied.
- 2) Maximum Surface Temperature when applying: 150°F (65°C)
- 3) Minimum Surface Temperature when applying: 40°F (5°C)
- 4) Maximum Surface Temperature after curing: 300°F-350°F (149°C-176°C)

#### **MIXING**

S.T.B.S. should be mechanically mixed or in a continuous agitation.

#### **APPLICATION**

S.T.B.S. is applied by standard blade over surface or can be sprayed. Oven time of 10 minutes @ 300°F (149°C); applied at 20 mils wet, giving 9 mils dry. Coating can be applied to rolled metal by blade or spray, whichever established at processing plant currently.

#### **MINIMUM SPREAD RATES (mil thickness)**

S.T.B.S. will be applied at no less than a total of 15 mils wet (375 microns)/9 mils dry (225 microns) for each application. Spread Rate is 110 sq ft per gallon. (10.2 sq meter per gallon)

#### **CURE TIME**

Oven 300°F (149°C) at 10 minutes.

#### **CLEAN-UP EQUIPMENT**

After completion, equipment should be cleaned with soap and water.