

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON HS CLEAR WILKO NO. 330.29

PRODUCT DESCRIPTION No. 330.29 Wilkopon HS Clear is a two component epoxy – polyamide coating suitable for use in areas exposed to condensation and high humidity. Made with ingredients that are approved for contact with Type VII food listed under 21 CFR 175.300. Its electrical conductivity is not tested, but it is assumed to be not static conductive (not anti-static).

PRINCIPAL USE: Recommended as coating for steel and concrete surfaces that require chemical and corrosion resistance. It is not recommended as clear coat for exterior application.

COLOR: Light Straw

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 330.29 to one volume of No. 330.18B Activator. For cool weather applications (50-70°F), use 330.18C Wilkopon Cool Weather Activator. Do not use 330-18C at temperatures over 70°F.

PHYSICAL PROPERTIES: with 330.18B: with 330.18C:

POT LIFE: @ 77°F 4-6 hrs 2-4 hrs.

WEIGHT PER GALLON 8.2 ±.5 lbs. 11.1 ±.5 lbs

VOC: 3.3 lbs. 3.7 lbs.

SOLIDS BY VOLUME: 50 ± 1.0% 44 ± 1.0%

COVERAGE: sq. ft per gal @ 1 mil dry

<i>Theoretical -</i>	797	771
<i>Practical -</i>	637	569

DRYING TIME: @ 77°F

<i>To Touch:</i>	1 to 2 hours	15 to 30 min
<i>To handle:</i>	6 to 8 hours	2 to 4 hours
<i>To Recoat:</i>	30 min - 72 hr.	30 min - 72 hr.

After 72 hours, scuff sand surface before topcoating. May be wet sanded in 6 hours.

FLASH POINT: 330.29 Part A: 82°F TCC
Part B: 115°F TCC
Part C: 82°F TCC

TEMPERATURE RESISTANCE: 200°F continuous, dry

RECOMMENDED DFT PER COAT: 3 Mils

RECOMMENDED PRIMER: Wilkopon Epoxy Primers 342.46 Gray, 342.44 Gray, or 347.67 Red.

CLEAN UP THINNER: No. 71 or MEK

RECOMMENDED THINNER: Wilko No. 71, Wilko No. 80 (for floors) or Wilko No. 44. Use No. 71 for temperatures above 90 °F or if using 330-18C Activator.

RECOMMENDED SUBSTRATE: Steel

RECOMMENDED TOPCOATS: If desired, it may be topcoated with Polyurethanes, Epoxy Enamels and Vinyls after scuff sanding.

SURFACE PREPARATION:

Steel: Surface must be clean and dry, free of oil, grease, wax and other contaminants. Use of chemical cleaning and pretreatment (e.g., phosphatizing) is highly recommended and will help improve the adhesion and will help enhance the overall properties of the coating. If heavy mill scale, rust or loose paint is present, clean parts by a mechanical means. Hand, power tool or SP7 Blast Cleaning will afford minimum protection. For the maximum protection of steel surfaces, dry abrasive blast to Commercial Blast Finish in accordance with SSPC-SP6. Apply the primer or coating prior to the development of surface rust.

New Concrete: New concrete must cure for a minimum of 30 days prior to coating. After this period the only surface preparation necessary is etching. This can be accomplished with an acid solution. After applying acid the reaction residues must be removed by using fresh water and a squeegee. Allow floor to dry thoroughly, sweep or vacuum to remove any/all powdery residue, and apply first coat of material. NOTE: Refer to "Coating Concrete" Brochure for more in-depth surface preparation. For optimum adhesion, use Wilkopon 342.22 or 342.44 Gray Primer.

Other Surfaces: Consult Wilko Representative

RECOMMENDED APPLICATION: May be applied by brush or roller, or conventional or airless spray.

APPLICATION PROCEDURE:

1. Mix the pigmented component, No. 330.29, until uniform, and then mix four volumes with one volume of No.330.18B Activator (or 330.18C for cool weather application). Allow the mixed material to stand for 30 minutes before applying. To prevent any craters, fisheyes, or crawling when used over fiberglass reinforced plastics, add 2 ounces of No. 850-10 or No. 850-05 per gallon of material.

2. *AIRLESS SPRAY:* Any standard airless spray equipment, such as Graco Bulldog Hydra-Spray or larger, with a .013 - .017 inch fluid tip is recommended. If thinning is necessary, use No. 71 Thinner.

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APPLICATION PROCEDURE (*cont'd*)

3. **CONVENTIONAL SPRAY:** Apply with industrial equipment, such as DeVilbiss MBC or JGA spray gun with No.78 or 765 Air cap, E fluid tip and needle, or Binks 18 or 62 spray gun, and a pressure pot with mechanical agitator. A moisture and oil trap in the main air supply line is required. Thin with up to 1 quart of No.71 Thinner per activated gallon.

4. **BRUSH OR ROLLER:** For concrete walls and floors, brush or roller application is preferred to assure coverage of porous surfaces. For best results use Wilko No. 80 for thinning. Use roller cover (short nap) suitable for applying epoxies to minimize air entrapment. Concrete must be allowed to set 28 days before painting.

5. Do not apply when surface temperature is less than 5° above dew point to prevent moisture condensation. For satisfactory cure, air and surface temperatures must be above 50°F.

6. Apply wet coat in even parallel passes, overlapping each pass 50% to avoid any holidays, bare areas and/or pinholes. If necessary, follow with a spray pass at right angles to the first pass.

7. Clean the equipment with No. 71 Thinner immediately after use.

8. Coating Concrete: Occasionally, gas escapes from the concrete, which may cause micro-bubbles forming on the paint film as it dries.. To minimize this phenomenon, apply a coat of the clear (reduced 50%) and allow to dry 24 hours, then follow with a full coat.

FIRST AID: If inhaled, remove to fresh air. If not breathing, administer artificial respiration. In case of any contact with eyes, flush with plenty of water for 15 minutes and secure medical attention.

PRECAUTION: Not intended for general consumer use. This product is flammable and can cause skin and eye irritations. Keep away from sparks, heat and open flames. Avoid contact with eyes, skin and clothing. Use with adequate ventilation and avoid prolonged breathing of vapors. Wear an air-supplied mask to avoid breathing concentrated vapors in enclosed areas. Keep the container closed.

For additional safety information, refer to Material Safety Data Sheets.