



# WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

POST OFFICE BOX 4089 • 2727 OHIO • PHONE (316)838-4288 • FAX(316)838-6328

## WILKOPON MASTIC WHITE

### WILKO NO. 331.15

**PRODUCT DESCRIPTION:** 331.15 Wilkopon Mastic White is a two component rust inhibitive epoxy polyamide coating that is designed for direct application to metals following the removal of loose rust and scale. It is an ideal coating in areas where sandblasting is not feasible or is impractical.

**PRINCIPAL USE:** Recommended coating for all structural steel, exterior of storage tanks and miscellaneous equipment in chemical and refinery facilities. It is suitable as interior lining for non-potable water tanks.

**COLOR:** White (Available in other colors - 332.54 Pearl Gray, 339.03 Aluminum, 332.48 Aluminum Gray, and 336.26 Black).

**FINISH:** Semi-Gloss

**COMPONENTS:** Two

**MIXING RATIO:** Equal volumes of Base No. 331.15 and Activator No. 331.15B (For cool weather use 331.15C)

**POT LIFE:** With 331.15B: 4 to 6 hours @ 77°F  
With 331.15C: 2 to 4 hours @ 65°F

**WEIGHT PER GALLON:** With 331.15B: 12.4 ± .5 lbs (mixed)  
With 331.15C: 12.7 ± .5 lbs

**VOC:** (mixed) With 331.15B: 1.30 lbs/gal  
With 331.15C: 2.25 lbs/gal

**SOLIDS BY VOLUME:** With 331.15B 82.0 ± 1.0% (mixed)  
With 331.15C 68.6 ± 1.0%

**COVERAGE:**@ 1 mil DFT W/331.15B W/331.15C  
*Theoretical* sq. ft./act. gal. - 1315 1100  
*Practical* sq. ft./act. gal. - 1052 880

**RECOMMENDED DRY FILM PER COAT:** 5-10 mils

**DRYING TIME:** @ 77°F W/331.15B W/331.15C  
*TO TOUCH:* 4 to 6 hours 2 to 4 hours  
*TO RECOAT:* 6 to 24 hours 4 to 72 hours

**THINNER:** Use Wilko No. 1, No. 13 or No. 100 Thinner. Use No. 71 Thinner for maximum pot life or when 331.15C is used. NOTE: Do not use No. 71 if recoating old alkyd paint.

**CLEAN UP THINNER:** No. 71 and MEK are recommended. No. 1 or No. 13 may also be used at early stages, however, they may not thoroughly clean the equipment.

**RECOMMENDED PRIMERS:** May be applied DTM. For additional corrosion resistance, use Wilkopon Primer Nos. 349.08, 349.10 or 349.13 Zinc Rich Epoxy Primer. Nos. 347.40 Beige, 342.46 Gray or 347.67 Red Primer may also be used.

**TEMPERATURE RESISTANCE:** 200°F continuous, dry

**VISCOSITY:** 100-110 KU

**RECOMMENDED SUBSTRATE:** Steel or concrete.

**RECOMMENDED TOPCOAT:** Topcoat with Wilkopon Epoxy or Wilkothane G or HS Polyurethane coatings only. Epoxy is recommended for corrosion resistance, while polyurethane is recommended for maximum gloss retention.

**SURFACE PREPARATION:** Surface must be clean and dry, free of oil, grease, wax or other contaminants. The use of chemical cleaning or pretreatment (e.g., phosphatizing) will help improve the adhesion and will enhance the overall properties of the coating. This multi-stage surface preparation is adequate for most industrial applications, and is highly recommended.

When coating newly fabricated steel, or if heavy mill scale, rust, or loose paint is present on existing structures, clean the parts by mechanical means. All sharp edges must be rounded and weld splatter must be removed prior to cleaning. Hand, power tool or SP7 Brush Blast Cleaning will afford minimum protection. For maximum protection of steel surface, dry abrasive blast to a Commercial Blast Finish in accordance with SSPC-SP6. Apply prior to the development of surface rust, usually within 8 hours or less especially in humid conditions.

#### EQUIPMENT REQUIRED:

##### *Conventional Spray:*

1. A material pressure pot with dual regulation.
2. Spray gun such as DeVilbiss MBC with an AV-601 EX fluid tip, 496 DEX needle and a 704 or 64 air cap. As an alternate, a Binks 2001, 2100, or No. 18 heavy duty sprays gun with a 66 PB nozzle.
3. A 25-50-foot length of air and fluid hose - ½ inch ID minimum, 5/8 inch preferable.
4. Minimum of 75 PSI continuous air supply to each spray gun, 100 psi preferable.

##### *Airless Spray:*

1. Airless spray equipment with pump ratio of 28:1 or 30:1.
2. Airless spray tip with orifice diameter of 0.017 or larger must be used.
3. Air supply that delivers at least 100 psi is recommended.

#### APPLICATION PROCEDURE:

Airless spray is recommended for maximum film build.

1. Separately mix the base and activator components until uniform, then mix equal volumes of the base and 331.15B Activator. Allow mixture to stand for at least 30 minutes before using. For cool temperature application (40-70°) use 331.15C instead of 331.15B. Do not use 331.15C if ambient temperature is above 70°F.

*continued on page 2*

APPLICATION PROCEDURE:(Cont'd)

2. **REDUCTION:** Caution: Any thinner added will raise the VOC of the coating. Do not thin with more than 101 ounces of No.71 Thinner per gallon of material activated with 331.15B to keep VOC below 3.8#/gal (63 oz. when activated with 331.15C). Check local VOC restrictions before thinning.

*Conventional Spray:* Thin up to 25% with appropriate thinner (refer to previous section for recommended thinner).

*Airless Spray-* May be applied without thinning at 70-85°F. In cooler temperatures, or with smaller airless units, thin up to 10% with appropriate thinner.

3. *Spray:* Apply one tack coat and follow with one full wet coat. Hold the spray gun 8-10 inches from the surface and overlap each pass 25% to avoid holidays.

4. If the ambient temperature exceeds 85°F, reduce with Wilko No. 101 to avoid dry spray. Do not apply when the surface temperature is less than 5° above the dew point. Do not use below 40°F.

5. *Brush or Roller:* Thin activated material until workable for roller or brush application. This method of application is recommended for maximum adhesion over marginally prepared or if surface condensation is present. Work the brush or roller into the surface in such a way that the surface contaminant is worked into the coating, and in the case of moisture, the brushing action will push the water aside to allow coating to come into contact with the substrate. CAUTION: Do not apply if heavy condensation is present. See Wilko Rep for more information on application over these surfaces.

6. Following are recommended cure schedule using 331.15C Activator:

| <b>Splash &amp; Spillage</b> |                  | <b>Immersion</b> |
|------------------------------|------------------|------------------|
| <i>Temperature</i>           | <i>Cure Time</i> | <i>Cure Time</i> |
| 50°F                         | 7 days           | 14 days          |
| 60°F                         | 3 days           | 7 days           |
| 70°F                         | 2 days           | 4 days           |
| 80°F                         | 40 hours         | 3 days           |
| 90°F                         | 32 hours         | 2 days           |
| 100°F                        | 24 hours         | 2 days           |

The above times are doubled if using 331.15B Activator. NOTE: 331.15B activator is not recommended at 65° or lower temperature.

7. For immersion service, use 331.15B and apply two coats for a total of 20 mils.

8. 331.15 may be used as an intermediate coat over zinc rich primers prior to application of polyurethane coatings. *Coating Inorganic Zinc Rich Primer:* The porous nature of zinc often causes pinholes or bubbling of the Intermediate (Tie) Coat. To eliminate bubbling of the first coat, thin 50% and apply a wet mist coat over surface area, allowing a short interval for solvent to escape, followed with full wet coat. This tie coat will penetrate the porous structure displacing trapped air and providing a sealed substrate for succeeding topcoat. Tie Coat should be applied to provide 3.0-5.0 mils dry film thickness, depending on the top coat and exposure.

PHYSICAL PROPERTIES:

| Substrate - Sandblasted Steel | DFT     | Result     |
|-------------------------------|---------|------------|
| Adhesion, ASTM D3359          | 2 mils  | 5A         |
| Pencil Hardness, ASTM D3363   | 4 mils  | 4H+        |
| Abrasion, ASTM D4060          | 4 mils  | 80 mg loss |
| 1000 gm load on CS17 wheel    |         |            |
| Salt Fog, ASTM B117           | 10 mils | 2000 hrs   |
| Gloss, ASTM D523, 60°         | 4 mils  | 70         |

**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.

