

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON SF GRAY FC WILKO NO. 332.25

PRODUCT DESCRIPTION: No. 332.25 Wilkopon SF Gray FC is a 100% solids, two component epoxy polyamine coating that is designed for direct application to concrete, and to metals following the removal of loose rust and scale.

TYPICAL USES: Recommended as a coating for structural steel, exterior of storage tanks and miscellaneous equipment in chemical and refinery facilities. It is an ideal coating in areas where sandblasting is not feasible or is impractical. Its excellent abrasion resistance and self-leveling properties make it an ideal coating for floors where heavy traffic and/or chemical spillage is anticipated. It is not recommended for areas where gloss retention is required. This material may also be used to fill cracks by mixing one part by volume of activated epoxy with two to three parts by volume of dry sand.

GENERIC TYPE: Epoxy-Polyamine

COLOR: RAL 7045 (available in other colors)

FINISH: Gloss

COMPONENTS: Two

MIXING RATIO: Mix 332.25A to 332.25B as supplied in pre weighed kit

SWEAT IN TIME: 15 minutes @ 77° F

POT LIFE: : @75° F 2 hours
@100° F 1 hour

WEIGHT PER GALLON: 10.3 +.5 lbs (mixed)

VOC: .05 lbs (mixed)

SOLIDS BY VOLUME: 98-100% (mixed)

COVERAGE: @ 12 mil DFT
Theoretical - 134 sq. ft./act. gal.

RECOMMENDED THICKNESS: 10 to 15 mils DFT

NUMBER OF COATS: 1 to 2 recommended

THINNER: None required – if needed Retarder No. 80

CLEAN UP THINNER: No. 71 or MEK

DRYING TIME with No. 332.25B Activator @77°F
TO TOUCH: 10-12 hours
TO RECOAT: 10-24 hours

This coating will be ready for light foot traffic in 48 hours at 77°F.

Coating will fully cure in 2 weeks at 77°F

TEMPERATURE RESISTANCE: Dry, 200°F continuous, 250 °F intermittent

SHELF LIFE: One Year, stored dry at 77°F

RECOMMENDED SUBSTRATE: Concrete or Steel

RECOMMENDED PRIMERS: Material may be applied directly to properly cleaned metal or concrete. For additional corrosion resistance, use No. 349.13 Wilkopon HS Primer Zinc Rich or 859-06 Primer Inorganic Zinc Rich. For concrete use 340.45 Wilkopon Clear Epoxy primer or 342.45 Wilkopon Gray Epoxy Primer.

RECOMMENDED TOPCOATS: Wilkothane HS, Wilkothane S polyurethanes or Wilkopon Epoxies. Allow coating to cure for 24 hours if recoating with urethanes.

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 adhesion and enhance overall properties of the coating, and is recommended if no loose paint, mill scale or rust is present and sandblasting is not feasible.

When coating newly fabricated steel, or if heavy mill scale, loose paint, or rust is present, clean parts by mechanical means. All sharp edges must be rounded and weld splatter removed before cleaning. Hand, power tool, or SP7 Blast Cleaning will afford minimum protection. For the maximum protection of steel surfaces, dry abrasive blast to a Commercial Blast Finish to meet SSPC-SP6. Apply primer prior to the development of any surface rust

CONCRETE: Refer to Wilko's guide on surface preparation guide for concrete.

APPLICATION:

Airless: Airless spray is recommended for maximum film build. Use airless spray equipment with pump ratio of 30:1 or greater and airless spray tip with orifice diameter of 0.019 to 0.025. On vertical surface 2 mils is the maximum that can be applied without sagging.

Brush or Roller: Use a stiff brush to apply. Thinning may be necessary for workability. For horizontal surface use the brush or roller to spread the paint evenly and allow it to self-level. Squeegee may also be used if used as floor coating. .

Conventional Spray: Use for thin film build of less than 2 mils. Apply with industrial equipment, such as DeVilbiss JGA and FF fluid tip, 765 air cap, or Binks No. 95 or 2001 spray gun with a 66 PB nozzle or Graco Delta XT with .055 tip, with separate air and fluid pressure regulators, and a moisture and oil trap in the main supply are recommended. Contamination with oil and water will result in shortened pot life, loss of adhesion, and poor film integrity.

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APPLICATION PROCEDURE:

1. **ACTIVATION:** Separately mix No. 332.25 Part A (2.5 parts base) and No. 332.25B Part B (one part activator) components until uniform. Do not mix partial kits unless the parts can be measured accurately at 2.5:1 mix ratio by volume. Then mix the base and activator and allow mixture to stand for 15 minutes before using. If mechanical agitator is used, use slow speed to prevent foam build up and do not mix for more than 5 minutes. Mixing for longer period will shorten the pot life. For extra skid resistance add 1# of Wilko No. 090.09 per gallon of activated paint and mix thoroughly. For denser particle distribution, add up to 4#/gal.

CAUTION: Workable pot life of this product at 75°F is 2 h for one gallon. Pot life is shorter at higher temperature or if mixed in larger quantities or if a mechanical mixer is used.

2. **REDUCTION:** Use 84 oz. of No. 80 Thinner for VOC of 2.8# or less.
Conventional Spray: Thin up to 25% with appropriate thinner.
Airless Spray- may be applied without thinning at 70-85°F. In cooler weather, or when using a smaller airless units, thin with up to 10% of the appropriate thinner.

Roll or Brush: May be brush applied or rolled as is 77°F or higher temperature. For roller or brush application thin up to 10% with No. 80 Thinner. Use a 1/4" nap roller to minimize air entrapment. Cross-coat to achieve uniform thickness. Do not allow the roller to become dry during cross coating. Apply coating from seam to seam in a continuous stroke to minimize any roller marks.

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

4. Allow coating to cure 3-5 days at 65 -80°F before placing into service. NOTE: The schedule for painting must be planned to include the application of material early enough to provide for at least partial cure prior to lower night time temperatures and the possibility of dew point conditions. Curing rates are accelerated by heat and are retarded by lower temperatures. Drying rates are based on 75°F. As a rule of thumb, for every 18° above 75° F, the curing rate will accelerate by approximately 100%. For every 18° below 75°F, curing rate is retarded by approximately 100%. The premature failure of fine coating systems is often experienced because of failure to acknowledge the facts related to low temperature application.

6. For satisfactory cure, air and surface temperatures must be above 50°F for the next 16 hours. Coatings applied at 50°F or lower will not properly cure, and its performance will be adversely affected.

8. *Coating previously Painted Surfaces:* If coating is in sound condition, clean the surface of all foreign material and apply the coating to a small area to test for lifting, bleeding, or lack of adhesion. If any of these characteristics are exhibited then remove all old paint and prepare surfaces as listed.

CHEMICAL RESISTANCE:

(Fumes, Splash and Spillage, Non-Immersion)

Aromatic Hydrocarbon	Passes
Aliphatic Hydrocarbons	Passes
Alkali	Passes
Organic Acids (Dilute)	Passes
Lubricating Oils	Passes
Acid: Resists fumes of non-oxidizing acids.	
Alcohol: Accepts the spillage of isopropyl, ethyl and butyl alcohol	
Petroleum Distillate: Resists splash and/or spillage of gasoline, sour crude, diesel fuel, and jet	

Other Properties:

Adhesion: Excellent over properly prepared steel or zinc rich coated surfaces.

Weather Exposure: Will not check, crack or craze after long or severe exposure. Chalking: Early surface chalking will occur under exterior exposure, and is a condition inherent with polyamide or amine catalyzed epoxy coatings.

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.