

# WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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## WILKOPON MASTIC ALUMINUM WILKO NO. 339.03

**PRODUCT DESCRIPTION:** 339.03 Wilkopon Mastic Aluminum is a two component epoxy polyamide coating that is designed for direct application to metals following the removal of loose rust and scale.

**PRINCIPAL USE:** Recommended coating for all structural steel, exterior of storage tanks and miscellaneous equipment in chemical and refinery facilities. Is an ideal coating in areas where sandblasting is not feasible or is impractical.

**COLOR:** Aluminum (Available in several colors - 332.54 for Pearl Gray, 331.15 for White, 332.48 for Aluminum Gray).

**FINISH:** Semi-Gloss

**COMPONENTS:** Two

**MIXING RATIO:** Equal volumes of Base No. 339.03 and Activator No. 339.03B (For cool weather use 339.03C)

**POT LIFE:** With 339.03B: 4 to 6 hours @ 77°F  
With 339.03C: 2 to 4 hours @ 65°F

**WEIGHT PER GALLON:** With 339.03B: 11.0 ±.5 lbs (mixed)  
With 339.03C: 11.3 ±.5 lbs (mixed)

**VOC:** With 339.03B: 1.60 lbs mixed)  
With 339.03C: 2.56 lbs mixed)

**SOLIDS BY VOLUME:** With 339.03B: 77 ±1.0%  
(mixed) With 339.03C: 64 ±1.0%

**COVERAGE:** (mixed) @ 1 mil DFT  
With 339.03B: *Theoretical* – 1236 sq. ft./act. gal.  
*Practical* - 989 sq. ft./act. gal.  
With 339.03C: *Theoretical* – 1022sq. ft./act. gal.  
*Practical* - 817 sq. ft./act. gal.

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

**DRYING TIME:** @ 77°F  
*TO TOUCH:* 4 to 6 hours  
*TO RECOAT:* 6 to 24 hours

**TEMPERATURE RESISTANCE:** 200°F continuous

**THINNER:** Use Wilko No. 1, No. 13 or No. 100 Thinner. Use No. 71 Thinner for maximum pot life or when 339.03C 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 SUBSTRATE:** Steel

**RECOMMENDED TOPCOAT:** May be used DTM or may be topcoated with Wilkopon Epoxy, or for gloss retention topcoat with Wilkothane G or HS Polyurethane coatings. Polyurethane is recommended for maximum gloss retention.

**RECOMMENDED PRIMERS:** May be applied directly to metal. For additional corrosion resistance, No. 349.08 or 349.10 Zinc Rich Epoxy Primers or No. 347.40 Wilkopon Beige Primer or 342.46 Wilkopon Gray Primer may also be used.

**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.

**APPLICATION:** Airless spray is recommended for maximum film build. Use a high volume output pump and a tip of 17 or larger. Additional thinning is required if applied using conventional gun, resulting in lower film build.

### 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 No. 18 or 62 heavy duty spray gun or Binks 2001 with a 66 PB nozzle.
3. A 25-50 foot length of fluid hose - ½ inch ID minimum, 5/8 inch preferable.
4. A 25 - 50 foot length of air hose - ½ inch ID minimum, 5/8 inch preferable.
5. 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 should be used.

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**APPLICATION PROCEDURE:**

1. Separately mix the base and activator components until uniform, then mix equal volumes of the base and 339.03B Activator. Allow mixture to stand for at least 30 minutes before using.
2. For cool temperature application (40-70°) use 339.03C instead of 339.03B. Do not use 339.03C if ambient temperature is above 70°F – potlife will be short. Do not thin with more than 91 oz of No.71 Thinner per gallon of material activated with 339.03B to keep VOC below 3.8#/gal (51 oz. when activated with 339.03C).
3. **REDUCTION:**  
*Conventional Spray:* Thin up to 25% with appropriate thinner (refer to previous section for recommended thinner and maximum thinner allowed to meet VOC restriction).  
  
*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. Caution: Any thinner added will raise the VOC of the coating.
4. *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.
5. If the ambient temperature exceeds 85°F, reduce 339.03 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.
6. *Brush or Roller:* Thin activated material until workable for spray 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.
7. Allow coating to cure 3 - 5 days at 77°F before placing into immersion service.

**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. Secure medical attention in all case of exposure.

**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.