



# WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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## WILKO NO. 342.22 WILKOPON PRIMER GRAY

**PRODUCT DESCRIPTION:** No. 342.22 Wilkopon Primer Gray is a two component epoxy polyamide primer that has good early recoat properties. It has excellent sanding and filling properties, which makes it ideal for refinishing surfaces that have been previously coated with epoxies and urethanes. Has excellent adhesion to a wide variety of substrates including concrete, treated galvanized & stainless steel, etched aluminum, and fiberglass filled polyester plastics.

**PRINCIPAL USE:** Recommended as coating for steel and concrete surfaces that require chemical and corrosion resistance. Ideal as a primer for transportation vehicles when topcoat with urethanes. This primer has good adhesion to clean (or sanded) old epoxy and urethane paint, which makes it an ideal sealer over such coatings for recoating with urethanes.

**COLOR:** Gray (342.22 for Yellow, 347.49 for red oxide, 341.22 for white)

**COMPONENTS:** Two

**MIXING RATIO:** Four volumes of No. 342.22 to one volume of No. 342.22B Activator. For cool weather applications (50-70°F), use 342.22C Wilkopon Cool Weather Activator.

**POT LIFE:** with 342.22B: 8-10 Hours @ 77°F  
with 342.22C: 2-4 Hours @ 77°F  
Continuous mixing or high temperature will shorten pot life

**WEIGHT PER GALLON:** 10.6 ±.5 lbs.

**VOLATILE ORGANIC COMPOUNDS:** 3.7 lbs.

**SOLIDS BY VOLUME:** 45.7 ± 1.0%

**COVERAGE:** @ 1 mil dry  
*Theoretical* - 732 square feet per gallon  
*Practical* - 586 square feet per gallon

**VISCOSITY:** 475-525 cps  
@77°F

Values will vary with change in temperature and may rise on aging.

**DRYING TIME:** @ 77°F W/342.22B W/342.22C  
*To Touch:* 1 to 2 hours ½ to 1 hour  
*To handle:* 6 to 8 hours 2 to 4 hours  
*To Recoat:* 30 minutes - 72 hr. After 72 hours, scuff sand surface before topcoating. It may be wet sanded in 6 hours. Recoat same day if alkyd topcoat is used. It may be force dried at 250°F (surface temperature) for 10-15 minutes to achieve a faster dry-to handle time.

**RECOMMENDED DRY FILM THICKNESS:** 2-3 mils

**RECOMMENDED THINNER:** Wilko No. 71 or Wilko No. 44. Use No. 71 for temperatures above 90°F. or when using 342.22C CW Activator. Use No.71 or No.38 MEK for cleanup.

**TEMPERATURE RESISTANCE:** 200°F continuous, 250°F dry, 300° intermittent

### PHYSICAL PROPERTIES\*:

INITIAL 60° GLOSS ..... <20  
PENCIL HARDNESS ..... H-2H  
DIRECT IMPACT IN-LBS ..... 40  
REVERSE IMPACT IN-LBS ..... 20  
CONICAL MANDREL, PASS ..... 1/4 INCH DIAMETER  
MEK DOUBLE RUBS ..... 20 NO EFFECT  
2 HOURS GASOLINE EXPOSURE ..... NO EFFECT  
1200 HOURS SALT FOG ..... EXCELLENT

*\*Applied directly to Bonderite 1000 cold rolled steel at 2 to 3 recommended mils dry (4-7 wet). Finish is air dried 14 days at room temperature before tests were conducted. Bonderite 1000 is iron phosphate - treated polished cold rolled steel*

### Salt spray tests using 342.22 Wilkopon Epoxy Primer and 721.11 Wilkothane G Topcoat:

Over Sandblasted Steel: 2000 Hours  
Over Bonderite 1000: 1800 Hours

**RECOMMENDED THINNER:** Wilko No. 71 or Wilko No. 44. Use No. 71 for temperatures above 90°F. or when using 342.22C CW Activator. Use No.71 or No.38 MEK for cleanup.

**RECOMMENDED PRIMER:** May be used as intermediate coat over Zinc Rich Primers such as Wilko Nos. 349.08 or 349.23 Wilkopon Zinc Rich Primer, and No. 859-06 Inorganic Zinc Rich Primer.

**RECOMMENDED SUBSTRATE:** Steel, Prepared Aluminum

**RECOMMENDED TOPCOATS:** Polyurethanes, Epoxy Enamels and Vinyls. May also be topcoated with Alkyd Enamels if done within 6 hours.

### SURFACE PREPARATION:

*Steel:* Surface must be clean and dry, free of oil, grease, wax and other contaminants. The 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 Brush 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 prior to the development of surface rust.

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## SURFACE PREPARATION(cont'd)

*Fiberglass Plastics:* Solvent wipe surface using MEK or a wax remover. Scuff sand the surface using #320 or #200 grit sandpaper, then apply light tack coat and let it flash 15-20 minutes before applying a full coat. If any pinholes or craters are evident, use No. 850-10 Anti-Crater Additive at a rate of 2-4 ounces per gallon.

*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

### APPLICATION PROCEDURE:

1. Mix the pigmented component, No. 342.22, until uniform, and then mix four volumes with one volume of No.342.22B Activator. 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. Apply at recommended dry film thickness of 2-3 mils DFT (5-7 WET).

2. *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 2001 spray gun and quart cup. If a pressure pot is used, use one 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.

Following is an example of a typical gun setup for a Binks 2100:

#### **Siphon Fed (Cup Gun):**

Fluid Nozzle: 66SS (0.070 Orifice), Part #45-6601

Air Nozzle: 66SD, Part #46-6020

Needle: #565, Part # 47-56500

Atomization Pressure: 40-60 psi

#### **Pressure Fed**

Fluid Nozzle: 63CSS (0.052 Orifice) Part #45-6331

Air Nozzle: 63PB, Part #46-6002

Needle: 563A, Part #47-56310

Pot Pressure: 5-10 psi

Atomization pressure: 40-60 psi.

3. *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.

4. *BRUSH OR ROLLER:* For concrete walls and floors, brush or roller application is preferred to assure coverage of porous surfaces, however, these methods will leave brush or roller streak marks.

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. Topcoating with Alkyds: This primer may be topcoated with alkyd enamels provided that it is recoated within 4 to 6 hours. For critical applications, check the adhesion of individual topcoats before proceeding with the whole job. Use No. 71 Thinner for topcoat, and check for lifting or strike-in (loss of gloss). Additional adhesion and DOI may be achieved if the primer is wet-sanded with No.400 sandpaper after four hours' drying.

8. Film Thickness: This primer may be applied at higher film thickness to fill imperfections, provided that each coat is allowed to dry, and that the coating is not to be subjected to applications where thermal stress will be encountered (sudden change in temperature in a short period). If each coat is not allowed to dry, solvent may get trapped in the film, resulting to failures like mudcracking or alligatoring. On film thickness of between 6-12 mils, check for pencil hardness after 48-72 hours. If the film is hard to touch but appears gummy after the film is broken, solvent may be trapped in the film, and topcoating it is not recommended until the film is completely hard (pencil hardness of H or better). Do not topcoat if mudcracking is evident - sandblast and re-prime when this occurs.

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

10. *Coating 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, apply a wet mist coat of the 342.22 over surface area, allowing a short interval for solvent to escape. Follow with full wet coat, or apply a tie coat which has been reduced by 50% or more. 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, depending on the top coat and exposure requirements. See topcoat TDS for more information.

**ALTERNATE PRODUCTS:** For lower VOC requirements use Wilko No. 342.45 or 342.44 Wilkopon Primers.

**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 cases 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.

