



WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON HS RECOATABLE PRIMER GRAY WILKO NO. 342.46

PRODUCT DESCRIPTION: No. 342.46 Wilkopon HS Primer Gray is a two component epoxy, high build, epoxy-polyamide coating designed for fast dry and early or extended recoatability. It meets the Arizona Administrative Code Section R18-2-727. It also meets the Maricopa County Emission limits of 3.5#/gal for air-dried coating for metal parts and products

TYPICAL USES: Recommended as coating on exterior of storage tanks, structural steel and miscellaneous equipment in chemical and refinery facilities. It is designed to have a variable recoat window required due to construction schedules.

GENERIC TYPE: Epoxy-Polyamide

COLOR: Gray (available in red – 347.67)

FINISH: Flat

COMPONENTS: Two

MIXING RATIO: One part of 342.46A to One part of 342.46B Activator.

SWEAT IN TIME: 30 minutes @ 77° F

POT LIFE: with 342.46B: @75° F 8 hrs, @100° F 2 hrs
with 342.46C: @50° F 4hrs, @ 70° F 1 hr

WEIGHT PER GALLON: 11.6 +.5 lbs (mixed)

VOC: 2.5 lbs (mixed)

SOLIDS BY VOLUME: 64 ± 2.0% (mixed)

COVERAGE: @ 2 mil DFT
Theoretical - 510 sq. ft./act. gal.
Practical - 408 sq. ft./act. gal.

RECOMMENDED THICKNESS: 2.5 to 4 mils DFT

RECOMMENDED NUMBER OF COATS: 1 to 2

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

THINNER: No. 71 (best), Retarder No. 101 or No. 44
REDUCTION: with 342.46B Activator

Below 85 °F: Up to 34 oz No. 71 Thinner (3.5 #VOC)

Up to 50 oz No. 71 Thinner (3.8#VOC)

Above 85 °F: Up to 29oz No.101 Retarder (3.5#VOC)

Up to 42oz No.101 Retarder (3.8# VOC)

With 342.46C Activator, use No. 71 Thinner only.

CLEAN UP THINNER: No. 71 or MEK

SHELF LIFE: One Year

FLASH POINT: 342.46A: 60° F TCC
342.46B: 45° F TCC
342.46C: 45° F TCC

DRYING TIME (Primer will full cure in 2 weeks at 70°F)
with No. 342.46B Activator

°F/°C*	To Touch	To Recoat
32/0	N/R	N/R
50/10	N/R	N/R
70/20	2 hrs	6 hrs
90/32	1 hr	4 hrs

with No. 342.46C Activator

°F/°C*	To Touch	To Recoat
32/0	N/R	N/R
50/10	4 hrs	6 hrs
70/20	2 hrs	2 hrs
90/32	N/R	N/R

* Surface temperature

RECOMMENDED SUBSTRATE: Steel

RECOMMENDED PRIMERS: Material may be applied directly to properly cleaned metal. For additional corrosion resistance, use No. 349.13 Wilkopon HS Primer Zinc Rich, No. 859.20 Primer WB Inorganic Zinc Rich or 859-06 Primer Inorganic Zinc Rich.

RECOMMENDED TOPCOATS: Wilkopon Epoxies or Wilkothane HS Polyurethanes. It may be recoated within 2-6 hours (depending on activator used and temperature), or up to 1 year after application. Power wash to remove contaminants if recoated after 1 week. It may be recoated wet-on-wet with epoxies, or after up to one year after surface cleaning.

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 Brush 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. Sandblast profile of 1-3 mils is recommended. Apply primer prior to the development of any surface rust.

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APPLICATION METHODS: Conventional or airless spray, brush, and roller

EQUIPMENT REQUIRED:

Airless Spray:

1. Airless spray equipment with pump ratio of 28:1 or 30:1.
2. Airless spray tip with orifice diameter of 0.015 to 0.019
3. A 25-50 foot length of fluid hose

Conventional Spray:

1. Pressure pot with dual air regulator.
2. Spray gun such as a DeVilbiss MBC with an AV-601 EX fluid tip, 496 DEX needle and 704 or 64 air cap, or Binks No. 18 or 62 heavy duty spray gun with a 66 PB nozzle
3. A 25-50 foot length of fluid hose - ½ inch ID minimum.
4. A minimum of 75psi continuous air supply to each spray gun.

APPLICATION PROCEDURE:

1. **ACTIVATION:** Separately mix No. 342.46A Part A (base) and No. 342.46B Part B (activator) components until uniform, then mix equal volumes of base and activator and allow mixture to stand for 30 minutes before using. For Cool Weather (50-70°F), use 342.46C Activator instead of 342.46B for Part B. Mix equal volumes of base and 342.46C activator, allow to stand 5 minutes, then use immediately or within the specified pot life.
2. **REDUCTION:** *Conventional Spray:* Thin up to 25% with appropriate thinner (see above section -RECOMMENDED 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. (see above-RECOMMENDED 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. 71 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. If the ambient temperature exceeds 85°F, reduce with No. 101 Thinner Retarder to avoid any dry overspray. Do not apply when surface temperature is less than 5° above dew point.
5. 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.

7. **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, apply a wet mist coat 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.
8. **Coating previously Painted Surfaces:** If coating is in sound condition, clean the surface of all foreign material and apply the primer 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. If needed, use No. 13 Thinner (do not use No. 71) and apply a thin intermediate coat (2-3 mils wet) to seal the old paint. Do not apply a heavy coat as this will saturate the old paint that may cause lifting and lead to paint failure. Heavy films will also cause stress on the old coating that may cause delamination or splitting.

PHYSICAL PROPERTIES:

Direct Impact Resistance	160 in. lbs	(ASTM G14)
Salt Fog Resistance	1000 hrs.	(ASTM B117)
Flexibility	Passes (1/8 inch conical mandrel)	
Heat Resistance	Passes (200° F continuous)	

CHEMICAL RESISTANCE:

(Fumes, Splash and Spillage, Non-Immersion)

Aromatic Hydrocarbon	Passes
Aliphatic Hydrocarbons	Passes
Alkali Solutions	Passes
Acid Solutions	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. Secure medical attention in all exposure incidents.

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.