

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 PRIMER RED OXIDE WILKO NO. 347.49

PRODUCT DESCRIPTION: No. 347.49 Wilkopon Primer Red Oxide 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: Red Oxide (more colors are available)

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 347.49 to one volume of No. 347.49B Activator. For cool weather applications (50-70°F), use 347.49C Wilkopon Cool Weather Activator.

POT LIFE: with 347.49B: 8-10 Hours @ 77°F
with 347.49C: 2-4 Hours @ 77°F
Continuous mixing or high temperature will shorten pot life

WEIGHT PER GALLON: 10.6 ± 5 lbs.

VOLATILE ORGANIC COMPOUNDS: 3.8 lbs.

SOLIDS BY VOLUME: 45.5 ± 1.0%

COVERAGE: @ 1 mil dry
Theoretical - 730 square feet per gallon
Practical - 584 square feet per gallon

RECOMMENDED DFT PER COAT: 2-3 Mils

FLASH POINT: Part A: 45 °F TCC
Part B: 55°F TCC

DRYING TIME: @ 77°F

To Touch: 1 to 2 hours
To handle: 6 to 8 hours
To Recoat: 30 minutes - 72 hr. After 72 hours, scuff sand surface before topcoating. May be wet sanded in 6 hours. Recoat same day if alkyd topcoat is used.

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

CLEAN UP THINNER: No. 71 or MEK

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
200 HOURS SALT FOG EXCELLENT

RECOMMENDED THINNER: Wilko No. 71 or Wilko No. 44. Use No. 71 for temperatures above 90 °F. or when using 347.49C CW Activator.

RECOMMENDED APPLICATION: May be applied by brush or roller, or conventional or airless spray.

RECOMMENDED PRIMER: May be used as intermediate coat over Zinc Rich Primers such as Wilko No. 349-08 and No. 859-06.

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

RECOMMENDED SUBSTRATE: Steel

SURFACE PREPARATION:

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

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. *continued on page 2*

APPLICATION PROCEDURE:

1. Mix the pigmented component, No. 347.49, until uniform, and then mix four volumes with one volume of No.347.49B 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.

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.

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.

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.

ALTERNATE PRODUCTS: For low VOC requirements use Wilko No. 342.45 or 342.44 Wilkopon Primers. For gray version use 342.22, for white use 341.22. Call Wilko for other colors,

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.