



WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON HS RECOATABLE PRIMER RED WILKO NO. 347.67

PRODUCT DESCRIPTION: No. 347.67 Wilkopon HS Primer Red 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: Red (available in gray)

FINISH: Flat

COMPONENTS: Two

MIXING RATIO: One part of 347.67A to One part of 347.67B Activator.

SWEAT IN TIME: 30 minutes @ 77° F

POT LIFE: with 347.67B: @75° F 8 hrs, @100° F 2 hrs
with 347.67C: @50° F 4hrs, @ 70° F 1 hr
Thinning with No. 71 Thinner will help extend pot life. Do not expose paint and equipment to direct sun .

WEIGHT PER GALLON: 11.7 +.5 lbs (mixed)

VOC: 2.5 lbs (mixed)

SOLIDS BY VOLUME: 63 ± 2.0% (mixed)

COVERAGE: @ 2 mil DFT
Theoretical - 507 sq. ft./act. gal.
Practical - 406 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 347.67B 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 29 oz No.101 Retarder (3.5#VOC)

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

With 347.67C Activator, use No. 71 Thinner only.

CLEAN UP THINNER: No. 71 or MEK

APPLICATION METHODS: Conventional or airless Spray

FLASH POINT: 347.67A: 60° F TCC
347.67B: 45° F TCC
347.67C: 45° F TCC

SHELF LIFE: One Year, unopened and stored below 90°F

DRYING TIME (Primer will full cure in 2 weeks at 70°F)

with No. 347.67B Activator	°F/°C*	To Touch	To Recoat
32/0	N/R	N/R	N/R
50/10	N/R	N/R	N/R
70/20	2 hrs	6 hrs	
90/32	1 hr	4 hrs	

with No. 347.67C Activator	°F/°C*	To Touch	To Recoat
32/0	N/R	N/R	N/R
50/10	4 hrs	6 hrs	
70/20	2 hrs	2 hrs	
90/32	N/R	N/R	N/R

* Surface temperature N/R – Not Recommended

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. May be recoated wet-on-wet with epoxies.

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. Blast profile must be between 1-3 mils. Apply primer prior to the development of any surface rust

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APPLICATION PROCEDURE:

1. **ACTIVATION:** Separately mix No. 347.67A Part A (base) and No. 347.67B 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 347.67C Activator instead of 347.67B for Part B. Mix equal volumes of base and 347.67C activator, allow to stand 5 minutes, then use immediately or within the specified pot life.
2. **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). Use an airless spray equipment with pump ratio of 28:1 or 30:1, spray tip with orifice diameter of 0.015 to 0.019, and a 25-50 foot length of fluid hose
3. **CONVENTIONAL SPRAY:** Thin up to 25% with appropriate thinner (see above section -RECOMMENDED THINNER). Apply tack coat and follow with full wet coat. Hold gun 8-10 inches from surface and overlap each pass 25% to avoid holidays. Apply using atomization pressure of 40-60 psi, and for pressure-fed gun, use pot pressure of 5-10 psi. Following is an example of a typical gun setup for a Binks 2100:

	Siphon Fed Gun	Pressure Fed
Fluid Nozzle	66SS (0.070 Orifice), Part #45-6601	63CSS (0.052 Orifice) Part #45-6331
Air Nozzle	66SD, Part #46-6020	63PB, Part #46-6002
Needle	#565, Part # 47-56500	563A, Part #47-56310

4. **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.
5. If the ambient temperature exceeds 85°F, reduce with No. 101 Thinner Retarder to avoid any dry overspray.
6. 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.
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. 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. Do not apply when surface temperature is less than 5° above dew point or when the humidity exceeds 70%.
9. **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.