

# WILKO PAINT, Inc.

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## MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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### WILKOPON HS PRIMER ZINC RICH WILKO NO. 349.10

**PRODUCT DESCRIPTION:** No. 349.10 Wilkopon HS Primer Zinc Rich is a two component epoxy polyamide coating. It provides excellent protection in chemical spillage areas and it has excellent corrosion resistance due to the cathodic nature of zinc.

**PRINCIPAL USE:** Recommended as a primer coating on exterior of storage tanks, structural steel and miscellaneous equipment in chemical and refinery facilities. It is an ideal primer for three-coat system consisting of zinc rich primer, epoxy intermediate coat, and polyurethane topcoats.

**COLOR:** Gray

**GENERIC TYPE:** Epoxy-Polyamide

**FINISH:** Flat

**COMPONENTS:** Two

**MIXING RATIO:** Eight parts of 349.10 to one part of 349.10B or 8 parts of 349.10 to one part of 349.10C (cool weather) Activator

°F/°C	W/ 349.10B	W/ 349.10C
	Activator	Activator
40/0	N/R	N/R
50/10	N/R	8 hrs
70/20	8 hrs	6 hrs
90/32	6 hrs	N/R
N/R = Not Recommended		

**WEIGHT PER MIXED GALLON:** 23.5 ±.5 # 23.5#

**VOC:** pounds/activated gallon 3.47 3.49

**SOLIDS BY VOLUME:** 51.8 ±1 % 51.3 ±1 %

**COVERAGE:** sq. ft./act. gal. @ 1 mil DFT  
Theoretical - 830 796  
Practical - 664 637

**RECOMMENDED DRY FILM PER COAT:** 2-3 mils

**NUMBER OF COATS:** 1 to 2 recommended

**RECOMMENDED SUBSTRATE:** Steel

**TEMPERATURE RESISTANCE:** 200°F continuous  
250°F intermittent

**RECOMMENDED PRIMER:** Apply directly to properly cleaned metal.

**CLEAN UP THINNER:** No. 71 or MEK

#### DRYING TIME:

°F/°C*	w/349.10B Activator		w/349.10C Activator	
	To Touch	To Recoat	To Touch	To Recoat
32/0	N/R	N/R	N/R	N/R
50/10	N/R	N/R	4 hrs	6 hrs
68/20	2 hrs	8 hrs	2 hrs	2 hrs
90/32	1 hr	4 hrs	N/R	N/R

\*Surface and air temperatures

**RECOMMENDED THINNER:** Use Wilko 71 Use the following guidelines for VOC of material after thinner is added (in ounces) to activated gallon to limit VOC to 4.2#/gal:  
Thinner Added with 349.10B 349.10C  
No. 71 33 32

**RECOMMENDED TOPCOATS:** Use epoxy intermediate coats or topcoats only. May be recoated with epoxies or itself after 2 hours. Recoat within 72 hours

**SURFACE PREPARATION:** Sandblast to conform to a minimum NACE #2 or SSP-SP10 surface preparation standard (Near White) as described below:

*Near White Blast Cleaned Surface:* Defined as a surface from which all dirt, grease, oil, paint, corrosives, mill scale, rust, oxides or other foreign matter has been removed except for light shadows and streaks or slight discoloration (oxide that is bonded with metal). At least 95% of any given surface area has the appearance of NAC #1 (White Metal) and remaining area is limited to slight discoloration (Comparable to SSP-SP10, Near White Blast Cleaning). Prior to Sandblasting: Round off all sharp edges and remove all weld splatter with power tools. Remove oil, grease, and other surface contaminants with suitable solvent or detergent wash. After sandblasting and before priming, remove all sand and other residue from surface with high-pressure air, lint free rag or vacuum. Sandblasted surface should not show effects of any oxidation or contamination prior to application.

#### APPLICATION:

**EQUIPMENT REQUIRED:** As recommended or equal

*Conventional:* DeVilbiss MBC-510 gun with heavy mastic spring, an E tip and a 704 air cap, or Binks 18, 62, or 69 gun with a 66 nozzle and no more than 25 feet of 1/2" ID material hose. A variable speed agitator in the pressure pot and an oil and moisture trap in the main air supply line are essential. Also, separate air and fluid pressure regulators are recommended.

*Airless:* Recommended for maximum film build. A Graco Bulldog 30:1, a Speedflo Alaskan PZ, or equivalent designed for zinc applications. Teflon packing is recommended for reliable pump operation. Use a fluid tip with a .017 inch orifice or larger and 1800-3000 psi fluid pressure. Use a variable speed mixer to keep the primer uniformly blended. *continued on page 2*

**APPLICATION PROCEDURE:**

**CAUTION** - To insure against the loss of, or damage to spray equipment, do not allow any material to remain in pot, pump or fluid lines when unit is not operating, except for brief periods. When an operation interruption is necessary, immediately purge the equipment of material to prevent any "zinc packing" and/or setting up of the activated material. Caution should be observed if No.349.10C (Cool Weather Activator) is used due to the short pot life.

1. Separately mix No. 349.10 Part A (Base) and No. 349.10B or 349.10C (Activator) components until uniform, then mix 4 volumes of base and one volume of 349.10B Activator or 8 volumes of base to one volume of 349.10C. Allow mixture to stand for 30 minutes if No.349.10B is used, (5 minutes if No. 349.10C is used), before using.
2. **TECHNIQUE:** Properly adapted equipment for application of organic zinc is of the utmost importance. (see "Equipment" above). Optimum galvanic functionality of the zinc filler is accomplished by the uniform deposition of the total amount of zinc filler. Settling of the heavy particulates in the spray container will cause an imbalance of the formulation and will adversely affect performance, illustrating the need for the suspension of the zinc by frequent agitation during the application process. The applicator must deposit the atomized material as a wet film (wetness is observed briefly at high ambient temperatures) to minimize dry spray and excessive dissipation of the vehicle between nozzle and surface. Loose powder, observed by the naked eye or easily brushed off with bare hands, is an indication of improperly thinned and/or applied primer and may result in difficulty with the application of the topcoat and an early system failure. At higher temperatures (over 75°F), or under windy conditions, adjust spray equipment and/or add additional No. 37 until a wet film can be deposited at the proper film thickness. Multiple passes with spray apparatus may be necessary to get the recommended film depth, especially with conventional equipment. A wet film gauge is useful in determining the approximate dry film depth of organic zinc if used as follows: After film has set for an hour or so, as indicated by dry flat surface conditions from solvent loss, place gauge firmly on flat surface, move in scratching motion until bare metal is contacted. The imprint left by the graduated prongs indicates the approximate depth of the uncured film. Due to the high solids content and the puffy and porous nature of the coating, the reading obtained is a reasonably accurate dry film measurement of the cured organic zinc. With this type of high solids primer, minimal shrinkage will occur during completion of the cure after all the solvents have evaporated.
3. **REDUCTION:** Because of the differences in painting conditions, equipment and application techniques, adjustments in the amount of thinner used may be necessary.  
*Conventional and airless Spray:* May be applied without thinning. VOC will stay within 4.2 #/gal with the addition of up to 5% of appropriate thinner. **CAUTION-** Zinc will settle rapidly due to its heavy weight, and over thinning will make zinc settle faster.
4. If the ambient temperature exceeds 85°F, reduce with No. 101 Thinner or No. 37 Thinner to avoid dry overspray. Do not apply when surface temperature is less than 5°F above dew point. Pot life is shorter when thinned with No. 101.
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 occurs because of failure to acknowledge the facts related to low temperature application.

6. *Coating Organic 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.

**RESISTANCE GUIDE:** For optimum resistance, topcoat with suitable coating.

*Water:* Excellent resistance to fresh, salt and sea water.

*Salt:* Resists spillage and splash by most alkaline salt solutions in atmospheric exposures at temperatures up to 200°F.

*Alkali:* Resists temporary exposure to fumes splash and/or spillage of concentrated solutions at temperatures up to 150°F.

*Acid:* Resists fumes of non-oxidizing acids.

*Alcohol:* Accepts the spillage of isopropyl, ethyl and butyl alcohols.

*Petroleum Distillate:* Resists splash and/or spillage of gasoline, sour crude, diesel fuel, jet fuel and lubricating oil.

*Adhesion:* Excellent to 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.

**ALTERNATE PRODUCTS:** Wilkopon Zinc Rich Primer Nos. 349.08, 349.13 and 349.23. 349.13 is a higher solids, lower VOC version. The 349.23 is a 3-component version that has the same solids and properties as the 349.13.

**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 incidence 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.

