



WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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ENAMEL HS WHITE

WILKO No. 461.14

PRODUCT DESCRIPTION: No.461.14 Enamel HS LF White #16440 is high quality alkyd enamel formulated to provide good exterior durability. It possesses a long "open time" suitable for spraying large structures.

PRINCIPAL USE: Used extensively for the exterior surfaces of storage tanks, vessels and structural steel in industrial areas.

WEIGHT PER GALLON: 10.3 ±.5 lbs.

VOLATILE ORGANIC COMPOUNDS: 2.9 lbs./gal

SOLIDS BY VOLUME: 56 ± 1.0%

COVERAGE: @ 1 mil dry
Theoretical - 898 square feet per gallon
Practical - 719 square feet per gallon

RECOMMENDED DFT PER COAT: 2-3.0 Mils

DRYING TIME: @ 77°F
To Touch: 1 to 2 hours
To handle: 6 to 8 hours
To Recoat: Overnight

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

RECOMMENDED THINNER: Wilko No.1, No.2, No.10, or No.25. Use No.1 or No.25 for cool weather (60-70°F) and use No. 2 at 70-90°F. For temperatures above 90 °F, use No.10 to avoid dry overspray. Do not add more than 11 ounces per gallon to keep VOC at less than 3.5. Do not add more than 24 ounces of thinner to keep VOC at the AIM limit of 3.8 #/gal for industrial maintenance finishes.

CLEAN UP THINNER: No. 10 or Xylol

TEMPERATURE RESISTANCE: 200°F dry, continuous

RECOMMENDED PRIMER: Wilko No. 491.22 CI White, 492.22 Primer CI Gray, or No. 497.50 or 497.105 Primer Corrosion Inhibitive Red

HARDENER: This coating will dry without any hardener. For added toughness and to accelerate overnight dry especially in cool weather, use Wilko No. 050.43 Hardener at a rate of 8 oz per gallon.

SURFACE PREPARATION: Surface must be clean and dry, free from oil, grease, wax or any other contaminants. For maximum protection of steel surfaces, dry abrasive blast to a Commercial Blast Finish in accordance with SSPC-SP6. Apply recommended primer prior to development of any surface rust, then topcoat.

APPLICATION:

Mix contents until homogenous, then thin as needed. Refer to *Recommended Thinner*, above, for reduction amounts.

1. **CONVENTIONAL SPRAY:** No special gun setup is needed to apply this product. Most suction or pressure fed gun intended for applying low viscosity coating will work for this application. Examples are Binks Model 62 or 2001 Gun with a fluid tip of 63 - 66 and air cap of 63PR for pressure fed, to 66SK for siphon fed, guns. For pressure fed setup, regulate the tank pressure at 5-10 psi. Atomization pressure should be maintained at 65-75psi. A moisture and oil trap in the main air supply line is required.

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.

2. **AIRLESS SPRAY:** Use a high output airless equipment, such as Graco Bulldog Hydra-Spray or larger, with a .011 - .017 inch fluid tip and tip pressure of 2400 psi. For best results use fluid tip of .010 -.015 and an air source of 80-100# using a 28:1 pump ratio (approximately 2500 psi fluid pressure). Using a larger tip or lower pressure may affect application properties of the coating and will result in air entrapment and sags. If pigtails are evident, increase pressure, use smaller tip, or add thinner.
3. Spray apply one wet tack coat and follow with a full wet coat. Hold spray gun 6-8 inches from surface and overlap each pass 25%. Allow first coat to dry for at least 16 hours @ 77°F (25°C) before applying a second coat.
3. **BRUSH OR ROLLER:** Use high quality roller covers and brushes to *obtain* a smooth finish and minimize lap marks. If necessary, thin with No. 10 thinner; do not over thin to avoid sagging.
4. For best results, use at temperature of 65°F or above. Do not apply when surface or ambient temperature is anticipated to drop below 50°F in 24 hours. Do not apply to damp surfaces, and surface temperature must be 5°F above the dew point for 24 hours to prevent moisture condensation, which might result in water spotting and poor film integrity.
5. To avoid any contamination, use an air source with a good moisture trap and oil filter. Contamination with water will result in short pot life, poor film integrity and early coating failure. Any contamination with oil and other particulates, including water, could result in cosmetic defects (pin holing, cratering, crawling, etc.) and/or loss of adhesion.

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APPLICATION (cont'd):

6. Use No.850.05 Fish Eye Eliminator if pin holing or cratering is evident. For areas that are heavily contaminated with oil, wax or other particulate that may cause surface defects, use No. 850.10 Anti-Crater at a rate of up to 4 ounces per gallon of paint. This must not be used as an alternative to proper surface cleaning prior to painting.
7. Allow coating to cure 3 - 5 days at 77°F before placing into service. Applicators should be made aware, especially during cool seasons or in cooler climates, that this material will require 12-16 hours curing time at 77°F for recoating, and that during this period the film is extremely vulnerable to moisture and moisture laden contaminants. Consequently, the painting schedule must be planned to include the deposition of material early enough to provide at least partial cure prior to lower nighttime temperatures and possible dew point conditions.
8. Curing rates are accelerated by heat and retarded by lower temperatures. Drying rates are based on 75°F. As a rule, for every 18° above 75°F the curing rate will accelerate by approximately 100%. For every 18° below 75°F the curing rate will be retarded by approximately 100%. The premature failure of fine coating systems is often caused by failure to acknowledge facts related to applying at low temperatures. This coating may not cure at temperatures of 50°F or lower. Do not apply if the average temperature is not expected to go over 50°F during the next 24 hours.
9. For Painting aluminum, galvanized steel and other surfaces, download Wilko Publications for surface preparation for different substrates at:

<http://www.wilkopaintinc.com/Download1.html>

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 (MSDS).