

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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ENAMEL DAIRY WHITE WILKO NO. 481.07

PRODUCT DESCRIPTION: Wilko No.481.07 Enamel Spray White is a fast dry chain – stopped alkyd enamel that has good durability and excellent gloss retention.

TYPICAL USES: Used on farm, implement and transportation equipment and also as a general protective and decorative coating.

GENERIC TYPE: Chain-stopped alkyd

COLOR: White

FINISH: Gloss

WEIGHT PER GALLON: 9.7 lbs.

VOC: 4.34 pounds per gallon

SOLIDS BY VOLUME: 39 ± 1 %

COVERAGE: @ 1 mil dry film
Theoretical - 626 square feet/gallon
Practical - 500 square feet/gallon

RECOMMENDED DRY FILM THICKNESS: 1 to 2 mils

DRYING TIME: @ 77°F
To Touch: 5 to 10 minutes
To Handle: 1 to 2 hours

THINNER: Wilko No. 1 or No. 13

CLEAN UP THINNER: Wilko No. 1 or No. 13

RECOMMENDED SUBSTRATE: Steel

RECOMMENDED PRIMER: Wilko No. 497-35 Primer Corrosion Resisting Red or No.497-81 Primer Corrosion Resistant Beige.

TEMPERATURE RESISTANCE: 200°F continuous

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 other contaminants. The use of chemical cleaning or pretreatment (e.g., phosphatizing) will help improve adhesion, enhances the overall properties of the coating, and is highly recommended. For most industrial applications, this multi - stage surface preparation is adequate.

When coating newly fabricated steel, or if heavy mill scale, rust, or loose paint is present on existing structures, clean the parts by mechanical means. All sharp edges must be rounded and weld splatter must be removed prior to cleaning. Hand, power tool, or SP7 Brush Blast Cleaning will afford minimum protection only. For maximum protection of steel surfaces, dry abrasive blast to a commercial Blast Finish in accordance with SSPC-SP6. Apply the primer or coating prior to the development of any surface rust. An appropriate primer must be used when coating sandblasted steel surfaces.

Refer to Wilko's *Metal Preparation Guide* when painting aluminum or galvanized steel. Note: Do not apply to stainless or galvanized steel or aluminum without using an appropriate primer.

APPLICATION PROCEDURE:

1. Mix until uniform, and then reduce up to 25% with No. 1 or No. 13 Thinner. Use No. 1 when spraying small parts or in cool weather for faster dry and to avoid sagging.
2. **AIRLESS SPRAY:** Thin approximately 10-20% by volume with No. 1 or No. 13 Thinner to a spray viscosity of 20-26 seconds on the Zahn No. 2 Cup. Spray apply one wet tack coat and follow with full wet coat. Hold spray gun 6 - 8 inches from surface and overlap each pass 25%. For the best results use a fluid tip of .010-.015 and an air source of 80 - 100# using a 28:1 pump ratio (approximately 2500 psi fluid pressure). Use of a larger tip or lower air pressure may affect the application properties of the coating and may result in sags and air entrapment.
3. **CONVENTIONAL SPRAY:** Thin approximately 25% by volume with Wilko No.1 or No.13 Thinner. If ambient temperature is 85°F or higher, use Retarder No. 100. Spray apply one wet tack coat and follow with two full wet coats. Hold gun 8-10 inches from surface and overlap each pass 25%.
4. To avoid any contamination an air source with a good moisture trap and oil filter is required. Contamination with water will result in surface defects, poor film integrity and early coating failure. Any contamination with oil or other particulates, including water, may result in cosmetic defects (pinholing, cratering, crawling, etc.) and/or loss of adhesion.
5. Use Wilko No. 850-05 Fish Eye Eliminator if pinholes or craters become evident. For areas that are heavily contaminated with oil, wax or other particulates that 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.
6. When recoating, watch for the critical recoat period, at which time the coating is susceptible to lifting. This usually lasts from 2-10 days and varies with the ambient curing temperature. Test a small area before recoating entire surface.

continued on page 2

WILKO NO. 481.07 - Page 2

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 cases of exposure.

PRECAUTION: 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.