

# 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

## PRIMER HS LOW VOC GRAY WILKO NO. 492.43

**PRODUCT DESCRIPTION:** No.492.43 Primer HS Corrosion Inhibitive Gray is a fast dry, lift resistant, high solids alkyd primer. It is formulated with lead and chromate free ingredients and has a low HAPS and low VOC content.

**PRINCIPAL USE:** Designed as primer for steel surface to be topcoated with alkyd enamels, acrylic emulsions, and polyurethanes. As a primer for structural steel, storage tanks, farm equipment and machinery, and for most OEM applications.

**COLOR:** Gray (available in other colors)

**WEIGHT PER GALLON:** 12.6 ±.5 lbs.

**VOC:** 3.2 lbs./gal.

**SOLIDS BY VOLUME:** 57 ± 1.0%

**COVERAGE:** @ 1 mil dry  
*Theoretical* - 914 square feet per gallon  
*Practical* - 731 square feet per gallon

**RECOMMENDED FILM THICKNESS:** 1.5 mils dry (plus sandblast profile if sandblasted) for minimum protection. The maximum film thickness must not exceed 2 times this figure or film properties will be compromised.

**SHELF LIFE:** One year, unopened and stored indoors at 77 °F.

**DRYING TIME:** @ 77°F  
*To Touch:* 10 to 15 minutes  
*To Handle:* 30 to 45 minutes  
*To Recoat:* 45 minutes

**TEMPERATURE RESISTANCE:** 200°F dry, continuous

### APPLICATION:

*Ransburg Disc:* Not recommended

*Airless Spray:* Apply as received.

*Conventional Spray:* Reduce up to 10 ounces of No. 13 Thinner to keep VOC below 3.5#/gal, or thin up to 22 ounces to keep VOC below 3.8#/gal.

**RECOMMENDED THINNERS:** Use No.13 for all-weather thinning, Or for alternate thinner use the following:

Below 80°F: Wilko No.158 HAPS Free or No.143 VOC Free Thinner

Above 80°F: Wilko No.11 Retarder or No. 210 Thinner

**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 coating, and is recommended if no mill scale, heavy rust or loose paint is present and sandblasting or other mechanical ways of cleaning is not feasible.

When coating newly fabricated steel, or if heavy mill scale, rust loose paint is present, clean parts by a mechanical means. Sharp edges must be rounded off and weld splatter removed prior to 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 match SSPC-SP6. Apply primer prior to the development of any surface rust.

### APPLICATION EQUIPMENT:

- 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 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. Thin with No. 143 or No.210 Thinner to keep VOC at its level.
- AIRLESS SPRAY:** Any standard airless spray equipment, such as Graco Bulldog Hydra-Spray or larger, with a .011 - .017 inch fluid tip is recommended.

### APPLICATION PROCEDURE:

- Apply by conventional, or airless spray equipment. Stir the primer thoroughly, preferably by mechanical means.
- Apply full wet film with the cross coat method to insure uniform coverage and film depth.
- To assure an adequate cure, do not apply when the surface or ambient temperature is anticipated to drop below 50°F in 24 hours. Surface temperature must be at least 5° above the dew point for 24 - 36 hours to prevent moisture condensation, which might result in water spotting and poor film integrity.
- Do not apply to wet or damp surfaces or surfaces which are likely to be exposed to excessive moisture before an adequate cure occurs.
- Although this coating is recoatable the same day with most paints, it is recommended that the topcoat be tested in an inconspicuous area before proceeding to topcoat the whole unit, especially if done after 16 hours.

**CLEAN UP THINNER:** MEK, No. 1, No.158 or No. 13

**FIRST AID:** If inhaled, remove to fresh air. If not breathing, administer artificial respiration, preferably mouth to mouth or similar method. 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.