

# WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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## PRIMER CORROSION INHIBITIVE RED - QUICK DRY WILKO NO. 497.35

**PRODUCT DESCRIPTION:** No. 497.35 Primer Corrosion Inhibitive Red is a fast dry, non-lifting primer for use on steel surfaces. Designed with lead and chromate free ingredients.

**PRINCIPAL USE:** Is ideal for use as a primer for steel surfaces that are to be topcoated with lacquers, enamels, or acrylic modified alkyds.

**COLOR:** Red (492.24 Gray and other colors available)

**WEIGHT PER GALLON:** 11.6 ±.5 lbs.

**VOLATILE ORGANIC COMPOUND:** 4.6#/gal lbs.

**SOLIDS BY VOLUME:** 37± 1.0%

**COVERAGE:** @ 1 mil dry  
*Theoretical* - 594 square feet per gallon  
*Practical* - 475 square feet per gallon

**RECOMMENDED DFT PER COAT:** 1.5- 2 Mils

**DRYING TIME:** @ 77°F  
*To Touch:* 5 to 10 minutes  
*To handle:* 15 to 30 minutes  
*To Recoat:* 30 to 60 minutes

### PERFORMANCE PROPERTIES:

**Hardness:** Method ASTM D 3363-74: Passes HB requirement after 30 days cure at 77°F

**Salt Spray:** Method ASTM B 117-73: Passes requirement of 500 hours exposure with no more than 1/8 inch creepage at the scribe and no blistering, cracking, softening or delamination of the film.

**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 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 prior to the development of any surface rust.

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.

**TEMPERATURE RESISTANCE:** Dry 200°F continuous

**RECOMMENDED THINNER:** Wilko Thinner No.158, No.1 or Wilko Thinner No.13.

**CLEAN UP THINNER:** No. 13 or Xylol

### APPLICATION EQUIPMENT:

**1. 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 18 or 62 spray gun, and a pressure pot with mechanical agitator. A moisture and oil trap in the main air supply line is required. Thin with Wilko No. 1, No.13 or No. 158 Thinner if needed. 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.

**3. BRUSH OR ROLLER:** Not recommended due to its low viscosity and fast drying characteristics

**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.

**RECOMMENDED TOPCOATS:** Alkyd enamels, acrylic enamels and lacquers

**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 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 or 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.

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