

# WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

## MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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### WILKOTHANE HS WHITE WILKO NO. 721.95

**PRODUCT DESCRIPTION:** No. 721.95 Wilkothane HS White is a high-solids, high-build, two component acrylic polyurethane coating with a 2#/gal VOC that meets most VOC regulations. This material exhibits excellent gloss and color retention during extended service life, and may be applied direct to metal or concrete. It forms a tough, flexible coating that has good chemical and abrasion resistance. It meets the Arizona Administrative Code Section R18-2-727. It also meets the Maricopa County Emission limits of 3.5#/gal for air-dried coating for metal parts and products

**TYPICAL USES:** This material is used for coating structural steel, piping, tanks and vessels in power, petrochemical and treatment plants. It is also used for exterior of railcars, off the road heavy construction equipment and heavy transportation vehicles.

**COLOR:** White (Available in various colors)

**FINISH:** Gloss

**COMPONENTS:** Two

**MIXING RATIO:** Four volumes of No. 721.95 to one volume of No. 050-35 Activator.

**POT LIFE:** 2 to 3 hours at 70°F  
1 to 2 hours at 90°F

**WEIGHT PER GALLON:** 11.8 + .5 lbs/act. gal.

**VOC:** 1.94 lbs/act. gal.

**SOLIDS BY VOLUME:** 70.8 + 2% act.

**COVERAGE:** @ 1 mil DFT  
*Theoretical* - 1135 sq. ft./act. gal.  
*Practical* - 908 sq. ft./act. gal.

**NUMBER OF COATS:** 1-2

**DRY FILM THICKNESS PER COAT:** 2-3 Mils

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

**THINNER:** Wilko No. 44 or Retarder No. 145

**CLEAN UP THINNER:** Wilko No. 44 or MEK

**DRYING TIME:** *To Touch:* 2-3 hours at 70°F  
1-2 hours at 90°F  
*To Handle:* 8-10 hours at 70°F  
6-8 hours at 90°F

Note: Dry time and cure of Wilkothane HS may be accelerated with addition of No. T-22 Accelerator. Caution!! The addition of accelerator will reduce the potlife of an activated coating.

**RECOMMENDED SUBSTRATE:** Steel

**RECOMMENDED PRIMERS:** No.347-40 Wilkopen HS Primer Yellow or No. 342-46 Wilkopen HB Primer Gray

**RECOMMENDED TOPCOATS:** Wilkothane HS

**SURFACE PREPARATION:** Surface must be clean and dry, free of oil, grease, wax or other contaminants. The use of chemical cleaning or pretreatment for steel (e.g., phosphatizing) is highly recommended and will help to improve adhesion and enhance the overall properties of the coating. For most industrial applications, this multi-stage surface preparation is adequate. Clean the parts by mechanical means when coating newly fabricated steel, or if heavy mill scale, rust, or loose paint is present on existing structures. All sharp edges must be rounded and weld splatter removed prior to cleaning. Hand, power tool or SP7 Brush Blast Cleaning will afford the minimum protection. For the maximum protection, dry abrasive blast to a Commercial Blast Finish in accordance with SSPC-SP6. Apply prior to the development of any surface rust. An appropriate primer must be used when coating sandblasted surfaces. Concrete must be cleaned and acid etched.

**APPLICATION METHOD:** Conventional or Airless Spray. May also be brushed or rolled.

#### APPLICATION PROCEDURE:

- Mix pigmented components until uniform, then mix four parts of Part A with one part of No. 050-35 Activator.
- CONVENTIONAL:** Apply only with industrial equipment such as DeVilbiss MBC or JGA spray gun. Any contamination with oil or water will cause short pot life, loss of adhesion, and poor film integrity. A separate air & fluid pressure regulator and a moisture and oil trap in the main supply are recommended.
- AIRLESS:** Use any standard airless spray equipment such as Graco, DeVilbiss, or others that have a 28:1 or higher pump ratio and a fluid tip with a .013 - .017 inch finishing orifice.
- ROLL OR BRUSH:** May be applied by brush as is at 77°F or higher. For roller application, thin up to 10% with No. 44 Thinner. Use a 1/4" nap roller to help minimize air entrapment. Crosscoat to achieve uniform thickness. Do not allow roller to dry out during crosscoating. Apply from seam to seam in a continuous stroke to minimize roller marks.
- Do not apply this coating when surface temperature is less than 5°F above dew point to prevent moisture condensation. For satisfactory cure, air and surface temperatures must be above 50°F for the next 16 hours. Coatings applied at 50°F or lower will not properly cure, and its performance will be adversely affected. Use No. T022 Accelerator at a rate of 1 to 2 ounces per gallon at application temperatures of 70°F or lower. Caution: Addition of No. T022 Accelerator will shorten the potlife to 1-2 hours, less at high temperatures or if mechanical mixers are used.

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**APPLICATION PROCEDURE: (Cont'd)**

6. Thinning not normally required. If necessary to thin for workability, use up to one pint of No.44 Thinner per gallon of activated material. Apply a wet coat in even parallel passes, overlapping each pass 50% to avoid holidays, bare areas and pinholes. If necessary, follow with a second pass at right angles to first. Note: The VOC of the coating will be higher with the addition of solvents. One pint of No. 44 added to an activated gallon will result in VOC of 2.6#/gal, and one quart will result in VOC of 3.05#/gal.
7. Use No. 850-05 Fisheye Eliminator if any pinholing or cratering become evident. For areas that are heavily contaminated with oil, wax or other particulates that cause surface defects, No. 850-10 Anti-Crater may be used at a rate of up to 4 ounces per gallon of material. This should never be used as an alternative to proper surface cleaning prior to the application of the coating.

**CHEMICAL RESISTANCE:**

<b>EXPOSURE</b>	<b>FUME</b>	<b>SPILLAGE</b>
Acid	Good	Excellent
Alkali	Good	Excellent
Salt	Excellent	Excellent
Petroleum Products	Excellent	Excellent
Water	N/A	Excellent
Skydrol	N/A	Good

**PHYSICAL PROPERTIES:**

Impact Resistance (ASTM D2794)	
Direct	80#/sq in
Reverse	40#/sq in
Taber Abrasion	
CS-10 Wheels, 1000 gram weight	
mg loss/1000 cycles	108

**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.

**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.