

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOTHANE HS ALUMINUM GRAY WILKO NO. 722.72

PRODUCT DESCRIPTION: No. 722.72 Wilkothane HS Aluminum Gray is a high solids two component acrylic polyurethane exhibiting excellent gloss retention and chemical 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: Exterior structural finishes, maintenance coating for pipe, tanks and vessels. May also be used for painting of construction equipment and general transportation vehicles (OEM and refinish).

GENERIC TYPE: Acrylic-Aliphatic Polyurethane

COLOR: Aluminum Gray

FINISH: Gloss - 85 degrees minimum

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 722.72 to one volume of No. 050-25 Activator.

POT LIFE: 4 Hours @ 75°F
2 hours @ 85°F
1 hour @ 95°F

Addition of accelerator or high speed mixing will shorten above pot life. Thinning will extend useable pot life. Do not expose mixed paint, hoses or painting equipment to direct sun to prevent premature setting in the line due to elevated temperature.

WEIGHT PER GALLON: 10.2 +.5 lbs (mixed)

VOC: 2.8 lbs (mixed)

SOLIDS BY VOLUME: 60.4 ± 1.0% (mixed)

COVERAGE: @ 2 mil DFT
Theoretical - 485 sq. ft./act gal.
Practical - 388 sq. ft./act. gal.

RECOMMENDED THICKNESS: 2 to 3 mils DFT

NUMBER OF COATS: 1 to 2 recommended

DRYING TIME: To Touch: 2 to 3 hours
@ 77°F To Recoat: 24 hours

THINNER: No. 44 or Retarder No. 145

CLEAN UP THINNER: No. 44 or MEK

TEMPERATURE RESISTANCE: Dry 200°F continuous

FLASH POINT: 722.72: 23° F TCC
050-25: 23° F TCC

APPLICATION METHODS: Conventional or airless spray

RECOMMENDED SUBSTRATE: Steel or Aluminum

RECOMMENDED PRIMERS: No. 342-46 Wilkopon Gray Primer and No. 347-67 Wilkopon HS Red Primer. Wilko No. 349-13 Wilkopon Primer Zinc Rich and other Wilkopon Primers may also be used.

RECOMMENDED TOPCOATS: Wilkothane HS Clear

SURFACE PREPARATION:

General Maintenance:

1. Round off all sharp edges and remove any weld splatter, and remove all rust, mill scale, grease and other Foreign matter
2. For best results, sandblasting to conform with SSPC-SP-10-63T is recommended. Following sandblasting, remove all sand, grit and residue with high-pressure air.
3. Apply coating prior to the development of any surface rust.
4. Over old epoxy or urethane surfaces when blasting is not possible, clean surface of any oil, grease, rust, dirt and loose paint. Sand the old coating to assure proper adhesion

OEM or Other Industrial Applications:

Surface must be clean and dry, free from oil, grease, wax or other contaminants. Use of chemical cleaning or pretreatment (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. If heavy mill scale, rust, or loose paint is present, clean the parts by mechanical means. Hand, power tool, or SP6 Blast Cleaning will afford minimum protection. For maximum protection of steel surfaces, dry abrasive blast pitted rusty areas or loose paint to a Commercial Blast Finish in accordance with SSPC-SP6-63. Apply the primer or coating prior to the development of any surface rust.

APPLICATION PROCEDURE:

1. Mix pigmented components until uniform, then mix four volumes of pigmented component with one volume of Wilkothane Activator No. 050-25 and stir well. If using a mechanical mixer, do not mix for more than 5 minutes, and stop the mixer after this period. Constant mixing will shorten the potlife considerably, especially if an accelerator is used.
2. **CONVENTIONAL SPRAY:** Apply with industrial equipment such as DeVilbiss JGA or Binks 95 or 2001 or Graco Delta XT spray gun with separate air and fluid pressure regulators, and a moisture and oil trap in the main supply are recommended. Contamination with oil and water will result in shortened pot life, loss of adhesion, and poor film integrity.

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APPLICATION PROCEDURE: (cont'd)

3. AIRLESS SPRAY: Standard airless sprays Graco, DeVilbiss, or others with a 28:1 or higher pumps ratio and a .011 to .014 inch fluid tip.

4. Thinning is not normally required. If thinning is necessary 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 required, follow with a spray pass at right angles to the first pass. VOC with additional thinner:

4 oz/gal	3.00
8 oz/gal	3.13
12 oz/gal	3.26
32 oz/gal	3.80

Under hot conditions or where dry spray or orange peel is evident, use a retarder like No. 145 Thinner. It may be blended with No.44 or used solely as needed. Wilko No. 145 will also minimize dry overspray and prevent lap marks.

5. Do not apply coating when surface temperature is less than 5°F above the dew point to prevent moisture condensation. For satisfactory cure, air and surface temperatures must be above 65°F. In cool weather (under 70°F), use Wilko No. T012 to accelerate cure in the amount of 1/2 to 2 ounces per gallon, or use Wilko No. T022 in the amount of 1/4 to 1 ounce per gallon. CAUTION: Potlife will be shorter with the addition of T012 accelerator.

6. Use Wilko No. 850-05 Fisheye Eliminator if pinholing or cratering become evident during use. For areas heavily contaminated with oil, wax or other particulates that cause surface defects, use up to 4 oz. of Wilko No. 850-10 Anti-Crater per activated gallon of paint. This should not ever be used as an alternative to proper surface preparation and cleaning prior to painting.

ALTERNATE PRODUCT: For mildew resistant version of this product use 722.272

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