



WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOTHANE HS YELLOW 13655 HH WILKO NO. 723.655

PRODUCT DESCRIPTION: No. 723.655 Wilkothane HS Yellow is a high solids two component acrylic polyurethane exhibiting excellent gloss retention and chemical resistance.

TYPICAL USES: Exterior structural finishes, maintenance coating for pipes, 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: FSC#13655 Yellow (available in several colors)

FINISH: Gloss - 85 % minimum

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 723.655 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: 9.2 +.5 lbs (mixed)

VOC: 2.95 lbs (mixed)

SOLIDS BY VOLUME: 59.9 ± 1.0% (mixed)

COVERAGE: @ 2 mil DFT
Theoretical - 480 sq. ft./act. gal.
Practical - 384 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: 2- 24 hours

PHYSICAL PROPERTIES:

60 degree gloss meter reading (ASTM D-523), 90 plus
Pencil hardness (ASTM D-3363), H-2H
Adhesion to substrate (ASTM D-3359B), 100% 5B
Flexibility ASTM D-522 3mm
Impact resistance (ASTM D-2794) direct 80-120 lb/in
reverse 40-80 lb/in

TEMPERATURE RESISTANCE: Dry 200°F continuous, can take intermittent spikes of up to 300°F.

FLASH POINT: 723.655: 23° F TCC
050.25: 23° F TCC

RECOMMENDED THINNER: No. 44 or Retarder No. 145 Refer to Section 4 of *Application Procedure*, below, for Thinning Instructions and resulting VOC. No. 38 Fast Dry Thinner may be used in cold weather.

CLEAN UP THINNER: No. 44 or MEK

APPLICATION METHODS: Conventional or airless spray

RECOMMENDED SUBSTRATE: Steel or Aluminum

RECOMMENDED PRIMERS: 702.25 Wilkothane Gray Primer, No. 342.46 Wilkopon Gray Primer and No. 347.67 Wilkopon HS Red Primer. Wilko No. 342.45 Wilkopon Gray or 349.08 Wilkopon Primer Zinc Rich and other Wilkopon Primers may also be used.

RECOMMENDED TOPCOATS: Wilkothane HS colors and clear such as 720.18 Wilkothane HS Clear or 720.29 Wilkothane HS MR Clear.

SURFACE PREPARATION:

General Maintenance:

1. Round off all sharp edges and remove any weld splatter.
2. Remove all rust, mill scale, grease and other foreign matter.
3. For best results, sandblasting to conform to SSPC-SP-10 is recommended.
4. Following sandblasting, remove all sand, grit and residue with high-pressure air.
5. Apply coating prior to the development of any surface rust.
6. 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 application, 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 SP7 Brush 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. Apply the primer or coating prior to the development of any surface rust.

continued on page 2

APPLICATION:

1. Mix pigmented component 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.
2. **CONVENTIONAL SPRAY:** Apply with industrial equipment, such as DeVilbiss JGA and FF fluid tip, 765 air cap, or Binks No. 62, 95, 2100 or 2001 spray gun with a 66 PB nozzle and air cap of 63PR for pressure fed, to 66SK for siphon fed, guns or Graco Delta XT with .055 tip. For pressure fed setup, regulate the tank pressure at 5-10 psi. Atomization pressure should be maintained at 65-75psi. 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.

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.

3. **AIRLESS SPRAY:** Standard airless sprays Graco, DeVilbiss, or others with a 28:1 or higher pump ratio and a .011 to .015 inch fluid tip. Check for pigtails before applying. If pigtail occurs, use a smaller tip, higher pressure, add thinner or a combination of these remedies. Pigtail is an indication of poor atomization that can lead to sagging, low gloss and microfoam formation.
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:

8 oz/gal	2.8 #/gal
32 oz/gal	3.5
45 oz/gal	3.8

Under hot conditions or where dry spray or orange peel is evident, use a retarder like No.101 or No.145 Thinner. They may be blended with No.44 as needed or used solely under hot application temperatures (90° and above). Retarders 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 or low surface temperatures (under 65°F), use Wilko No. T022 to accelerate cure in the amount of ½ to 1 ounce per gallon. CAUTION: Potlife will be shorter with the addition of accelerator.

6. Use Wilko No. 850.05 Fisheye Eliminator if pinholing or cratering becomes evident during use. For areas that are 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.
7. Clear coating: Compatible clear coats such as 720.18 may be applied wet on wet (2-4 hours air drying) over Wilkothane HS coatings, or after an overnight dry as a clear finish coat. Spray a medium coat of the activated clear, allow to tack off, then follow with a full second coat. For mildew resistance, use 720.29 in place of 720.18
8. Compatible clear urethanes such as 720.18 may be added to 723.655 Wilkothane HS and applied as the final coat to improve gloss and color retention. Mix thoroughly up to 25% of activated clear material with activated pigmented base. Reduce up to 25% by volume with No.44 or No. 145 or a combination of the two. Caution: the addition of clear may cause the color of the finish coat to shift. It is important that the same amount of clear coat be added for all the areas that are painted.

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 incidence of exposure.

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.