

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOTHANE HS MINT GREEN WILKO NO. 728.81

PRODUCT DESCRIPTION: No. 728.81 Wilkothane HS Mint Green is a high solids two component acrylic polyurethane exhibiting excellent gloss retention and chemical resistance.

TYPICAL USES: Exterior structural finishes, maintenance coating for pipings, 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: Mint Green (available in several colors)

FINISH: Gloss - 85 degrees minimum

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 728.81 to one volume of No. 050-25 Activator.

POT LIFE: 6 to 8 Hours @ 77oF

WEIGHT PER GALLON: 11.3 +.5 lbs (mixed)

VOC: 2.96 lbs (mixed)

SOLIDS BY VOLUME: 58.5 ± 1.0% (mixed)

COVERAGE: @ 2 mil DFT
Theoretical - 469 sq. ft./act. gal.
Practical - 375 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
@ 77oF *To Recoat:* 24 hours

THINNER: No. 44 or Retarder No. 145

CLEAN UP THINNER: No. 44 or MEK

RECOMMENDED PRIMERS: No. 342-46 Wilkopon Gray Primer, No. 347-67 Wilkopon HS Red Primer, No. 349-13 Wilkopon Primer Zinc Rich and other Wilkopon Primers

TEMPERATURE RESISTANCE: Dry 200oF continuous

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

APPLICATION METHODS: Conventional or airless spray. May also be brushed or rolled in small areas.

FLASH POINT: 728.81: 23o F TCC
050-25: 23o F TCC

RECOMMENDED SUBSTRATE: Steel or Aluminum

RECOMMENDED TOPCOATS: Wilkothane HS colors and 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 with SSPC-SP-10-63T 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 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.
2. *CONVENTIONAL SPRAY:* Apply with industrial equipment such as DeVilbiss MBC or JGA 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.
3. *AIRLESS SPRAY:* Standard airless spray Graco, DeVilbiss, or others with a 28:1 or higher pump 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:

17 oz/gal	3.5
29 oz/gal	3.8
5. Do not apply coating when surface temperature is less than 50F above the dew point to prevent moisture condensation. For satisfactory cure, air and surface temperatures must be above 50oF.
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.

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. equipment such as

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.