

# WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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## WILKOTHANE HS ALUMINUM WILKO NO. 729.935

**PRODUCT DESCRIPTION:** No. 729-935 Wilkothane HS Aluminum is a high solids, high build two component acrylic polyurethane coating that meets environmental VOC regulations when properly used. This material exhibits excellent gloss and color retention during extended service life.

**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:** Leafing Aluminum (available in several colors)

**FINISH:** Gloss - 85 degrees minimum

**COMPONENTS:** Two

**MIXING RATIO:** Four volumes of No. 729.935 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:** 9.3 +.5 lbs (mixed)

**VOC:** 2.7 lbs (mixed)

**SOLIDS BY VOLUME:** 61.4 ± 1.0% (mixed)

**COVERAGE:**@ 1 mil DFT *Theoretical* - 985 sq. ft./act. gal.  
*Practical* - 788 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  
*To Recoat:* within 24 hours  
@ 77°F

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

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

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

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

**APPLICATION METHODS:** Conventional or airless spray

**FLASH POINT:** 729.935: 23° F TCC  
050-25: 23° F TCC

**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 colors and clear. Apply 720.44 Wilkothane HS Clear after allowing 729-935 to air dry to handle (6-8 hours, 24 hours maximum) to prevent smudging and to prevent acid rain blemishes on exposure.

**ALTERNATE PRODUCT:** Use Wilko No. 729-925 or 729.940 for a Non-Smudge Finish with less brightness.

### SURFACE PREPARATION:

#### *General Maintenance:*

1. Round off all sharp edges and remove any weld splatter. Remove all rust, mill scale, grease and other foreign matter.
3. For best results, sandblasting to conform to SSPC-SP-10-63T is recommended. Following sandblasting, remove all sand, grit and residue with high-pressure air. 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.
5. Recoating over aged 729-935: Apply 603-08 Wash Primer or etch with 850-01 Rust Sol prior to recoating.

#### *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

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*SURFACE PREPARATION: (cont'd)*

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. To extend potlife, keep the material cool and out of direct sunlight and add thinner.
2. *CONVENTIONAL SPRAY:* Apply with industrial equipment such as DeVilbiss MBC or JGA or Binks 18, 62 or 2001 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 .013 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:
 

3 oz/gal	2.8
25 oz/gal	3.5
38 oz/gal	3.8
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. T022 to accelerate cure in the amount of ½ to 2 ounces per gallon. CAUTION: Potlife will be shorter with the addition of T022 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.
7. *Topcoating Aluminum Coatings:* This coating must be topcoated within 16 hours @77°F to assure good intercoat adhesion. Applying 720.44 Wilkothane HS Clear will preserve the surface by isolating the aluminum from abrasive forces or chemical attack, and it resists yellowing. Clear coating is recommended in heavy traffic areas or in corrosive environment. If the aluminum coating is allowed to dry for more than 16 hours @77°F (or 8 hours above 85°F), it must be acid etched with 850.01 Rust Sol, or primed with 603-08 Wash Primer then recoated with 729-935 before clear coating. If not properly done, the clear coat may delaminate prematurely. The same procedure must be applied when re-coating old aluminum coatings.

**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.

***For Technical Information call:***

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