

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

POST OFFICE BOX 4089 • 2727 OHIO • PHONE (316)838-4288 • FAX(316)838-6328

SILICONE ZINC RICH PRIMER WILKO NO. 809.01

PRODUCT DESCRIPTION: No.809.01 Silicone Zinc Rich Primer is a two-package primer designed for high temperature service (400-1200°F). It provides excellent corrosion resistance and is the recommended primer for 849.01 Silicone Aluminum.

PRINCIPAL USE: As primer for hot piping, exhaust stacks, mufflers, and vessels operating from 400 to 1200°F. It may also be used to touch up damaged inorganic zinc rich primer used for high temperature applications.

COLOR: Gray (also available in other colors)

FINISH: Flat

COMPONENTS: Two

WEIGHT PER GALLON: 15 ± 1 lbs. (mixed)

VOC: 3.93 lbs./gal. (mixed)

SOLIDS BY VOLUME: 45 ± 1.0% (mixed)

COVERAGE: @ 1 mil dry
Theoretical - 720 square feet per gallon
Practical - 576 square feet per gallon

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

DRYING TIME: @ 77°F
To Touch: 30 to 60 minutes
To Handle: 3 to 4 hours
To Recoat: 3 to 4 hours

May be applied at temperatures as low as 40°F, full cure is achieved upon exposure to temperature of 350°F for 4 hours.

SURFACE PREPARATION:

Repairing Inorganic Zinc Rich Primers: Abrasive blast affected area according to NACE#2 or SSPC-SP10 Near White Metal Blast. Thin 50% and apply thin coats until desired film thickness is achieved. Feather into primer, but do not exceed the maximum DFT of 2 mils over all surfaces.

Direct to Metal: For low temperature applications (350° - 550°F) Surface must be clean and dry, free of oil, grease, wax or other contaminants. The use of chemical cleaning or pretreatment (e.g., phosphating) will help improve the adhesion and will enhance the overall properties of the coating. Consult Wilko representative for temperatures under 350°F.

For high temperatures (350 - 1200 °F), or when coating newly fabricated steel, or if heavy mill scale, rust, or loose paint is present on existing structures, clean the parts by mechanical means. All sharp edges must be rounded and weld splatter must be removed prior to cleaning. Dry abrasive blast to a Near White Blast Finish in accordance with SSPC-SP10 or Nace #2. For maximum protection of steel surface, blast to White Metal according to NACE#1 or SSPC-SP5 if feasible. Apply immediately or prior to development of any surface rust.

RECOMMENDED THINNER: Wilko No. 13 Thinner, No. 3 or No. 100 Retarder

RECOMMENDED FILM THICKNESS: 2 mils dry for maximum for optimum performance and resistance to mudcracking.

RECOMMENDED PRIMER: Apply directly to properly prepared steel surfaces, or use for touch up over inorganic zinc rich primers.

APPLICATION PROCEDURE: May be applied by brush, roller, or spray. Spray application is preferred for film depth consistency and optimum cosmetic value. For conventional or airless spray application, use a set up designed for applying zinc coatings.

MIXING: Stir paint thoroughly until uniform, then slowly sift, under agitation and through a wire screen, 8 lbs of 809.01B Zinc Dust per gal as supplied, mix until smooth and thin as below.

REDUCTION: Below 85 °F: Use Wilko No. 13. Above 85°F: Use Wilko No.100. Do not thin with more than 86 ounces of thinner per gallon of paint to keep VOC below the AIM limit of 5.4#/gal for high temperature coatings. Check local VOC restrictions before using.

Topcoating Zinc Rich Primer: The primer must air dry 2-4 hours, before topcoating with 820- or 840- series silicone coatings. For first coat, apply T/C reduced 50% with No. 1 Thinner, in a full wet tack coat to reduce any pinholing or bubbling. This coat will be rapidly absorbed by the porous zinc film, exhibiting negligible film depth. An hour solvent release period should then be allowed. Follow with a second coat reduced 1/2 to 1 pint No. 1 Thinner at 1.0-1.5 mils DFT. Cure at operating temperature for 4 hours or slowly resume continuous operations.

Preferred procedure: Allow 2-hour solvent release following each coat. Apply heat at operating temperature for at least 4 hours for complete cure.

Weldable Coating: May be used as a weldable coating if applied at thin films (1-2 mils DFT).

Shopcoat applied coating: This coating may be applied at the shop, transported and erected at the site, cleaned, repaired, then topcoated with high heat silicone topcoat. The coating system will cure when the unit is fired and operating temperature of over 400°F is achieved. The topcoat must be applied within 2 weeks, or as long as 30 days as long as it is not exposed to moisture.

RESISTANCE GUIDE: Heat Tolerance: 450°F Dry when used with 820- Modified Silicones, or up to 1200°F when used with 840-series Silicone coatings. This coating exhibit excellent adhesion and topcoat holdout at high temperatures. It surpasses inorganic zinc rich coatings in performance when properly applied. NOTE: At temperatures under 350°F, this coating will remain thermoplastic and may be damaged if scraped. For low temperature zinc rich application, consult Wilko Representative for appropriate recommendations. *Continued on page 2*

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 or wear an air supplied mask to avoid breathing concentrated vapors in enclosed areas. Keep the container closed. For additional safety information, refer to MSDS.