

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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MODIFIED SILICONE ALUMINUM WILKO NO. 829-01

PRODUCT DESCRIPTION: No.829-01 Modified Silicone Aluminum is a single package topcoat with excellent resistance in mild to severe weather exposures - providing outstanding gloss and color retention

TYPICAL USES: As exterior finish for mufflers for construction and general transportation vehicles and as maintenance coatings where fast dry, high gloss, durability and heat resistance of up to 500°F are required.

GENERIC TYPE: Acrylic-Silicone

COLOR: Aluminum

FINISH: Bright

COMPONENTS: One

WEIGHT PER GALLON: 8.0 +. 5 lbs

VOC: 5.05 lbs

SOLIDS BY VOLUME: 30.7 ± 2.0%

COVERAGE: @ 1 mil DFT
Theoretical - 492 sq. ft./gal.
Practical - 394 sq. ft./gal.

RECOMMENDED THICKNESS PER COAT: 2 mils

NUMBER OF COATS: 1 to 2 recommended

TEMPERATURE RESISTANCE: Dry 500°F continuous,
550 °F intermittent

DRYING TIME To Touch: 15-20 minutes
To Handle: 30-40 minutes
Full cure will occur after exposure to high temperature. (2-4 hours at 300-400°F). Also read Resistance Guide.

FLASH POINT: 45° F TCC

APPLICATION METHODS: Conventional or airless spray

THINNER: No. 13 or Retarder No. 100

REDUCTION: Below 85 °F:Use Wilko No. 13
Above 85 °F:Use Wilko No.100

Do not thin with more than 24 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 this product.

CLEAN UP THINNER: No. 13 or MEK

RECOMMENDED SUBSTRATE: Steel

RECOMMENDED PRIMERS: Material may be applied directly to properly cleaned metal. For enhanced corrosion resistance use Wilko No. 859-06 Primer Inorganic Zinc Rich. Do not use organic primers for high temperature applications.

SURFACE PREPARATION:

Over Primers: Must abrasive blast clean to conform to NACE#1 or SSPC-SP5 White Metal Blast prior to application of primer. Refer to Product Data of primer for detailed application procedures.

Direct To Metal: Surface must be clean and dry, free of oil, grease, wax or other contaminants. The use of chemical cleaning or pretreatment (e.g., phosphatizing) will help improve adhesion and enhance overall properties of the coating, and is recommended if no loose paint, mill scale or rust is present and sandblasting is not feasible.

When coating newly fabricated steel, or if heavy mill scale, loose paint, or rust is present, clean parts by mechanical means. All sharp edges must be rounded and weld splatter removed before cleaning. Hand, power tool, or SP6 Blast Cleaning will afford minimum protection. For the maximum protection of steel surfaces, dry abrasive blast to a Commercial Blast Finish to meet SSPC-SP6-63. Apply primer prior to the development of any surface rust

EQUIPMENT REQUIRED:

Conventional Spray:

1. Pressure pot with dual air regulator.
2. Spray gun such as a DeVilbiss MBC with an AV-601 EX fluid tip, 496 DEX needle and 704 or 64 air cap, or Binks No. 18 heavy duty spray gun with a 66 PB nozzle
3. A 25-50 foot length of fluid hose - ½ inch ID minimum.
4. A minimum of 75psi continuous air supply to each spray gun.

Airless Spray:

1. Airless spray equipment with pump ratio of 28:1 or 30:1.
2. Airless spray tip with orifice diameter of 0.015 to 0.019 should be used.

APPLICATION PROCEDURE:

May be applied by brush, roller or spray. Spray application is preferred for production of film depth consistency and optimum cosmetic value. For conventional or airless spray application, use a light material nozzle set-up. Allow 2-hour solvent release following each coat. Apply heat at operating temperature (350°F+) for at least 4 hours for complete cure.

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APPLICATION PROCEDURE: (cont'd)

Topcoating Inorganic Zinc: The primer must exhibit full cure. Refer to product data, No. 859-06. Apply 1 coat No. 829-01 Acrylic Modified Silicone Aluminum 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 8-hour solvent release period should 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 resume continuous operations.

Recoating old 829-01 Finishes: For maximum life of the coating, old finishes must be sandblasted as described in the *Surface Preparation* section. If old finishes must be recoated, ensure that it is tightly adhering film, and it must be sanded, cleaned and then treated with 850-01 Rust Sol to promote intercoat adhesion. Apply a minimal film thickness to avoid delamination.

RESISTANCE GUIDE:

When used with inorganic zinc rich primer the system provides excellent protection for surfaces with medium operational temperatures in mild to severe atmospheric conditions. Inorganic zinc rich primer is also recommended for priming hot surfaces which operate intermittently. **Caution:** Until it is fully cured, this coating be dry to touch at room temperature, but it will remain thermoplastic (soft to touch and susceptible to damage when scraped) at 150°F or higher temperature (Refer to Drying Time). Do not use if the temperature will not reach the full cure schedule – consult a Wilko representative for advise on the type of coating to use in your specific application.

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.