

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON EPOXY MASTIC

PRODUCT DESCRIPTION: Wilkopon Epoxy Mastic line is a two-component rust inhibitive epoxy polyamide coating that is designed for direct application to metals following the removal of loose rust and scale. It is an ideal coating in areas where sandblasting is not feasible or is impractical.

PRINCIPAL USE: Recommended coating on all structural steel, exterior of storage tanks and miscellaneous equipment in chemical and refinery facilities. It is suitable as interior lining for non-potable water tanks.

COLORS: 331.15 White, 336.26 Black, 332.54 Pearl Gray, 339.03 Aluminum, 332.48 Aluminum Gray, and other colors).

FINISH: Semi-Gloss

COMPONENTS: Two

MIXING RATIO: Equal volumes of Wilkopon Mastic Part A and Activator Part B (For cool weather use Part C Activator)

POT LIFE: With Part B Activator: 4 to 6 hours @ 77°F
With Part C Activator: 2 to 4 hours @ 65°F

WEIGHT PER GALLON: With Part B: 12 ± 1 lbs (mixed)
With Part C: 12 ± 1 lbs

VOC: (mixed) With Part B: 1.30 lbs/gal
With Part C: 2.25 lbs/gal

SOLIDS BY VOLUME: With Part B 82.0 ± 1.0% (mixed)
With Part C 69.0 ± 1.0%

COVERAGE: @ 1 mil DFT W/Part B W/Part C
Theoretical sq. ft./act. gal. - 1300-1400 1100-1200
Practical sq. ft./act. gal. - 1040-1120 880-960

RECOMMENDED DRY FILM PER COAT: 5-10 mils

DRYING TIME: @ 77°F W/Part B W/Part C
TO TOUCH: 4 to 6 hours 2 to 4 hours
TO RECOAT: 6 to 24 hours 4 to 72 hours

THINNER: Use Wilko No. 1, No. 13 or No. 100 Thinner. Use No. 71 Thinner for maximum pot life or when Part C is used. NOTE: Do not use No. 71 if recoating old alkyd paint.

CLEAN UP THINNER: No. 71 and MEK are recommended. No. 1 or No. 13 may also be used at early stages, however, they may not thoroughly clean the equipment.

RECOMMENDED PRIMERS: May be applied DTM. For additional corrosion resistance, use Wilkopon Primer Nos. 349.08, 349.10 or 349.13 Zinc Rich Epoxy Primer. Nos. 347.40 Beige, 342.46 Gray or 347.67 Red Primer may also be used.

TEMPERATURE RESISTANCE: 200°F continuous, dry

RECOMMENDED SUBSTRATE: Steel or concrete

RECOMMENDED TOPCOAT: Topcoat with Wilkopon Epoxy or Wilkothane G or HS Polyurethane coatings only. Epoxy is recommended for corrosion resistance, while polyurethane is recommended for maximum gloss retention.

SURFACE PREPARATION: 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. This multi-stage surface preparation is adequate for most industrial applications, and is highly recommended.

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. Hand, power tool or SP6 Blast Cleaning will afford minimum protection. For maximum protection of steel surface, dry abrasive blast to a Commercial Blast Finish in accordance with SSPC-SP6-63. Apply prior to the development of surface rust, usually within 8 hours or less especially in humid conditions.

EQUIPMENT REQUIRED:

Conventional Spray:

1. A material pressure pot with dual regulation.
2. Spray gun such as DeVilbiss MBC with an AV-601 EX fluid tip, 496 DEX needle and a 704 or 64 air cap. As an alternate, a Binks 2001 or No. 18 heavy duty sprays gun with a 66 PB nozzle.
3. A 25-50 foot length of fluid hose - ½ inch ID minimum, 5/8 inch preferable.
4. A 25 - 50 foot length of air hose - ½ inch ID minimum, 5/8 inch preferable.
5. Minimum of 75 PSI continuous air supply to each spray gun, 100 psi preferable.

Airless Spray:

1. Airless spray equipment with pump ratio of 28:1 or 30:1.
2. Airless spray tip with orifice diameter of 0.017 or larger must be used.
3. Air supply that delivers at least 100 psi is recommended.

APPLICATION PROCEDURE:

Airless spray is recommended for maximum film build.

1. Separately mix the base and activator components until uniform, then mix equal volumes of the base and Part B Activator. Allow mixture to stand for at least 30 minutes before using. For cool temperature application (40-70°) use Part C instead of Part B. Do not use Part C if ambient temperature is above 70°F.

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APPLICATION PROCEDURE:(Cont'd)

2. **REDUCTION:** Caution: Any thinner added will raise the VOC of the coating. Do not thin with more than 101 ounces of No.71 Thinner per gallon of material activated with Part B to keep VOC below 3.8#/gal (63 oz. when activated with Part C). Check local VOC restrictions before thinning.

Conventional Spray: Thin up to 25% with appropriate thinner (refer to previous section for recommended thinner).

Airless Spray- May be applied without thinning at 70-85°F. In cooler temperatures, or with smaller airless units, thin up to 10% with appropriate thinner.

3. *Spray:* Apply one tack coat and follow with one full wet coat. Hold the spray gun 8-10 inches from the surface and overlap each pass 25% to avoid holidays.

4. If the ambient temperature exceeds 85°F, reduce with Wilko No. 101 to avoid dry spray. Do not apply when the surface temperature is less than 5° above the dew point. Do not use below 40°F.

5. *Brush or Roller:* Thin activated material until workable for roller or brush application. This method of application is recommended for maximum adhesion over marginally prepared or if surface condensation is present. Work the brush or roller into the surface in such a way that the surface contaminant is worked into the coating, and in the case of moisture, the brushing action will push the water aside to allow coating to come into contact with the substrate. CAUTION: Do not apply if heavy condensation is present. See Wilko Rep for more information on application over these surfaces.

6. Following are recommended cure schedule using Part C Activator:

Splash & Spillage		Immersion
<i>Temperature</i>	<i>Cure Time</i>	<i>Cure Time</i>
50°F	7 days	14 days
60°F	3 days	7 days
70°F	2 days	4 days
80°F	40 hours	3 days
90°F	32 hours	2 days
100°F	24 hours	2 days

The above times are doubled if using Part B Activator. NOTE: Part B activator is not recommended at 65° or lower temperature.

7. For immersion service, use Part B and apply two coats for a total of 20 mils.

PHYSICAL PROPERTIES:

Substrate - Sandblasted Steel	DFT	Result
Adhesion, ASTM D3359	2 mils	5A
Pencil Hardness, ASTM D3363	4 mils	4H+
Abrasion, ASTM D4060	4 mils	80 mg loss
1000 gm load on CS17 wheel		
Salt Fog, ASTM B117	10 mils	2000 hrs
Gloss, ASTM D523, 60°	4 mils	70

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.