

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON PRIMER GRAY WILKO NO. 342.45

PRODUCT DESCRIPTION: No. 342.45 Wilkopon Primer Gray is a two component epoxy polyamide primer that has good corrosion and chemical resistance as well as early recoat properties. It has excellent sanding and filling properties, which makes it ideal for refinishing surfaces that have been previously coated with epoxies and urethanes. Has excellent adhesion to a wide variety of substrates including concrete, treated galvanized & stainless steel, etched aluminum, and fiberglass filled polyester plastics.

PRINCIPAL USE: Recommended as coating for steel and concrete surfaces that require chemical and corrosion resistance. Ideal as a primer for transportation vehicles when topcoated with urethanes. This primer has good adhesion to clean (or sanded) old epoxy and urethane paint, which makes it an ideal sealer over such coatings for recoating with urethanes.

COLOR: Gray

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 342.45 to one volume of No. 342.45B Activator. For cool weather applications (50-70°F), use 342.45C Wilkopon Cool Weather Activator. Do not use 342.45C if the VOC restriction is 3.5#/gal.

PHYSICAL PROPERTIES: with 342.45B: with 342.45C:

POT LIFE: @ 77°F 6-8 hrs 3-4 hrs.

WEIGHT PER GALLON: 11.2 ± 5 lbs. 11.2 ± 5 lbs

VOC: 3.3 lbs. 3.6 lbs.

SOLIDS BY VOLUME: 50 ± 1.0% 44.6 ± 1.0%

COVERAGE: sq. ft per gal @ 1 mil dry
Theoretical - 802 715
Practical - 642 572

DRYING TIME: @ 77°F
To Touch: 1 to 2 hours 15 to 30 min
To handle: 6 to 8 hours 2 to 4 hours
To Recoat: 0 min - 72 hr 30 min - 72 hr.
After 72 hours, scuff sand surface before topcoating. May be wet sanded in 6 hours.

FLASH POINT: 342.45 Part A: 1°F TCC
Part B: 45°F TCC
Part C: 1°F TCC

RECOMMENDED DFT PER COAT: 2-3 Mils

CLEAN UP THINNER: No. 71 or MEK

RECOMMENDED APPLICATION: May be applied by brush or roller, or conventional or airless spray.

TEMPERATURE RESISTANCE: 200°F continuous, 250°F dry

RECOMMENDED THINNER: Wilko No. 71 or Wilko No. 44. Use No. 71 for temperatures above 90 °F. Do not add more than 8 ounces of No. 71 Thinner to one gallon of material activated with 342.45B to keep VOC below 3.5#/gal. For VOC restriction of 3.8#/gal, up to 21 ounces of No. 71 may be used.

RECOMMENDED PRIMER: May be used as intermediate coat over Zinc Rich Primers such as Wilko No. 349-08 and No. 859-06.

RECOMMENDED TOPCOATS: Urethanes, Epoxy Enamels and Vinyls. May also be topcoated with Alkyd Enamels if done within 6 hours.

RECOMMENDED SUBSTRATE: Steel

SURFACE PREPARATION:

Steel: Surface must be clean and dry, free of oil, grease, wax and other contaminants. Use of chemical cleaning and pretreatment (e.g., phosphatizing) is highly recommended and will help improve the adhesion and will help enhance the overall properties of the coating. If heavy mill scale, rust or loose paint is present, clean parts by a mechanical means. Hand, power tool or SP7 Brush Blast Cleaning will afford minimum protection. For the maximum protection of steel surfaces, dry abrasive blast to Commercial Blast Finish in accordance with SSPC-SP6. Apply the primer or coating prior to the development of surface rust.

Fiberglass Plastics: Solvent wipe surface using MEK or a wax remover. Scuff sand the surface using #320 or #200 grit sandpaper, then apply light tack coat and let it flash 15-20 minutes before applying a full coat. If any pinholes or craters are evident, use No. 850-10 Anti-Crater Additive at a rate of 2-4 ounces per gallon.

New Concrete: New concrete must cure for a minimum of 30 days prior to coating. After this period the only surface preparation necessary is etching. This can be accomplished with an acid solution. After applying acid the reaction residues must be removed by using fresh water and a squeegee. Allow floor to dry thoroughly, sweep or vacuum to remove any/all powdery residue, and apply first coat of material. NOTE: Refer to "Coating Concrete" Brochure for more in-depth surface preparation.

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APPLICATION PROCEDURE:

1. Mix the pigmented component, No. 342.45, until uniform, and then mix four volumes with one volume of No.342.45B Activator (or 342.45C for cool weather application). Allow the mixed material to stand for 30 minutes before applying. To prevent any craters, fisheyes, or crawling when used over fiberglass reinforced plastics, add 2 ounces of No. 850-10 or No. 850-05 per gallon of material.

2. *CONVENTIONAL SPRAY:* Apply with industrial equipment, such as DeVilbiss MBC or JGA spray gun with No. 78 or 765 Air cap, E fluid tip and needle, or Binks 18 or 62 spray gun, and a pressure pot with mechanical agitator. A moisture and oil trap in the main air supply line is required. Thin with up to 1 quart of No.71 Thinner per activated gallon.

3. *AIRLESS SPRAY:* Any standard airless spray equipment, such as Graco Bulldog Hydra-Spray or larger, with a .013 - .017 inch fluid tip is recommended. If thinning is necessary, use No. 71 Thinner.

4. *BRUSH OR ROLLER:* For concrete walls and floors, brush or roller application is preferred to assure coverage of porous surfaces.

5. Do not apply when surface temperature is less than 5° above dew point to prevent moisture condensation. For satisfactory cure, air and surface temperatures must
Be above 50°F.

6. Apply wet coat in even parallel passes, overlapping each pass 50% to avoid any holidays, bare areas and/or pinholes. If necessary, follow with a spray pass at right angles to the first pass.

7. Topcoating with Alkyds: This primer may be topcoated with alkyd enamels provided that it is recoated within 4 to 6 hours. For critical applications, check the adhesion of individual topcoats before proceeding with the whole job. Use No. 71 Thinner for topcoat, and check for lifting or strike-in (loss of gloss). Additional adhesion and DOI may be achieved if the primer is wet-sanded with No.400 sandpaper after four hours' drying.

8. *Film Thickness:* This primer may be applied at higher film thickness to fill imperfections, provided that each coat is allowed to dry, and that the coating is not to be subjected to applications where thermal stress will be encountered (sudden change in temperature in a short period). If each coat is not allowed to dry, solvent may get trapped in the film, resulting to failures like mudcracking or alligatoring. On film thickness of between 6-12 mils, check for pencil hardness after 48-72 hours. If the film is hard to touch but appears gummy after the film is broken, solvent may be trapped in the film, and topcoating it is not recommended until the film is completely hard (pencil hardness of H or better). Do not topcoat if mudcracking is evident - sandblast and re-prime when this occurs.

9. Clean the equipment with No. 71 Thinner immediately after use.

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 exposure incidents.

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.