



## **COATING RECOMMENDATIONS**

*With Attached Product Data*  
**Coating System No. 24**

**For:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**Prepared By:**

**WILKO PAINT, INC.**

### **SURFACE DESCRIPTION**

Typically used for new facility piping under 250° F (meter runs, regulator runs, valves, above ground appurtenances, and other natural gas facilities which do not exceed 250° F).

### **COATING SYSTEM**

An inorganic zinc-rich primer, an HS epoxy intermediate coat and a two-component HS acrylic polyurethane topcoat.

### **SURFACE PREPARATION**

Remove dirt, oil, grease and other surface contaminants. Round off sharp edges and remove weld splatter. Abrasive blast clean to N.A.C.E. #2 Near White Metal Blast. Use 16-40 mesh abrasive to produce 1.0 to 2.0 mil surface profile.

### **PRIME COAT**

**Product**  
**No. Coats**  
**Application**  
**Dry Film Thickness**  
**Wet Film Thickness**

859.06 Inorganic Zinc-Rich Primer  
One  
Conventional Air Spray  
2-3 mils above surface profile  
3-5 mils above surface profile

### **INTERMEDIATE COAT**

**Product**  
**No. Coats**  
**Application**  
**Dry Film Thickness**  
**Wet Film Thickness**

342.46 Wilkupon HS Recoatable Primer Gray or  
347.67 Wilkupon HS Recoatable Primer Red  
One  
Brush, roller or spray  
1.5-2.0 mils  
4.0-5.0 mils

### **TOP COAT**

**Product**  
**No. Coats**  
**Application**  
**Dry Film Thickness**  
**Wet Film Thickness**

721.52 Wilkothane HS White (colors)  
One to two  
Brush, roller or spray  
1.5-2.0 mils  
3.5-5.0 mils

- REMARKS:**
1. See Technical Data Sheets for mixing instructions.
  2. If mold/mildew is a problem, use 721.104 Wilkothane HS MR in place of 721.52
  3. Add 1-2 ounces of T022 per gallon of mixed material of 721.52 Wilkothane HS to compensate for cold temperatures. Caution: the addition of T022 will shorten pot life of mixed material especially in hot weather.
  4. Use 342.46C or 347.67C Activator if the ambient or surface temperature is below 70°F.

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### **ADDITIONAL INFORMATION**

**Application of Zinc Rich Coatings:** Use conventional spray equipment with agitator-equipped paint pots for applying zinc rich coatings. Zinc rich materials tend to pack in the pump and settle in the lines in airless spray equipment. Avoid film build in excess of recommendations. Inorganic zinc-rich materials may mud crack if applied in exorbitant film thickness. Apply a wet coat and avoid dusting to minimize bubbling when topcoated.

### **Applied Zinc-Rich Primer Surface Preparation**

The following instructions address the treatment and preparation of zinc primers prior to application of topcoats. 859.06 Inorganic Zinc Rich must be fully cured before topcoating.

1. Using aluminum screen, lightly rub areas where zinc dust overspray has embedded in the cured film. These areas are manifested by a rough, sandpaper-like texture. Screen the area to a smooth feel, avoiding excessive removal of zinc.
2. Following the above operation, remove residual dust from the entire surface with a stiff bristle brush. Do not use wire brush!
3. If the operation does not effectively remove the dusty residue, apply a moderate pressure water wash. Do not use excessive pressure to avoid stripping the zinc coating.
4. If water wash is used, allow adequate drying time prior to topcoat application.
5. If the zinc film is inorganic, test for cure by lightly rubbing the surface with an MEK (methyl ethyl ketone) saturated rag. If solubilization or removal is not evident, the primer is adequately cured for top coating. This procedure is not recommended for organic zinc rich primers (Wilkopon #349.10) or silicone zinc rich primers (809-01). The cure of 859.06 Inorganic Zinc Rich Primer is accelerated by the presence of moisture. The cure time is therefore faster in humid areas and slower in arid areas.
6. Do not recoat inorganic zinc with inorganic zinc. If repair is necessary, either spot blast and recoat, or use organic zinc rich for spot repairs (for non-high heat application).
7. Generally, the recoat interval of topcoat to zinc primers may be extended over a great length of time. After lengthy exposure, however, surface contamination and white rust may develop requiring a pre cleaning operation before topcoating.

### **Application Notes**

1. Refer to technical data sheets on 859.06 Inorganic Zinc Rich Primer, 342.46 or 347-67 Red Oxide Primer, and 721.52 Wilkothane HS White topcoat.
2. Topcoating uncured inorganic zinc rich primer may produce bubbling and pinholing in the initial coat. To counteract, reduce the intermediate coat 50% with the recommended thinner and apply a wet tack coat. The low viscosity of the tack coat will be absorbed in the porous film, displacing entrapped air. The film depth of the properly applied tack coat will be minimal. Allow the solvent in the tack coat to fully evaporate before applying the normal-strength intermediate coat.
3. Multiple passes with the spray gun may be required to produce recommended film thickness of topcoats. The interval between passes may require extended time when applying at low surface or atmospheric temperatures

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