



## **COATING RECOMMENDATIONS**

*With Attached Product Data*

### **Coating System No. 3**

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

**Prepared By:** **WILKO PAINT, INC.**

**SURFACE DESCRIPTION** Exterior above ground steel structures, piping, vessels, tanks, towers, or process facilities operating to 250° F continuous, 275° F intermittent

**COATING SYSTEM** An organic zinc-rich primer, HS epoxy intermediate coat and two-component 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. For more information refer to "APPLICATION AND INSPECTION" towards the end of this catalog

**PRIME COAT**  
**Product** 349.10 Wilkopon Organic Zinc-Rich Primer. Or 349.13 Wilkopon Organic Zinc-Rich Primer One.  
**No. Coats**  
**Application** Conventional air or airless spray.  
**Dry Film Thickness** 2.0-3.0 mils above surface profile.  
**Wet Film Thickness** 5.0-7.5 mils above surface profile.

**INTERMEDIATE COAT**  
**Product** 347.67 Wilkopon HS Recoatable Primer Red  
**No. Coats** One.  
**Application** Brush, roller or spray.  
**Dry Film Thickness** 1.5-2.0 mils.  
**Wet Film Thickness** 4.0-5.0 mils.

**TOP COAT**  
**Product** 721.52 Wilkothane HS White (colors).  
**No. Coats** Two.  
**Application** Brush, roller or spray.  
**Dry Film Thickness** 2.5-3.0 mils.  
**Wet Film Thickness** 3.5-5.0 mils.

- REMARKS:**
1. See Technical Data Sheets for mixing instructions.
  2. If mold/mildew is a problem, use 721.104 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 347.46C or 347.67C Activator if the ambient or surface temperature is below 70°



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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 – it may mud crack if applied in exorbitant film thickness. Apply a wet coat and avoid dusting to minimize bubbling when topcoated.

**Wet on Wet Application:** Allow 349.10 or 349.13 Wilkopon Zinc Rich Primer to air dry for 2-4 hours for the solvent to evaporate before topcoating. If excessive dusting of the zinc is evident, wipe off very lightly with a lint free or tack cloth before applying the topcoat.. Apply a tack coat and allow to air dry 30 minutes prior to applying a full coat. If there is excessive dusting, it is best to allow it to cure for 24 hours and follow the procedure in the next section below

#### **Cured Wilkopon Zinc-Rich Primer Surface Preparation**

The following instructions address the treatment and preparation of cured 349.10 or 349.13 Wilkopon Zinc Rich Primers prior to application of topcoats.

1. Using aluminum screen, lightly rub areas where zinc dust overspray has embedded in the cured film. This 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 if the primer has dried to an MEK-resistant stage. 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. Do not recoat Wilkopon Zinc Rich Primer with inorganic zinc. If repair is necessary, either spot blast and recoat, or use organic zinc rich for spot repairs.
6. Generally, the recoat interval of topcoat to zinc primers may be extended over a great length of time if an intermediate coat of epoxy is used. 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 349.10 or 349.13 Wilkopon Zinc Rich Primer, 347-67 Red Oxide Primer, and 721.52 Wilkothane HS White topcoat (or other colors).
2. Topcoating zinc rich primer may produce bubbling and pinholing in the initial coat. To counteract, reduce the intermediate primer 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. The tack coat can also be allowed to dry overnight before applying a full 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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