

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON HS PRIMER ZINC RICH WILKO NO. 349.08

PRODUCT DESCRIPTION: No. 349.08 Wilkopon HS Primer Zinc Rich is a two component epoxy polyamide coating. It provides excellent protection in chemical spillage areas.

PRINCIPAL USE: Recommended as a primer coating on exterior of storage tanks, structural steel and miscellaneous equipment in chemical and refinery facilities. It is an ideal primer for three coat system consisting of zinc rich primer, epoxy intermediate coat, and polyurethane topcoats.

COLOR: Gray

GENERIC TYPE: Epoxy-Polyamide

FINISH: Flat

COMPONENTS: Two

MIXING RATIO: Four gal of 349.08 to one gal 349.08B or 8 gallons of 349.08 to one gal of 349.08C (cool weather) Activator

POT LIFE:	with 349.08B	349.08C
	°F/°C Activator	Activator
	40/0 N/R	N/R
	50/10 N/R	8 hrs
	70/20 12 hrs	6 hrs
	90/32 6 hrs	N/R
	N/R = Not Recommended	

WEIGHT PER GALLON: 21 ±.5 lbs activated

VOC: pounds/activated gallon
w/349.08B: 3.97
w/349.08C: 4.02

SOLIDS BY VOLUME: w/349.08B: 44.4 ±1 % activated
w/349.08C: 43.4 ±1 % activated

COVERAGE: sq. ft./act. gal. @ 1 mil DFT

	w/349.08B:	w/349.08C:
Theoretical -	712	697
Practical -	570	557

RECOMMENDED DRY FILM PER COAT: 2-3 mils

NUMBER OF COATS: 1 to 2 recommended

RECOMMENDED SUBSTRATE: Steel

TEMPERATURE RESISTANCE: 200°F continuous
250°F intermittent

RECOMMENDED PRIMER: Apply directly to properly cleaned metal. For additional corrosion resistance use a chemical pretreatment.

DRYING TIME:

	w/349.08B Activator		w/349.08C Activator	
°F/°C*	To Touch	To Recoat	To Touch	To Recoat
32/0	N/R	N/R	N/R	N/R
50/10	N/R	N/R	4 hrs	6 hrs
68/20	2 hrs	8 hrs	2 hrs	2 hrs
90/32	1 hr	4 hrs	N/R	N/R

*Surface and air temperatures N/R-Not recommended

RECOMMENDED THINNER: Use Wilko 71 or No. 44 Thinner. Use No. 71 for maximum pot life or if 349.08C is used. Use the following guidelines for VOC of material after thinner is added (in ounces) to activated gallon to limit VOC to 4.2#/gal :

Thinner Added	with 349.08B	349.08C
No. 44	8	12
No. 71	10	14

RECOMMENDED TOPCOATS: Use only epoxy intermediate coats or topcoats. May be recoated with epoxies or itself after 2 hours. Recoat within 72 hours

CLEAN UP THINNER: No. 71 or MEK

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., phosphatizing) will help improve adhesion and enhance overall properties of the coating. This multi-stage surface preparation is highly recommended and will be adequate for most industrial applications.

When coating newly fabricated steel, or if heavy mill scale, loose paint, or rust is present, clean parts by a 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.

APPLICATION: Airless spray with a high-volume output pump and a tip of 19 or is recommended for maximum film build

EQUIPMENT REQUIRED: As recommended or equal
Conventional: DeVilbiss MBC-510 gun with heavy mastic spring, an E tip and a 704 air cap, or Binks 18, 62, or 69 gun with a 66 nozzle and no more than 25 feet of 1/2" ID material hose. A variable speed agitator in the pressure pot and an oil and moisture trap in the main air supply line are essential. Also, separate air and fluid pressure regulators are recommended.
Airless: A Graco Bulldog 30:1, a Speedflo Alaskan PZ, or equivalent designed for zinc applications. Teflon packing is recommended for reliable pump operation. Use a fluid tip with a .017 inch orifice or larger and 1800-3000 psi fluid pressure. Use a variable speed mixer to keep the primer uniformly blended.

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APPLICATION PROCEDURE:

CAUTION - To insure against the loss of, or damage to spray equipment, do not allow any material to remain in pot, pump or fluid lines when unit is not operating, except for brief periods. When an operation interruption is necessary, immediately purge the equipment of material to prevent any "zinc packing" and/or setting up of the activated material. Caution should be observed if No.349.08C (Cool Weather Activator) is used due to the short pot life.

1. Separately mix No. 349.08 Part A (Base) and No. 349.08B or 349.08C (Activator) components until uniform, then mix 4 volumes of base and one volume of 349.08B Activator or 8 volumes of base to one volume of 349.08C. Allow mixture to stand for 30 minutes if No.349.08B is used, (5 minutes if No. 349.08C is used), before using.
2. **TECHNIQUE:** Properly adapted equipment for application of organic zinc is of the utmost importance. (see "Equipment" above). Optimum galvanic functionality of the zinc filler is accomplished by the uniform deposition of the total amount of zinc filler. Settling of the heavy particulates in the spray container will cause an imbalance of the formulation and will adversely affect performance, illustrating the need for the suspension of the zinc by frequent agitation during the application process. The applicator must deposit the atomized material as a wet film (wetness is observed briefly at high ambient temperatures) to minimize dry spray and excessive dissipation of the vehicle between nozzle and surface. Loose powder, observed by the naked eye or easily brushed off with bare hands, is an indication of improperly thinned and/or applied primer and may result in difficulty with the application of the topcoat and an early system failure. At higher temperatures (over 75°F) or under windy conditions, adjust spray equipment and/or add additional No. 37 until a wet film can be deposited at the proper film thickness. Multiple passes with spray apparatus may be necessary to get the recommended film depth, especially with conventional equipment. A wet film gauge is useful in determining the approximate dry film depth of organic zinc if used as follows: After film has set for an hour or so, as indicated by dry flat surface conditions from solvent loss, place gauge firmly on flat surface, move in scratching motion until bare metal is contacted. The imprint left by the graduated prongs indicates the approximate depth of the uncured film. Due to the high solids content and the puffy and porous nature of the coating, the reading obtained is a reasonably accurate dry film measurement of the cured organic zinc. With this type of high solids primer, minimal shrinkage will occur during completion of the cure after all the solvents have evaporated.
3. **REDUCTION:** Because of the differences in painting conditions, equipment and application techniques, adjustments in the amount of thinner used may be necessary.
Conventional and Airless Spray: May be applied without thinning. VOC will stay within 2.8 #/gal with the addition of up to 5% of appropriate thinner. **CAUTION-** Zinc will settle rapidly due to its heavy weight, and over thinning will make zinc settle faster.
4. If the ambient temperature exceeds 85°F, reduce with No. 101 Thinner to avoid any dry overspray. Do not apply when surface temperature is less than 5°F above dew point.

5. Allow coating to cure 3-5 days at 65 - 80°F before placing into service

NOTE: The schedule for painting must be planned to include the application of material early enough to provide for at least partial cure prior to lower night time temperatures and the possibility of dew point conditions. Curing rates are accelerated by heat and are retarded by lower temperatures. Drying rates are based on 75°F. As a rule of thumb, for every 18° above 75°F, the curing rate will accelerate by approximately 100%. For every 18° below 75°F, curing rate is retarded by approximately 100%. The premature failure of fine coating systems is often experienced because of failure to acknowledge the facts related to low temperature application.

6. *Coating Organic Zinc Rich Primer:* The porous nature of zinc often causes pinholes or bubbling of the Intermediate (Tie) Coat. To eliminate bubbling of the first coat, apply a wet mist coat over surface area, allowing a short interval for solvent to escape. Follow with full wet coat, or apply a tie coat, which has been reduced by 50% or more. This Tie Coat will penetrate the porous structure displacing trapped air and providing a sealed substrate for succeeding topcoat. Tie Coat should be applied to provide 3.0-5.0 mils dry film, depending on the topcoat and exposure.

RESISTANCE GUIDE:

Water: Excellent resistance to fresh, salt and seawater.

Salt: Resists spillage and splash by most alkaline salt solutions in atmospheric exposures at temperatures up to 200°F.

Alkali: Resists temporary exposure to fumes splash and/or spillage of concentrated solutions at temperatures up to 150°F.

Acid: Resists fumes of non-oxidizing acids.

Alcohol: Accepts the spillage of isopropyl, ethyl and butyl alcohols.

Petroleum Distillate: Resists splash and/or spillage of gasoline, sour crude, diesel fuel, jet fuel and lubricating oil.

Adhesion: Excellent to properly prepared steel or zinc rich coated surfaces.

Weather Exposure: Will not check, crack or craze after long or severe exposure.

Chalking: Early surface chalking will occur under exterior exposure, and is a condition inherent with polyamide or amine catalyzed epoxy coatings.

ALTERNATE PRODUCTS: Wilkopen Zinc Rich Primer Nos. 349.10, 349.13 and 349.23. 349.13 is a higher solids, lower VOC version. The 349.23 is a 3-component version that has the same solids and properties as the 349.13.

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.