

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

POST OFFICE BOX 4089 • 2727 OHIO • PHONE (316)838-4288 • FAX(316)838-6328

RECOATING STRUCTURES PREVIOUSLY PAINTED WITH EPOXY/URETHANE

APPLICATION: Above Ground Exterior Structural Steel, Piping, Valves, (Etc.) Below 250°F, In All Atmospheres.

1. When used properly, Epoxy/Urethane Systems provide excellent gloss and color retention, as well as excellent chemical, moisture, ultraviolet (UV), and abrasion resistance. Service life expectancy of the finished Epoxy/Urethane coating can be as much as 10+ years in a normal exposure environment with application over a blast cleaned surface. Wilkopon HS Epoxy/Wilkothane HS Urethane is Volatile Organic Compound (VOC) compliant system.
2. Surfaces that are previously painted with epoxy urethane may be touched up, or recoated with an epoxy/urethane system, as long as the old coating is tightly adhering and proper recoat procedure is followed. Service life expectancy of properly recoated system can be as long as or longer than the original system. It will renew the overall appearance of the existing coating system to a like new finish, and can last for 10-15 years or more, depending on exposure conditions. *

PROCEDURE:

1. **ADHESION TEST PROCEDURE ON EXISTING/AGED COATING SURFACES-** Utilizing a very sharp knife or razor blade (box cutter) make 6 to 11 horizontal cuts approximately 1" in length spaced approximately 1/16" apart. Overlapping the horizontal cuts make 6 to 11 parallel cuts approximately 1 to 1½ "in length approximately 1/16" apart. The overall appearance of this test area should be in a tic tac toe pattern (or pound sign #). On top of the cut/scribed surface place a piece of duct tape (adhesive side down) to effectively cover the entire scribed surface. Rub the top of the tape thoroughly with a blunt object to ensure that the tape is adequately adhered to the scribed surface. After approximately one minute quickly remove the duct tape from surface beginning with one corner of the tape. If more than 10% of the existing paint was removed with the tape then **all of the existing paint surface must be removed** prior to painting due to poor coating adhesion. If less than 10% of the existing coating is removed then the existing coating may be repaired/over coated. *Large structures must have multiple adhesions test performed in varying areas.*
2. **WASH SURFACE** – Prior to any other surface preparation, the structure to be painted must be water washed with a solution of Trisodium Phosphate (TSP) such as "Spic & Span" to remove surface contamination. High-pressure water wash/spray is the most desirable where applicable or allowed. Rinse thoroughly after washing and let dry before blast cleaning or other methods of surface preparation.
3. **PREPARE SURFACE** – Structure must be inspected for visible failures like rusting, chalking or scaling. Paint scales and rust must be removed using a sander. Feather edge –sand damaged area to obtain an acceptable appearance. If the entire surface is heavily chalked, sand the entire area and re-wash. Slight chalking is acceptable as long as an epoxy sealer is used.
4. **PRIME SURFACE** - Apply one prime coat of 342.46 or 347.67 two component Epoxy paint, which has a volume solids content of 65%, to a minimum dry film thickness of 4 mils, over bare areas. Use the application procedures that may be feasible, which may be by brush, roller, or spray application. Seal the entire surface with the above primer, applying at least 1 mil. Allow to dry overnight before topcoating. Alternatively, 342.22 Wilkopon Primer may be used as a sealer for fast recoat time of 30 minutes.
5. **TOPCOAT:** Top coat with Wilkothane HS two component urethane, which has a volume solids content of 60%, to a minimum dry film thickness of 3 mils. Apply 720.18 Wilkothane HS clear coat for added protection. **
6. **ALTERNATE RENEWAL OF OLD COATING:** Aged epoxy/urethane systems have successfully been recoated without the application of an epoxy sealer provided that the surface is free of chalking and surface contaminants, which may cause adhesion failure and application problems like cratering or fisheye (the use of an epoxy sealer will minimize or eliminate these problems). Steps 1-3 above must be followed. An example of recoating procedure is as follows: Finish Coat: Apply one coat of Wilko 720 Series HS Polyurethane Color as directed on technical data sheets to spot primed areas. Mix 1 quart of Wilko #720-18 HS Clear with three quarts of Wilko 720 Series HS Polyurethane Color, add one quart of Wilko #050-25 HS polyurethane activator. Apply Polyurethane at 3 mils dry Film Thickness.**

* It is recommended that a test area be painted and tested for adhesion before proceeding with the project.

**If mold or mildew is a problem, an EPA approved anti mildew/mold agent may be added to the urethane finish coat upon request.