

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOTHANE HS CLEAR WILKO NO. 720.18

PRODUCT DESCRIPTION: No. 720.18 Wilkothane HS Clear is a high solids two component acrylic polyurethane exhibiting excellent gloss retention and chemical resistance. It meets the Arizona Administrative Code Section R18-2-727. It also meets the Maricopa County Emission limits of 3.5#/gal for air-dried coating for metal parts and products

TYPICAL USES: Exterior structural finishes, maintenance coating for pippins, tanks and vessels. May also be used for painting of construction equipment and general transportation vehicles (OEM and refinish).

GENERIC TYPE: Acrylic-Aliphatic Polyurethane

COLOR: Clear (available in several colors)

FINISH: Gloss - 85 degrees minimum

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 720.18 to one volume of No. 050.25 Activator.

POT LIFE: 4 Hours @ 75°F
2 hours @ 85°F
1 hour @ 95°F

Addition of accelerator or high speed mixing will shorten above pot life. Thinning will extend useable pot life. Do not expose mixed paint, hoses or painting equipment to direct sun to prevent premature setting in the line due to elevated temperature.

WEIGHT PER GALLON: 8.36 ± lbs (mixed)

VOC: 3.4 lbs (mixed)

SOLIDS BY VOLUME: 51.7 lbs (mixed)

COVERAGE: @ 2 mil DFT
Theoretical - 415 sq. ft./act. gal.
Practical - 332 sq. ft./act. gal.

RECOMMENDED THICKNESS: 2 to 3 mils DFT

NUMBER OF COATS: 1 to 2 recommended

DRYING TIME: *To Touch:* 2 to 3 hours
To Recoat: 24 hours
@ 77°F

THINNER: No. 44 or Retarder No. 145

FLASH POINT: 720.18: 23° F TCC
050.25: 23° F TCC

CLEAN UP THINNER: No. 44 or MEK

TEMPERATURE RESISTANCE: Dry 200°F

RECOMMENDED SUBSTRATE: Pigmented Urethane Coatings or Steel

SURFACE PREPARATION:

General Maintenance:

1. Round off all sharp edges and remove any weld splatter.
2. Remove all rust, mill scale, grease and other foreign matter
3. For best results, sandblasting to conform to SSPC-SP-10 is recommended.
4. Following sandblasting, remove all sand, grit and residue with high-pressure air.
5. Apply primer coating prior to the development of any surface rust, then color coat and clearcoat as directed below.
6. Over old urethane surfaces when blasting is not possible, clean surface of any oil, grease, rust, dirt and loose paint. Sand the old coating to assure proper adhesion. If the old coating is faded, apply a thin coat of epoxy primer and one coat of color coat before clear coating.

OEM or Other Industrial Applications:

Surface must be clean and dry, free from oil, grease, wax or other contaminants. If applied over steel or previously painted surfaces that has sat more than overnight, the use of chemical cleaning or pretreatment (e.g., phosphating over steel) is highly recommended and will help to improve adhesion and enhance the overall properties of the coating. For most industrial applications, this multi-stage surface preparation is adequate. If heavy mill scale, rust, or loose paint is present, clean the parts by mechanical means. Hand, power tool, or SP7 Brush Blast Cleaning will afford minimum protection. For maximum protection of steel surfaces, dry abrasive blast pitted, rusty areas or loose paint to a Commercial Blast Finish in accordance with SSPC-SP6. Apply the primer or coating prior to the development of any surface rust.

APPLICATION METHODS: Conventional or airless spray

APPLICATION PROCEDURE:

1. Mix four volumes of pigmented component with one volume of No. 050.25 Activator. Add about 10% by volume of No.44 Thinner and spray apply a test patch and check for "orange peel". If the ambient temperature is 85°F or higher add No. 145 Retarder to minimize orange peel or dry overspray and prevent lap marks. No. 145 may be substituted for the thinner if necessary. Addition of 3 oz of Thinner per activated gallon will result in 3.5#/gal VOC, and addition of 14 ounces per activated gallon will yield 3.8#/gal VOC.

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APPLICATION PROCEDURE: (cont'd)

2. *CONVENTIONAL SPRAY:* Apply with industrial equipment such as DeVilbiss JGA or Binks 95 or 2001 or Graco Delta XT spray gun with separate air and fluid pressure regulators, and a moisture and oil trap in the main supply are recommended. Contamination with oil and water will result in shortened pot life, loss of adhesion, and poor film integrity.
 3. *AIRLESS SPRAY:* Standard airless sprays Graco, DeVilbiss, or others with a 28:1 or higher pumps ratio and a .011 to .014 inch fluid tip.
 4. 720.18 may be applied wet on wet (2-4 hours air-drying) over Wilkothane HS coatings, or after an overnight dry as a clear finish coat. Spray a medium coat of the activated clear, allow to tack off, then follow with a full second coat. Do not allow more than 72 hours at 77°F (or overnight at higher temperatures), between the application of the color coat and clearcoat to avoid premature delamination failure. If a period of 72 hours at 77° has elapsed (or more than 24 hours at higher temperatures), scuff sand and use tack cloth to remove surface contaminant, (or apply 342.22 Wilkopon Primer instead of scuff sanding), apply the color coat, then clearcoat within the specified time frame. Consult your Technical Representative for advice under varying conditions.
 5. Topcoating Aluminum Coatings: 729.940 Wilkothane HS Aluminum must be topcoated within 24 hours @77°F to assure good intercoat adhesion. Applying 720.18 Wilkothane HS Clear will preserve the surface by isolating the aluminum from abrasive forces or chemical attack, and it resists yellowing. Clear coating is recommended in heavy traffic areas or in corrosive environment. For topcoating leafing aluminum like 729.935, use 720.44 instead. If the aluminum coating is allowed to dry for more than 24 hours @95°F (or 72 hours @77°F, 48 hours @85°F), it must be acid etched with 850.01 Rust Sol, then recoated with 729.940 before clear coating. If not properly done, the clear coat may delaminate prematurely.
 6. 720.18 may be added to Wilkothane HS finish coats to improve gloss and color retention. Mix thoroughly up to 25% of activated clear material with activated pigmented base. Reduce up to 25% by volume with No.44 or No. 145 or a combination of the two. Caution: the addition of clear may cause the color of the finish coat to shift, especially with metallic colors. It is important that the same amount of clear coat be added for all the areas that are painted.
 7. To restore gloss and color of chalky or faded, but tightly adhering polyurethane coating, remove chalk and contaminants by scrubbing with trisodium phosphate and Clorox solution & thoroughly rinse. When surface is dry, topcoat with a 1:1 mixture of activated No. 720.18 and the original Wilkothane HS color that has been reduced as previously described.
 8. In cool weather, use MEK in place of No.44 to avoid sagging. Add ½ to 1 ounce of T022 Accelerator at temperatures below 70°F to facilitate curing. Caution: Addition of accelerator will shorten pot life.
 9. To avoid any contamination, use an air source with a good moisture trap and oil filter. Contamination with water will result in short pot life, poor film integrity and early coating failure. Any contamination with oil and other particulates, including water, could result in cosmetic defects (pinholing, cratering, crawling, etc.) and/or loss of adhesion.
 10. Use Wilko No. 850-05 Fisheye Eliminator if pinholing or cratering become evident during use. For areas heavily contaminated with oil, wax or other particulate that cause surface defects, use up to 4 oz. of Wilko No. 850-10 Anti-Crater per activated gallon of paint. This should not ever be used as an alternative to proper surface preparation and cleaning prior to painting.
 11. Repairing damaged clear coat: Allow the clear coat to cure to nail hard (normally 72 hours @77°F), then inspect for type of flaw. If it is discolored (water spotting, whitewashed, etc.), the defective area must be sanded and feather edged. Apply a clear coat and featheredge into the undamaged area. In most cases, it is easier and more aesthetically acceptable if the entire unit is re-clearcoated.
 12. Repainting: The clearcoat of 720.18 may be recoated the same day with itself or with other urethane topcoats. If additional coats are needed after 24 hours, it is best to wait at least 2 days, scuff sand and use tack cloth to remove surface contaminant, (or apply 342.22 Wilkopon Primer instead of scuff sanding), apply the color coat, then clear coat within the specified time frame. (NOTE: This procedure is different than when recoating color coat and clear coating afterwards. Sanding color coats may produce discoloration or striation that will telegraph to the clear coat and produce uneven finish.)
- 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 incidence of exposure.
- PRECAUTION:** 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.