WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOTHANE G WHITE
WILKO NO. 721.11

PRODUCT DESCRIPTION: Wilko No. 721.11 Wilkothane G White is a two component aliphatic acrylic polyurethane. It has excellent gloss retention and good resistance to splash and spillage of most weak acids and alkalis, salts, most solvents, and water.

PRINCIPAL USE: As exterior finish for chemical processing & petrochemical plants, as well as coating for construction equipment and transportation vehicles. It is used as a topcoat over epoxy primers where corrosion and weather resistances are required.

GENERIC TYPE: Acrylic - Polyurethane

COLOR: White

WEIGHT PER GALLON: 10 ±.5 lbs.

VOC: 4.2 lbs.(mixed)

SOLIDS BY VOLUME: 43 ± 1.0%

COVERAGE: @ 2 mils dry
Theoretical - 348 square feet per gallon
Practical - 278 square feet per gallon

RECOMMENDED DFT PER COAT: 1-2 mils

DRYING TIME: @ 77°F
To Touch: ½ to 1 hour
To handle: 2-4 hours
To Recoat: 4-6 hours, overnight preferred

SURFACE PREPARATION: Surface must be clean and dry, free from oil, grease, wax or other contaminants. The use of chemical cleaning or pretreatment (e.g., phosphatizing) will help improve the adhesion and will enhance the overall properties of the coating, and is highly recommended if no mill scale or rust is present and sandblasting is not feasible. When recoating urethane coatings, scuff sand the surface or prime with 342.22 to ensure adhesion over the old finish.

When coating newly fabricated steel, or if heavy mill scale, rust, or loose paint is present on existing structures, clean the parts by mechanical means. All sharp edges must be rounded and weld splatter must be removed prior to cleaning. Hand, power tool or SP7 Brush Blast Cleaning will afford minimum protection. For maximum protection of steel surface, dry abrasive blast to a Commercial Blast Finish in accordance with SSPC-SP6 Apply prior to development of any surface rust. An appropriate primer must be used when coating sandblasted steel.

RECOMMENDED PRIMER: For optimum performance, use epoxy-polyamide primers like Wilko No. 342.22 Wilkopon Gray Primer or 342.46 Wilkopon Recoat Primer Gray or equivalent.

RECOMMENDED THINNER: Wilko No.44 or Wilko No.101. Use No. 101 for temperatures above 90 °F.

CLEAN UP THINNER: No. 44 or MEK

APPLICATION:

1. Apply by conventional or airless spray. Brush or roll small areas only. Mix pigmented components until uniform, then mix four volumes of pigmented component with one volume of No. 050.06 Activator.
2. *CONVENTIONAL SPRAY:* Thin approximately 25-40% by volume with No. 44 Wilkothane Thinner to 18-22 seconds viscosity on the Zahn No.2 cup. No special gun setup is needed to apply this product. Most suction or pressure fed gun intended for applying low viscosity coating will work for this application. Examples are Binks Model 62 , 2001 or 2100 Gun with a fluid tip of 63 - 66 and air cap of 63PR for pressure fed, to 66SK for siphon fed, guns. For pressure fed setup, regulate the tank pressure at 5-10 psi. Atomization pressure should be maintained at 45-75 psi.

Following is an example of a typical gun setup for a Binks 2100:

Siphon Fed (Cup Gun):
Fluid Nozzle: 66SS (0.070 Orifice), Part #45-6601
Air Nozzle: 66SD, Part #46-6020
Needle: #565, Part # 47-56500
Atomization Pressure: 40-60 psi

Pressure Fed
Fluid Nozzle: 63CSS (0.052 Orifice) Part #45-6331
Air Nozzle: 63PB, Part #46-6002
Needle: 563A, Part #47-56310
Pot Pressure: 5-10 psi
Atomization pressure: 40-60 psi.

3. *AIRLESS SPRAY*: Thin approximately 10-20%by volume with No. 44 Wilkothane Thinner to 20-26 seconds viscosity on Zahn No. 2 cup. For best results use fluid tip of .010 -.015 and an air source of 80-100# using a 28:1 pump ratio (approximately 2500 psi fluid pressure). Using a larger tip or lower pressure may affect application properties of the coating and will result in air entrapment and sags.
4. Spray apply one wet tack coat and follow with a full wet coat. Hold spray gun 6-8 inches from surface and overlap each pass 25%. Allow first coat to dry for at least 16 hours @ 77°F (25°C) before applying a second coat.

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APPLICATION (cont'd):

5. If ambient temperature is 90°F or higher use No.101 Retarder. Use MEK in place of No.44 in cool weather to avoid sags and add 1/2 to 1 ounce of T022 to expedite cure.
6. 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.
7. Use No.850.05 Fish Eye Eliminator if pinholing or cratering is evident. For areas that are heavily contaminated with oil, wax or other particulate that may cause surface defects, use No. 850.10 Anti-Crater at a rate of up to 4 ounces per gallon of paint. This must not be used as an alternative to proper surface cleaning prior to painting.
8. Allow coating to cure 3 - 5 days at 77°F before placing into service. Applicators should be made aware, especially during cool seasons or in cooler climates, that this material will require 12-16 hours curing time at 77°F for recoating, and that during this period the film is extremely vulnerable to moisture and moisture laden contaminants. Consequently, the painting schedule must be planned to include the deposition of material early enough to provide at least partial cure prior to lower nighttime temperatures and possible dew point conditions.
9. Curing rates are accelerated by heat and retarded by lower temperatures. Drying rates are based on 75°F. As a rule, for every 18° above 75°F the curing rate will accelerate by approximately 100%. For every 18° below 75°F the curing rate will be retarded by approximately 100%. The premature failure of fine coating systems is often caused by failure to acknowledge facts related to applying at low temperatures. This coating may not cure at temperatures of 50°F or lower. Do not apply if the average temperature is not expected to go over 50°F during the next 24 hours.
10. 720.07 Wilkothane G Clearcoat Application: To enhance the gloss of the color coat, mix up 720.07 clear up to 50% with the Wilkothane G color coat and apply as a final coat, or apply the clear coat as a final coat
11. For Painting aluminum, refer to Wilko Publication **"PAINTING ALUMINUM SURFACES.** This and other publications can be downloaded at:

http://www.wilkopaintinc.com/Download1.html

POT LIFE: 6-8 Hours @ 70°F
4-6 Hours @ 80°F
2-4 Hours @ 95°F

Addition of accelerator like T012 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.

Typical Film Properties*

INITIAL 60°/20° GLOSS	95/78
500 HOURS, QUV	89/75
1000 HOURS, QUV	83/72
PENCIL HARDNESS	H-2H
DIRECT IMPACT IN-LBS	50
REVERSE IMPACT IN-LBS	20
CONICAL MANDREL, PASS	1/8 INCH DIAMETER
MEK DOUBLE RUBS	40 NO EFFECT
4 HOURS GASOLINE EXPOSURE	NO EFFECT
1000 HOURS SALT FOG	EXCELLENT
1000 HOURS QUV	EXCELLENT

**Wilkothane G applied directly to Bonderite 1000* cold rolled steel at 1.2 to 1.5 mils dry. Finish air dried 14 days at room temperature before tests were conducted.*

Salt spray tests using 342.22 Wilkopon Epoxy Primer:

Over Sandblasted Steel:	2000 Hours
Over Bonderite 1000*:	1800 Hours

**Bonderite 1000 is iron phosphate - treated polished cold rolled steel*

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: 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 (MSDS).