WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOTHANE S WHITE
WILKO NO. 721.23

PRODUCT DESCRIPTION: No. 721.23 Wilkothane S White is a lead free two-component polyester polyurethane.

TYPICAL USES: This coating is designed as a finish for general transportation vehicles, such as trucks, buses and aircraft, and for areas that have aggressive environment like chemical manufacturing plants and the like. Its attractive tile - like finish and excellent abrasion and chemical resistance makes it an ideal coating for concrete floors and anywhere there is potential for chemical spillage.

COLOR: White (available in several colors)

FINISH: 60° Gloss - 85 % minimum

COMPONENTS: Two

MIXING RATIO: Two volumes of No. 721.23 to one volume of No. 050.09 Activator, or 1:1 with 050.07 Activator.

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.

ACTIVATED PROPERTIES:	With 050.07	With 050.09
WEIGHT PER GALLON:	9.6 ± .5 lbs	10.5 ± .5 lbs
VOC, lbs/gal:	4.3	3.5
SOLIDS BY VOLUME:	40 ± 1.0%	53 ± 1.0%
COVERAGE: sq. ft./act. gal. @ 1 mil DFT		
Theoretical -	690	850
Practical -	552	680

NUMBER OF COATS: 1 to 2 recommended

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

Note: Dry time and cure of Wilkothane S may be accelerated with addition of No. T-22 Accelerator. Caution!! The addition of accelerator will reduce the potlife of the activated coating and may adversely affect gloss.

THINNER: No. 44 or Retarder No. 101

CLEAN UP THINNER: No. 44 or MEK

TEMPERATURE RESISTANCE: Dry 200°F continuous

FLASH POINT:
721.23 : 24° F TCC
050.09: 23° F TCC
050.07: 23° F TCC

VISCOSITY: 40-50 F4
300-350 cps

CHEMICAL RESISTANCE:

EXPOSURE	FUME	SPILLAGE
Acid	Good	Excellent
Alkali	Good	Excellent
Solvent	Excellent	Excellent
Alcohols	Excellent	Excellent
Petroleum Products	Excellent	Excellent
Water	N/A	Excellent
Skydrol		Good

721.23 resists splash and spillage of the following chemicals:
Acetic Acid, 10%
Acetone
Aliphatic Solvents
Ammonia
Butyl Acetate
Butyl Benzyl Phthalate
Caustic Soda (50% Sodium Hydroxide)
Dibutyl Tin Dilaurate
Dimethyl Sulfoxide
Di Octyl Phthalate
Diesel Fuel
Ethyl Acetate
Ethyl Alcohol
Ethylene Glycol
Ethylene Glycol Butyl Ether
Ethylene Glycol Butyl Ether Acetate
Gasoline
Hydrochloric Acid, .1 N
Hydrogen Sulfide
Isopropyl Alcohol
Isobutyl Alcohol
Kerosene
Methyl Ethyl Ketone
Methyl Amyl Ketone
N-Butyl Propionate
Propylene Glycol
Propylene Glycol Phenyl Ether
Sodium Chloride
Sodium Hydroxide, .1 N
Sulfuric Acid, .1 N
Toluene
Xylene

RECOMMENDED THICKNESS: 2 to 3 mils DFT

RECOMMENDED TOPCOATS: Wilkothane S colors and clear

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RECOMMENDED SUBSTRATE: Steel or Aluminum

RECOMMENDED PRIMERS: No. 342-22 Wilkopon Gray, 347.29 Wilkopon Yellow and No. 347-49 Wilkopon HS Red Primers.. Wilko Primer No. 349-13 Wilkopon and 859.06 Zinc Rich Primers may also be used for added corrosion resistance (an intermediate coat is recommended). For galvanized surfaces and aluminum use 603.08 Chromate Free Wash Primer.

SURFACE PREPARATION:

General Maintenance:

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.

OEM or Other Industrial Applications:

Surface must be clean and dry, free from oil, grease, wax or other contaminants. Use of chemical cleaning or pretreatment (e.g., phosphatizing) 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 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 PROCEDURE:

1. Mix pigmented components until uniform, then mix one volume of pigmented component to one volume of 050.07. For higher application solids, mix two volumes of pigmented component with one volume of Wilkothane S Activator No. 050.09.
2. *CONVENTIONAL SPRAY:* Thin up to 25% by volume with No. 44 Wilkothane Thinner to 18-22 seconds viscosity on the Zahn No.2 cup if 050.09 Activator is used. Thinning is not needed if 050.07 Activator is used. 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 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). If pigtails are evident, use more thinner, increase fluid pressure, use a smaller tip or do a combination of these changes. Pigtails will result in air entrapment, low gloss 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.
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. Surface preparation brochures and other publications may be downloaded at:

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

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 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.

11/12/13