

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON 100% EPOXY COATING GRAY WILKO NO. 332.74

PRODUCT DESCRIPTION: No. 332.74 Wilkopon Epoxy Gray is a 100% solids, two component epoxy polyamide coating that is designed for direct application to concrete, and to metals following the removal of loose rust and scale.

TYPICAL USES: Recommended as a coating for structural steel, exterior of storage tanks and miscellaneous equipment in chemical and refinery facilities. It is an ideal coating in areas where sandblasting is not feasible or is impractical. Its excellent abrasion resistance and self-leveling properties make it an ideal coating for floors where heavy traffic and/or chemical spillage is anticipated. It is not recommended for areas where gloss retention is required.

GENERIC TYPE: Epoxy-Polyamide

COLOR: Gray (available in clear)

FINISH: Gloss

COMPONENTS: Two

MIXING RATIO: One part of 332.74A to One part of 332.74B Activator.

SWEAT IN TIME: 5 minutes @ 77° F

POT LIFE: : @75° F 15 min
@100° F 5 min

WEIGHT PER GALLON: 11.0 +.5 lbs (mixed)

VOC: .15 lbs (mixed)

SOLIDS BY VOLUME: 100 ± 2.0% (mixed)

COVERAGE: @ 2 mil DFT
Theoretical - 1604 sq. ft./act. gal.
Practical - 1283 sq. ft./act. gal.

RECOMMENDED THICKNESS: 2.5 to 4 mils DFT

NUMBER OF COATS: 1 to 2 recommended

TEMPERATURE RESISTANCE: Dry 200°F continuous, 250 °F intermittent

THINNER: No. 71 or Retarder No. 101

REDUCTION: Below 85 °F: Up to 84 oz. No. 71 Thinner (2.8#VOC)

CLEAN UP THINNER: No. 71 or MEK

APPLICATION METHODS: Airless Spray, Brush, Squeegee

SHELF LIFE: One Year

DRYING TIME with No. 332.74B Activator @77°F

TO TOUCH: 1 to 2 hours

TO RECOAT: 6 to 24 hours

Coating will fully cure in 2 weeks at 70°F

RECOMMENDED SUBSTRATE: Concrete or Steel

RECOMMENDED PRIMERS: Material may be applied directly to properly cleaned metal or concrete. For additional corrosion resistance, use No. 349.13 Wilkopon HS Primer Zinc Rich or 859-06 Primer Inorganic Zinc Rich. For concrete use 342.45 Wilkopon Gray Epoxy Primer.

RECOMMENDED TOPCOATS: Wilkothane HS polyurethanes or Wilkopon Epoxies. Allow coating to cure for 24 hours if recoating with urethanes.

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, and is recommended if no loose paint, mill scale or rust is present and sandblasting is not feasible.

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

CONCRETE: Refer to Wilko's guide on surface preparation guide for concrete.

APPLICATION: Airless spray is recommended for maximum film build. Use a high volume output pump and a tip of 19 or larger. On a vertical surface 2 mils is the maximum that can be applied without sagging. This material may also be used to fill cracks by mixing one part by volume of activated epoxy with two parts by volume of sand.

CAUTION: Workable pot life of this product is 15-20 minutes for one gallon or less at 77°F. Pot life is shorter at higher temperature or if mixed in larger quantities.

EQUIPMENT REQUIRED:

Airless Spray:

1. Airless spray equipment with pump ratio of 28:1 or 30:1.

2. Airless spray tip with orifice diameter of 0.015 to 0.019

Brush: use a stiff brush to apply. Thinning may be necessary for workability.

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APPLICATION PROCEDURE:

1. **ACTIVATION:** Separately mix No. 332.74A Part A (base) and No. 332.74B Part B (activator) components until uniform. Then mix equal volumes of base and activator and allow mixture to stand for 15 minutes before using.
2. **REDUCTION:** *Conventional Spray:* Thin up to 25% with appropriate thinner (see above section -RECOMMENDED THINNER/VOC).
Airless Spray- May be applied without thinning at 70-85°F. In cooler weather, or when using a smaller airless units, thin with up to 10% of the appropriate thinner. (see above-RECOMMENDED THINNER)
Roll or Brush: May be brush applied or rolled as is 77°F or higher temperature. For roller or brush application thin up to 10% with No. 71 Thinner. Use a 1/4" nap roller to minimize air entrapment. Cross-coat to achieve uniform thickness. Do not allow the roller to become dry during cross-coating. Apply coating from seam to seam in a continuous stroke to minimize any roller marks.
3. **CONVENTIONAL SPRAY:** Apply tack coat and follow with full wet coat. Hold gun 8-10 inches from surface and overlap each pass 25% to avoid holidays.
4. 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 18o above 75°F, the curing rate will accelerate by approximately 100%. For every 18o 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. For satisfactory cure, air and surface temperatures must be above 50°F for the next 16 hours. Coatings applied at 50°F or lower will not properly cure, and its performance will be adversely affected.
8. *Coating previously Painted Surfaces:* If coating is in sound condition, clean the surface of all foreign material and apply the coating to a small area to test for lifting, bleeding, or lack of adhesion. If any of these characteristics are exhibited then remove all old paint and prepare surfaces as listed.

CHEMICAL RESISTANCE:

(Fumes, Splash and Spillage, Non-Immersion)	
Aromatic Hydrocarbon	Passes
Aliphatic Hydrocarbons	Passes
Alkali	Passes
Organic Acids (Dilute)	Passes
Lubricating Oils	Passes
Acid: Resists fumes of non-oxidizing acids.	
Alcohol: Accepts the spillage of isopropyl, ethyl and butyl alcohol	
Petroleum Distillate: Resists splash and/or spillage of gasoline, sour crude, diesel fuel, and jet	

Other Properties:

Adhesion: Excellent over 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.

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.