



# WILKO PAINT, Inc.

MANUFACTURERS OF THE FINEST INDUSTRIAL COATINGS Since 1958

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## WILKOTHANE HS 2.8 GREEN METALLIC WILKO NO. 729.818

**PRODUCT DESCRIPTION:** No. 729.818 Wilkothane HS 2.8 Green Metallic is a high solids, high build two-component acrylic polyurethane coating that is environmentally compliant. Activated material meets most state VOC restrictions for industrial maintenance paints and also meets most local VOC restriction of 2.8#/gal. This product exhibits excellent gloss and color retention coupled with superior chemical resistance providing extended service life.

**TYPICAL USES:** Exterior structural finishes, maintenance coating for pipes, 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:** Green Metallic (available in many colors)

**FINISH:** High Gloss

**MIXING RATIO:** Four volumes of No. 729.818 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 with No. 145 or addition of Wilko No. 850.40 PL Extender will extend useable pot life. Do not expose paint, hoses or painting equipment to direct sun to prevent premature setting in the line due to elevated temperature.

### MIXED PAINT PROPERTIES:

Wt/Gal:	9.0	lbs
Solids By Volume:	56.1	%
VOC (Method 24):	2.76	#/gal
VOC (As supplied):	2.52	#/gal
Theo. Coverage @ 1mil DFT	900	Sq ft/gal
@ 2 mil DFT	450	Sq ft/gal

**FLASH POINT:** 722.73: 81° F TCC  
050.25: 76° F TCC

**TEMPERATURE RESISTANCE:** Dry 225°F continuous, can take intermittent spikes of up to 300°F.

**RECOMMENDED THICKNESS:** 2 to 3 mils DFT

**NUMBER OF COATS:** 1 to 2 recommended

**DRYING TIME:** @ 77°F  
*To Touch:* 2 to 3 hours  
*To Recoat:* 2- 24 hours  
Addition of No. T022 accelerator and/or higher temperature will decrease dry time. It may be force dried at up to 250°F to facilitate drying. Light colors might discolor if baked at higher temperature or longer than 15 minutes.

### PHYSICAL PROPERTIES:

60 degree gloss meter reading (ASTM D-523),	85+
Pencil hardness (ASTM D-3363),	H-2H
Adhesion to substrate (ASTM D-3359B),	100% 5B
Flexibility ASTM D-522	3mm
Impact resistance (ASTM D-2794)	direct 80-120 lb/in reverse 40-80 lb/in

**RECOMMENDED THINNER:** No. 118 VOC Free Thinner or No. 44 Thinner or No. 145 Retarder. Refer to Section 4 of *Application Procedure*, below, for Thinning Instructions. No. 38 Fast Dry Thinner may be used in cold weather.

**CLEAN UP THINNER:** No. 44 or NO.38

**APPLICATION METHODS:** Conventional or airless spray

**RECOMMENDED SUBSTRATE:** Steel or Aluminum

**RECOMMENDED PRIMERS:** 702.15 Wilkothane Gray Primer, No. 342.46 Wilkopon Recoatable HS Gray Primer, No. 347.67 Wilkopon HS Red Primer, Wilko No. 342.45 Wilkopon HS Gray Primer or 349.13 Wilkopon Primer Zinc Rich as well as other Wilkopon Primers.

**RECOMMENDED TOPCOATS:** 720.28 Wilkothane HS 2.8 Clear for additional gloss and color protection if desired or 720.49 Wilkothane HS 2.8 Clear MR that also provides Mildew Resistance.

### 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 coating prior to the development of any surface rust.
6. Over old epoxy or 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.

*continued on page 2*

*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 application, 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.

For Painting aluminum, refer to Wilko Publication "PAINTING ALUMINUM SURFACES. This and other publications can be downloaded at:

<http://www.wilkopaintinc.com/Downloads.html>

**APPLICATION METHODS:** Conventional or airless spray. Brush or roll for small areas only.

1. Mix pigmented component until uniform, then mix four volumes of pigmented component with one volume of Wilkothane Activator No. 050.25 and stir well. If using a mechanical mixer, do not mix for more than 5 minutes, and stop the mixer after this period.
2. **CONVENTIONAL SPRAY:** Apply with industrial equipment, such as DeVilbiss JGA and FF fluid tip, 765 air cap, or Binks No. 62, 95, 2100 or 2001 spray gun with a 66 PB nozzle and air cap of 63PR for pressure fed, to 66SK for siphon fed, guns or Graco Delta XT with .055 tip. For pressure fed setup, regulate the tank pressure at 5-10 psi. Atomization pressure should be maintained at 40-60psi. 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 poor adhesion and surface imperfections like craters or pinholes.

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:** Standard airless sprays Graco, DeVilbiss, or others with a 28:1 or higher pump ratio and a .011 to .015 inch fluid tip. Check for pigtails before applying. If pigtail occurs, use a smaller tip, higher pressure, add thinner or a combination of these remedies. Pigtail is an indication of poor atomization that can lead to sagging, low gloss and microfoam formation.

4. Thinning is not normally required. If thinning is necessary for workability, use up to one pint of No.118 or No. 44 Thinner per gallon of activated material. Apply a wet coat in even parallel passes, overlapping each pass 50% to avoid holidays, bare areas and pinholes. If required, follow with a spray pass at right angles to the first pass. Under hot conditions or where dry spray or orange peel is evident, use a retarder like No.101 or No.145 Thinner. They may be blended with No.118 or No.44 as needed or used solely under hot application temperatures (90° and above). Retarders will also minimize dry overspray and prevent lap marks.

NOTE: Addition of non VOC Exempt thinner(s) will raise the VOC.

5. Do not apply coating when surface temperature is less than 5°F above the dew point to prevent moisture condensation. For satisfactory cure, air and surface temperatures must be above 65°F. In cool weather or low surface temperatures (under 65°F), use Wilko No. T022 to accelerate cure in the amount of ½ to 1 ounce per gallon. CAUTION: Potlife will be shortened with the addition of accelerator.
6. Use Wilko No. 850.05 Fisheye Eliminator if pinholing or cratering becomes evident during use. For areas that are heavily contaminated with oil, wax or other particulates that cause surface defects, use up to 4 oz. of Wilko No. 850.10 Anti-Crater per activated gallon of paint. This should never be used as an alternative to proper surface preparation and cleaning prior to painting.
7. Clear coating: Compatible clear coats such as 720.28 or 720.49 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, and then follow with a full second coat.
8. Compatible clear urethanes such as 720.28 may be added to 729.818 Wilkothane HS and applied as the final coat 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 a combination of the two or NO.118 VOC Free Thinner. Caution: the addition of clear may cause the color of the finish coat to shift. It is important that the same amount of clear coat be added for all the areas that are painted.

**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 respirator to avoid breathing concentrated vapors in enclosed areas. Keep the container closed.

Refer to Safety Data Sheet for safety precautions. This and other publications are available for download at:

<http://www.wilkopaintinc.com/downloads/>

For more information, please contact your salesman. You may also call 1-800-658-3799 or send an email to [orders@wilkopaintinc.com](mailto:orders@wilkopaintinc.com) for any assistance, to request SDS, or to place an order.