

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

POST OFFICE BOX 4089 • 2727 OHIO • PHONE (316)838-4288 • FAX(316)838-6328

WILKOTHANE HS ALUMINUM METALLIC WILKO NO. 729.940

PRODUCT DESCRIPTION: No. 729-940 Wilkothane HS Aluminum Metallic is a high solids, high build two component acrylic polyurethane coating that meets environmental regulations. This material exhibits excellent gloss and color retention during extended service life.

TYPICAL USES: Exterior structural finishes, maintenance coating for pipings, 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: Aluminum Metallic

FINISH: Gloss - 85 % minimum

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 729.940 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

WEIGHT PER GALLON: 8.9 +.5 lbs (mixed)

VOC: 3.1 lbs (mixed)

SOLIDS BY VOLUME: 55.4 ± 1.0% (mixed)

COVERAGE: @ 1 mil DFT
Theoretical - 888 sq. ft./act. gal.
Practical - 711 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

CLEAN UP THINNER: No. 44 or MEK

TEMPERATURE RESISTANCE: Dry 200°F continuous

SHELF LIFE: One year, unopened and stored at 77°F

APPLICATION METHODS: Conventional or airless spray

FLASH POINT: 729.940: 23° F TCC
050-25: 23° F TCC

RECOMMENDED SUBSTRATE: Steel or Aluminum

RECOMMENDED PRIMERS: No. 342-46 Wilkopon Gray Primer and No. 347-67 Wilkopon HS Red Primer. Wilko No. 349-13 Wilkopon Primer Zinc Rich and other Wilkopon Primers may also be used.

RECOMMENDED TOPCOATS: Designed to be clearcoated with 720.18 or 720.29 Wilkothane HS Clear for high gloss.

SURFACE PREPARATION:

General Maintenance:

1. Round off all sharp edges and remove any weld splatter. Remove all rust, mill scale, grease and other foreign matter.
2. For best results, sandblasting to conform with SSPC-SP-10 is recommended. Following sandblasting, remove all sand, grit and residue with high pressure air.
3. Apply coating prior to the development of any surface rust.
4. Over old epoxy or urethane surfaces or when blasting is not possible, clean surface of any oil, grease, rust, dirt and loose paint. Sand or prime the old coating to assure proper adhesion.

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 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. Applthe primer or coating prior to the development of any surface rust.

Continued on page 2

APPLICATION PROCEDURE:

1. Mix pigmented components 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. Constant mixing will shorten the potlife considerably, especially if an accelerator is used.
2. *CONVENTIONAL SPRAY:* Apply with industrial equipment, such as DeVilbiss JGA and FF fluid tip, 765 air cap, or Binks No. 62, 95 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 65-75psi. 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. Thinning is not normally required. If thinning is necessary for workability, use up to one pint of 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. VOC with additional thinner:

12 oz/gal	3.5 #/gal
24 oz/gal	3.8 #/gal
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 (under 70°F), use Wilko No. T022 to accelerate cure in the amount of ½ to 2 ounces per gallon. CAUTION: Potlife will be shorter with the addition of T022 accelerator.
6. Use Wilko No. 850-05 Fisheye Eliminator if pinholing or cratering become evident during use. For areas 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 not ever be used as an alternative to proper surface preparation and cleaning prior to painting.
7. Clear coating: Compatible clear coats such as 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, and then follow with a full second coat. Do not allow the color coat to dry for more than 72 hours before clear coating.

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).

For Technical Information call:

Don L. Holt	918-299-0170
Tim Taylor	316-838-4288