

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

WILKOPON HS LIGHT GRAY WILKO NO. 332.111

PRODUCT DESCRIPTION No. 332.111 Wilkopon HS Gray is a two component epoxy – polyamide coating suitable for use in areas exposed to condensation and high humidity. Made with ingredients that are approved for contact with Type VII food listed under CFR 175.300

PRINCIPAL USE: Recommended as coating for steel and concrete surfaces that require chemical and corrosion resistance

COLOR: Light Gray

COMPONENTS: Two

MIXING RATIO: Four volumes of No. 332.111 to one volume of No. 330.18B Activator. For cool weather applications (50-70°F), use 330.18C Wilkopon Cool Weather Activator. Do not use 330-18C at temperatures over 70°F.

PHYSICAL PROPERTIES: with 330.18B: with 330.18C:

POT LIFE: @ 77°F 4-6 hrs 2-4 hrs.

WEIGHT PER GALLON 11.1 ±.5 lbs. 11.1 ±.5 lbs

VOC: 2.78 lbs. 3.3 lbs.

SOLIDS BY VOLUME: 60 ± 1.0% 55.5 ± 1.0%

COVERAGE: sq. ft per gal @ 1 mil dry
Theoretical - 962 890
Practical - 770 712

DRYING TIME: @ 77°F

To Touch: 1 to 2 hours 15 to 30 min
To handle: 6 to 8 hours 2 to 4 hours
To Recoat: 30 min - 72 hr. 30 min - 72 hr.
After 72 hours, scuff sand surface before topcoating. May be wet sanded in 6 hours.

FLASH POINT: 332.111 Part A: 82°F TCC
Part B: 115°F TCC
Part C: 82°F TCC

TEMPERATURE RESISTANCE: 200°F continuous, dry

RECOMMENDED DFT PER COAT: 3 MILS

RECOMMENDED APPLICATION: May be applied by brush or roller, or conventional or airless spray.

RECOMMENDED THINNER: Wilko No. 71, Wilko No. 44, or Wilko No.80. Use No. 71 for temperatures above 90 °F. For rolling or brushing use No. 80 Thinner.

CLEAN UP THINNER: No. 71 or MEK

RECOMMENDED SUBSTRATE: Steel

RECOMMENDED PRIMER: Wilkopon Epoxy Primers 342.46 Gray, 342.44 Gray, or 347.67 Red.

RECOMMENDED TOPCOATS: If desired, it may be topcoated with Polyurethanes, Epoxy Enamels and Vinyls after scuff sanding.

SURFACE PREPARATION:

Steel: Surface must be clean and dry, free of oil, grease, wax and other contaminants. Use of chemical cleaning and pretreatment (e.g., phosphatizing) is highly recommended and will help improve the adhesion and will help enhance the overall properties of the coating. If heavy mill scale, rust or loose paint is present, clean parts by a mechanical means. Hand, power tool or SP6 Blast Cleaning will afford minimum protection. For the maximum protection of steel surfaces, dry abrasive blast to Commercial Blast Finish in accordance with SSPC-SP6-63. Apply the primer or coating prior to the development of surface rust.

New Concrete: New concrete must cure for a minimum of 30 days prior to coating. After this period the only surface preparation necessary is etching. This can be accomplished with an acid solution.

After applying acid the reaction residues must be removed by using fresh water and a squeegee. Allow floor to dry thoroughly, sweep or vacuum to remove any/all powdery residue, and apply first coat of material. NOTE: Refer to "Coating Concrete" Brochure for more in-depth surface preparation. For optimum adhesion, use Wilkopon 342.22 or 342.44 Gray Primer.

Other Surfaces: Consult Wilko Representative

APPLICATION PROCEDURE:

1. Mix the pigmented component, No. 332.111, until uniform, and then mix four volumes with one volume of No.330.18B Activator (or 330.18C for cool weather application). Allow the mixed material to stand for 30 minutes before applying. To prevent any craters, fisheyes, or crawling when used over fiberglass reinforced plastics, add 2 ounces of No. 850-10 or No. 850-05 per gallon of material.

2. *CONVENTIONAL SPRAY:* Apply with industrial equipment, such as DeVilbiss MBC or JGA spray gun with No. 78 or 765 Air cap, E fluid tip and needle, or Binks 2001 or 62 spray gun, and a pressure pot with mechanical agitator. A moisture and oil trap in the main air supply line is required. Thin with up to 1 quart of No.71 Thinner per activated gallon.

Continued on page 2.

APPLICATION PROCEDURE *(cont'd)*

3. **AIRLESS SPRAY:** Any standard airless spray equipment, such as Graco Bulldog Hydra-Spray or larger, with a .013 - .017 inch fluid tip is recommended. If thinning is necessary, use No. 71 Thinner.

4. **BRUSH OR ROLLER:** For concrete walls and floors, brush or roller application is preferred to assure coverage of porous surfaces. To minimize air entrapment, replace part or all of the No. 71 Thinner with No.80 especially when applying the final coat.

5. Do not apply when surface temperature is less than 5° above dew point to prevent moisture condensation. For satisfactory cure, air and surface temperatures must be above 50°F.

6. Apply wet coat in even parallel passes, overlapping each pass 50% to avoid any holidays, bare areas and/or pinholes. If necessary, follow with a spray pass at right angles to the first pass.

7. Clean the equipment with No. 71 Thinner immediately after use.

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.