

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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PRIMER HS CORROSION INHIBITIVE RED WILKO NO. 497.108

PRODUCT DESCRIPTION: No.497.108 Primer HS Corrosion Inhibitive Red is a fast dry, lift resistant, high solids alkyd primer. It is formulated with lead and chromate free ingredients with low VOC content.

PRINCIPAL USE: Designed as primer for steel surface to be topcoated with alkyd enamels, polyurethanes, and acrylic emulsions. As a primer for structural steel, storage tanks, farm equipment and machinery, and for most OEM applications.

COLOR: Red (available in other colors)

WEIGHT PER GALLON: 15.4 \pm .5 lbs.

VOC: 2.8 lbs./gal.

SOLIDS BY VOLUME: 62 \pm 1.0%

COVERAGE: @ 1 mil dry
Theoretical - 995 square feet per gallon
Practical - 796 square feet per gallon

RECOMMENDED FILM THICKNESS: 1.5 mils dry for minimum protection. The maximum film thickness must not exceed 1-1/2 times this figure or film properties will be compromised.

DRYING TIME: *To Touch:* 10 to 15 minutes
@ 77°F *To Handle:* 30 to 45 minutes
To Recoat: 45 minutes

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 coating, and is recommended if no mill scale, heavy rust or loose paint is present and sandblasting or other mechanical ways of cleaning is not feasible.

When coating newly fabricated steel, or if heavy mill scale, rust loose paint is present, clean parts by a mechanical means. Sharp edges must be rounded off and weld splatter removed prior to 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 match SSPC-SP6-63. Apply primer prior to the development of any surface rust.

RECOMMENDED THINNERS:

Below 80°F: Wilko No.158 HAPS Free Thinner, No.143
VOC-Free Thinner, No.1 or No.13

Above 80°F: Wilko No.145 HAPS Free Retarder, No. 210
VOC- Free Thinner, No.13, or No.100 Retarder

NOTE: No.1, No. 13 and No.100 are VOC- and HAPS-
containing Thinners.

CLEAN UP THINNER: MEK, No. 1 or No. 13

APPLICATION EQUIPMENT:

1. *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 18 or 62 spray gun, and a pressure pot with mechanical agitator. A moisture and oil trap in the main air supply line is required. Reduce up to 24 ounces of No. 13 Thinner to keep VOC below 3.5#/gal, or thin up to 38 ounces to keep VOC below 3.8#/gal. Thin with No. 143 or No.210 Thinner to keep VOC at its level.

2. *AIRLESS SPRAY:* Apply as received. Any standard airless spray equipment, such as Graco Bulldog Hydra- Spray or larger, with a .011 - .017 inch fluid tip is recommended.

APPLICATION PROCEDURE:

1. Apply by conventional, or airless spray equipment. Stir the primer thoroughly, preferably by mechanical means.
2. Apply full wet film with the cross coat method to insure uniform coverage and film depth.
3. To assure an adequate cure, do not apply when the surface or ambient temperature is anticipated to drop below 50°F in 24 hours. Surface temperature must be at least 5° above the dew point for 24 – 36 hours to prevent moisture condensation, which might result in water spotting and poor film integrity.
4. Do not apply to wet or damp surfaces or surfaces which are likely to be exposed to excessive moisture before an adequate cure occurs.
5. Although this coating is recoatable the same day with most paints, it is recommended that the topcoat be tested in an inconspicuous area before proceeding to topcoat the whole unit, especially if done after 16 hours.

SHELF LIFE: 1 year, unopened and stored indoors at 77°F.

FIRST AID: If inhaled, remove to fresh air. If not breathing, administer artificial respiration, preferably mouth to mouth or similar method. 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.

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