

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKO GATOR-KURE "K" WHITE EPOXY WILKO NO. 331.46

PRODUCT DESCRIPTION: No.331.46 Wilko Gator Kure "K" White Epoxy is a two component, high solids, flake-glass reinforced epoxy - polyamine coating. It provides protection against fresh and salt water, as well as some petroleum products, such as crude oil. It is capable of curing at temperatures as low as 35 °F. Maximum chemical resistance is achieved following exposure to higher temperatures (above 60°F). It has the capability of adhering to damp surfaces and of curing underwater and under high humidity conditions. 331.46 is reinforced with Aramid fibers for better application properties and greater abrasion, wear and impact resistance.

TYPICAL USES: As a coating in sewage treatment plants, power plants, and refineries where water and chemical resistance are required.

GENERIC TYPE: Epoxy-Polyamine

COLOR: White

FINISH: Semi-gloss

COMPONENTS: Two

MIXING RATIO: 1 part of No. 331.46A to 1 part of 330.30B or 331.46B.

POT LIFE 45 min @ 65°F
35 min @ 77°F
15-30 min @ 90°F

Thinning will extend the potlife of the activated material

WEIGHT PER GALLON: 14.1 lbs activated

VOC: 0.24 lbs./activated gal.

SOLIDS BY VOLUME: 97.25 % activated

COVERAGE: @ 1 mil DFT
Theoretical - 1560 sq. ft./act. gal.
Practical - 1248 sq. ft./act. gal.

RECOMMENDED DRY FILM : 12-16 mils

RECOMMENDED TOPCOATS: May be topcoated with most epoxies and urethanes.

RECOMMENDED PRIMERS: May be applied DTM. For additional corrosion resistance, use Wilko No. 349.10, 349.13 or 349.23 Organic Zinc Rich Primers. It may be applied over existing epoxy primers.

TEMPERATURE RESISTANCE: To 250°F dry

DRYING TIME: Although this coating is moisture-tolerant during application, avoid exposure to heavy condensation for at least 30 minutes. Coating may be submerged one hour after it is applied.

@ 35°F.: @ 60°F.: @ 90°F.:

To Recoat: may be recoated immediately

Dry Hard: 36 hours 12 hours 8 hours

Full Cure: 14 days 10 days 5 days

SURFACE PREPARATION: This coating will adhere to superficial rust and marginally prepared metal surfaces. For maximum performance, surface must be clean and dry, free from oil, grease, wax or any other contaminants. The use of a chemical cleaner and/or pretreatment (e.g., phosphatizing) will help to improve the adhesion and enhance the overall properties of the coating, and is recommended if sandblasting is not feasible. When coating newly fabricated steel, or if heavy mill scale, rust and/or loose paint is present, clean the parts by a mechanical means. Sharp edges must be rounded and weld splatter removed prior to cleaning. Hand, power tool or SP7 Brush Blast Cleaning will afford minimum protection. For maximum protection of steel surfaces, dry abrasive blast to a Commercial Blast Finish in accordance to SSPC-SP63. Apply primer or coating prior to the development of any surface rust. New concrete must be cured for at least 28 days, then acid etched, before applying any type of coating. Old concrete must be free of grease, wax, oil, or loose rust, and if necessary, re-etched before painting.

RECOMMENDED SUBSTRATE: Steel and concrete

APPLICATION EQUIPMENT:

Airless Spray: Most recommended for high film build. Standard airless spray equipment such as Graco Bulldog Hydra-Spray or larger, with 0.027-0.030 inch fluid tip.

Conventional Spray: Industrial equipment such as DeVilbiss MBC or JGA, or a Binks 18 or 62 spray gun and a pressure pot with mechanical agitator. A moisture and oil trap in main air supply line is essential. Separate pressure regulators for air and fluid pressure are recommended.

APPLICATION PROCEDURE:

1. Stir No. 331.46A Wilko Gator Kure "K" White Part A until the material is uniform, then add 1 part Activator No. 331.46B to one part of Base No. 331.46A and thoroughly stir the mixture for five minutes.

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APPLICATION PROCEDURE (cont'd)

2. Thinning is normally not required when applied with paint gloves, mittens or spatula. For airless or conventional spray, thin only as necessary for atomization. At lower temperatures, use up to one pint of No.71 Thinner per activated gallon.
3. Spray: Apply a heavy wet coat in even, parallel passes with 50% overlap. Immediately follow with additional cross coat passes to obtain a continuous film with no pinholes, bare spots or holidays.
4. Apply additional material needed for the correct film thickness and repair of any pinholes or damaged areas within the recoat time limit.
5. Check thickness of coating with a non-destructive gauge, such as a Mikrotest or an Elcometer. If film is less than 16 mils DFT, apply additional material.
6. Check for pinholes, holidays and any other bare areas with a non-destructive holiday detector, such as a Tanker and Rasor Model M-1.
7. When applying in confined area, ventilate during application and curing to remove solvent vapors.
8. Damp surfaces and areas that are subject to condensation must be dried as much as possible by wiping with a cloth. Immediately apply the coating using mittens or brush, working the material into the residual surface moisture
9. When repairing deep-profiled areas, use fiberglass mesh for reinforcement. Apply the first coat, lay the fiberglass and cover with another coat..

RECOAT TIME: Recoat within the following times to ensure proper intercoat adhesion.

35 - 64°F	36 hours
65 - 74°F	24 hours
75 - 100°F	12 hours

Surface of the coating must be abraded by mechanical means if above recoat times are exceeded. To prevent edge delamination, abrade 1/2 inch beyond the area to be recoated using a 100 grit sandpaper. The coating may not perform adequately if the recoat times are exceeded, or if the application temperature is below 50°F. For optimum performance, obtain the desired film thickness in the least number of coats. Optimum resistance is achieved following exposure to temperatures of 60°F or higher.

ALTERNATE PRODUCT: 331.41 is a similar product with less abrasion, wear and impact resistance .

ORDERING AND KIT INFORMATION:

Kit Sizes: 1 Gallon, 1 quart, and 1 pint. A Kit consists of 1 container of 331.46A and another container of 331.46B - when mixed together it will yield the kit size. Each kit comes with Parts A and B, one stir stick, and one 2" brush. A can opener will be provided with each boxed kit(s).

For Additional Information Call:

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

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 exposure incidents.

PRECAUTION: 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