

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON HS BLACK WILKO NO. 336.10

PRODUCT DESCRIPTION No. 336.10 Wilkopon HS Black is a two component, high gloss epoxy – polyamide coating suitable for use in areas exposed to condensation and high humidity.

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

COLOR: Black

COMPONENTS:
Two

MIXING RATIO: Four volumes of No. 336.10 to one volume of No. 330.18B Activator. For cool weather applications (50-70°F), use 330.18C Wilkopon Cool Weather Activator.

PHYSICAL PROPERTIES: with 330.18B: with 330.18C:

POT LIFE: @ 77°F 6-8 hrs 4-6 hrs.

WEIGHT PER GALLON: lbs 8.5 ±.5 8.5 ±.5

VOC: lbs/gal 3.25 3.65

SOLIDS BY VOLUME: 54.5 ± 1.0% 49.1 ± 1.0%

COVERAGE: sq. ft per gal @ 1 mil dry
Theoretical - 874 788
Practical - 699 630

DRYING TIME: @ 77°F

To Touch: 1 to 2 hrs 15 to 30 min

To handle: 6 to 8 hrs 2 to 4 hrs

To Recoat: 30 min - 72 hrs 30 min - 72 hrs

After 72 hours, scuff sand surface before topcoating. May be wet sanded in 6 hours.

FLASH POINT: 336.10 Part A: 82°F TCC
Part B: 115°F TCC
Part C: 82°F TCC

RECOMMENDED DFT PER COAT: 2-3 Mils

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

RECOMMENDED SUBSTRATE: Steel

TEMPERATURE RESISTANCE: 200°F continuous, 250°F dry

CLEAN UP THINNER: No. 71 or MEK

RECOMMENDED THINNER: Wilko No. 71 or Wilko No. 44. Use No. 71 for temperatures above 90 °F.

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 SP7 Brush Blast will afford minimum protection. For the maximum protection of steel surfaces, dry abrasive blast to Commercial Blast Finish in accordance with SSPC-SP6. 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.

APPLICATION PROCEDURE:

Thinning: Use the following VOC guidelines when thinner is added for spraying:

Using 330.18B activator – Do not add more than 27 ounces of No. 71 Thinner to keep VOC at 3.5 #/gal or less. To keep VOC level of 3.8#/3 or less, do not use more than 42 oz of No. 71 Thinner per gallon of activated material.

Using 330.18C activator – Do not add more than 7 ounces of No. 71 Thinner to keep VOC at 3.5 #/gal or less. To keep VOC level of 3.8#/3 or less, do not use more than 20 oz of No. 71 Thinner per gallon of activated material.

1. Mix the pigmented component, No. 336.10, 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. For VOC calculations, the additives must be considered as solvents added.

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APPLICATION PROCEDURE (*cont'd*)

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 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. Thin with No.71 Thinner per activated gallon.

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.

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. 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.