

# WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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## WILKOPON COAL TAR EPOXY WILKO NO. 336.12

**PRODUCT DESCRIPTION:** No.336.12 Wilkupon Coal Tar Epoxy is a two component 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).

**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:** Black

**FINISH:** Semi-gloss

**COMPONENTS:** Two

**MIXING RATIO:** 4 volumes of Base No. 336.12 to 1 volume of Activator No. 336.12B. Note: 336.12B is a cool weather activator in itself, and this being the case, 336.12C designation is unnecessary and is not available.

**PACKAGING:**

*5 gallon unit:* 4 gallons of Base 336.12A in a 5 gal. pail & 1 gallon of Activator No. 336.12B in a quart can.

*One gallon unit:* 102 ounces of 336.12A Base in 1 gallon container and 26 ounces of 336.12B Activator in 1 quart can.

**POT LIFE, w/336.12B:** 2-4 hours @ 77°F  
1-2 hours @ 90°F

**WEIGHT PER GALLON:** 10.55 lbs activated

**VOC:** 2.4 lbs./activated gal.

**SOLIDS BY VOLUME:** 68.6% act.

**COVERAGE:** @ 1 mil DFT  
*Theoretical* - 1200 sq. ft./act. gal.  
*Practical* - 965 sq. ft./act. gal.

**RECOMMENDED TOPCOATS:** Coal tar will bleed through if topcoated by other than itself.

**RECOMMENDED THINNER:** No.1, No.13 or No. 71

**RECOMMENDED PRIMERS:** May be applied DTM. For additional corrosion resistance, use Wilko No. 349-08 Primer Organic Zinc Rich. May be applied over existing epoxy primers.

**TEMPERATURE RESISTANCE:** To 300°F dry

**DRYING TIME:** Surface temperature must be at least 5°F above dew point at all times to prevent moisture condensation.

	@ 35°F.:	@ 60°F.:	@ 90°F.:
To Recoat:	8 hours	6 hours	4 hours
Dry Hard:	36 hours	12 hours	8 hours
Full Cure:	14 days	10 days	5 days

Surface temperature must be at least 35°F at application time to prevent entrapment of ice that will lead to holidays, and if sprayed applied, must be free of moisture. Steel that is exposed to sunlight for a few hours will typically have higher temperature than ambient temperature, allowing application at temperature as low as 35°F.

**SURFACE PREPARATION:** 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

**RECOMMENDED DRY FILM PER COAT:** 8-16 mils

*continued on page 2*

**APPLICATION EQUIPMENT:**

*Airless Spray:* Standard airless spray equipment such as Graco Bulldog Hydra-Spray or larger, with 0.018-0.027 inch fluid tip.

*Conventional Spray:* Industrial equipment such as DeVilbiss MBC or JGA, or a Binks 18 or 62 spray gun and a pressure material 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. 336.12A Wilkoon Coal Tar Part A until the material is uniform, then add 1 part Activator No. 336.12B to four parts of Base No. 336.12A and thoroughly stir the mixture for five minutes.
2. Thinning is normally not required when applying with airless spray equipment. For conventional spray, thin only as is necessary for atomization. At lower temperatures, use one quart of No.71 Thinner per activated gallon. Do not add more than 41 ounces of No. 71 Thinner to keep VOC below 3.5#/gal.
3. 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 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 Razor Model M-1.
7. When applying in confined area, ventilate during application and curing to remove solvent vapors.
8. *Brush or Roller:* Application by brush or roller may require multiple application to achieve the desired film thickness. Thin activated material until it is workable for roller or brush application. This method of application is recommended for maximum adhesion over marginally prepared surfaces or if surface condensation is present. Work the brush or roller into the surface in such a way that the surface contaminant is worked into the coating, and in the case of moisture, the brushing action will push the water aside to allow coating to come into contact with the substrate. CAUTION: Do not apply if heavy condensation is present. See Wilko Rep for more information on application over these surfaces.

**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.

**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 cases of exposure.

**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