

COATING RECOMMENDATIONS
With Attached Product Data

Coating System No. 32 A
Interior Tank Lining

For: _____ **Date:** _____

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SURFACE DESCRIPTION Interior of Steel Fuel Storage Tanks operating to 350°F.

COATING SYSTEM 100% High Volume Solids/ High Build Novolac Epoxy Interior Tank Lining For fuels such as gasoline and diesel, strong acids, light crude oil and chemicals.

SURFACE PREPARATION **Preferred:** Round off sharp edges. Remove dirt, oil, grease and other surface contaminants. Abrasive Blast clean to SSPC 5/NACE 1 White Metal Blast. Use 16-40 mesh U.S. Series abrasive to produce 2.0 -3.0 mil anchor profile.

Stripe Coat Application: Thin primer approximately 20% to 30% utilizing specified thinner. Extreme care should be utilized to effectively coat all nuts, bolt threads, crack, crevices, support beam edges and welds edges. Allow 20-minute cure time (solvent flash off) prior to application of initial prime coat.

TOP COAT

Product	332-140 Wilkopon HS Novolac Epoxy Light Gray or other color if required.)
No. Coats	One
Application	Spray. (Cross hatch application method is recommended to achieve uniform/complete coverage and dry film thickness)
Dry Film Thickness	20 mils.
Wet Film Thickness	20 mils.

Holiday/Pin Hole Detection: After coating is applied and cured the entire surface is to be checked to ensure a minimum of 20 mils dry film thickness was achieved. Pin Holes/ Holiday detection should be checked utilizing a wet sponge holiday detector to ensure there are no pinholes in lining. High Voltage (spark testing) @ 100-125 volts/mil

➤ Reference:

NACE Standard RP0188-99 Discontinuity (Holiday) Testing of New Protective Coatings on Conductive Substrates

NACE SP0490-07 Holiday Detection of FBE External Pipeline Coatings

NACE RP0274 High Voltage Electrical Inspection

* Any holiday/pinhole found shall be marked and repaired by lightly sanding the surrounding area and applying a thinned coat (coating thinned by 40-50%) to the pinhole area. After repair apply another coat of novolac epoxy unthinned. Recheck for holidays in repaired and make additional repairs if necessary.

REMARKS: See Technical Data Sheets for mixing and application instructions.

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