WILKO PAINT, Inc.

W I C H I T A, K A N S A S 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON 100% SOLIDS SPRAYABLE COATING
WILKO NO. 332.140

PRODUCT DESCRIPTION: No. 332.140 Wilkopon 100% Solids Sprayable Coating is a two-component special novolac finish designed to withstand rapid temperature changes without developing internal stresses that cause delamination, cracking or peeling. It exhibits excellent resistance to abrasion, water, asphalt, crude oil, grease, gasoline and most chemicals.

TYPICAL USES: Recommended as interior lining and exterior coating for steel and concrete tanks, brine and slurry tanks, chemical and duct lines, stacks and bag houses, and floor coating where chemical spill is prevalent.

COLOR: Light Gray

WEIGHT PER GALLON: 11 pounds Activated

FLASH POINTS: >240°F

VOLUME SOLIDS: 100%

VOC: 0 grams per liter

RECOMMENDED THICKNESS:2-3 coats @10 mils dry per coat

COVERAGE: 160 square feet per 10 mils thickness

SURFACE PREPARATION: Note: For optimal coating performance, take considerable care with surface preparation.

Metal: Remove all oil, grease or scale from the surface, then blast with sharp sand or grit to finish. Use a non-spherical blast medium to give a 2-3 mil profile and to achieve the following surface preparation standards:

Non-chemical Service: SSPC-SP6 Commercial Blast (NACE 3)
*Intermittent Splash or Wear:*SCC-SP10 near White Metal Blast (NACE 2)
Immersion or Abrasive Service: SSPC-SP5 White Metal Blast (NACE 1)

Concrete: Concrete should be aged at least 28 days before coating and the surface should be clean, dry and free of form-release agents silicone water proof coatings and/or curing agents. Sand Blasting or scarification is recommended. Wash down old concrete to remove all residues and neutralize the pH before blasting or scarifying. For severe service, a second wash is recommended.

MIXING PROCEDURES: Note: Do not mix partial kits.

1. Thoroughly mix resin before adding the hardener.
2. Empty the entire amount of the hardener into the resin container. Do not mix in plastic container. Mix ratio is 2 parts of 332.140A to 1 part of 332.140B
3. Mix thoroughly, until uniform in consistency, then continue to mix for an additional 2-3 minutes. Pay special attention to the bottom and the sides of the container to insure complete mixing. Due to the high viscosity of this product, a mechanical mixer is preferred. Use at low speed and keep the mixing blade down in the product to avoid entrapping air. If mixing by hand, use a square cornered, flat implement, such as a standard paint stirring stick.

THINNING: If thinning is necessary, especially at temperatures lower than 60°F add 4 to 6 fl. oz. of MEK to the resin and mix thoroughly before adding the hardener. Note: Do not exceed 10% solvent by volume. Read the Material Safety Data Sheet for MEK (flammable liquid) before using it.

POT LIFE:

Temperature:	Time:
40°F	1 hour and 20 minutes
55°°F	50 minutes
70°F	30 minutes

Do not keep blended coating in the original container unless immediate use is planned. Otherwise, exotherm (heat created during the curing process) will considerably shorten the pot life. Pour the coating into a rolling tray or large aluminum-basting pan. Try to keep the depth of coating in the tray below 3/8".

CAUTIONS:
1. If the ambient temperature is 85°F or higher, pot life may be as short as 20 minutes. Have the working surfaces ready, and mix no more than one gallon of the coating at a time. To increase the pot life under these conditions, put the tray or pan on ice or in ice water. Do not get water or ice in the tray with the coating.
2. The substrate temperature must be no less than 5°F above dew point - the temperature at which moisture will condense on the surface of the substrate - during all blasting and coating procedures.

SERVICE TEMPERATURE: This coating is recommended for the internal lining for off-gas bag houses and tanks. It is capable of 350 °F continuous operation. The coating will yellow after being exposed to 350 °F, but will maintain its integrity.

continued on page 2

CHEMICAL RESISTANCE:

Acetic Acid up to 10%	Hydrogen sulfide *
Ammonium Hydroxide	Water, Brine
Black Liquor	Aromatic & Aliphatic Solvents
Butyl Acetate	Mineral Acids
Butyl Carbitol	Nitric Acid up to 45%
(Most) Chlorides	(Mild) Organic Acids
White Liquor	(Most) Phosphates
Urea Solutions	Phosphoric Acid
1,1,1-Trichloroethane	Potassium Hydroxide*
Hydrochloric Acid	Sodium Hydroxide*
Sulfuric Acid up to 80%	(Most) Sulfides
Gasoline, diesel fuel	Asphalt, Tar, Crude Oil

*Ambient temperatures only

APPLICATION: 332.140 may be sprayed, brushed, rolled or applied by squeegee. Use a medium bristle brush or a non-shed roller (3/8" nap or shorter) designed for use with epoxies. For spray application, use an airless system such as a Binks, DeVilbiss or Graco, with the following specifications as a guideline:

Pump:	40:1 or greater Ratio
Minimum Output	3500 psi
Product Hose I.D.	0.375-.50 inch
Maximum Length	50 feet
Tip Size:	0.028-.035 inch
In-line Filter:	30 mesh

MULTIPLE COATS: Second and subsequent coats must be applied before the previous coat has completely cross-linked. Apply additional coats when the previous coat will still string out (pigtail) and hold its shape when touched. If any slight tack remains, allow the product to cure, then brush blast before applying the next coat.

The same requirement applies when overlapping the seams of the adjacent coating sections to create a continuous protective film. If the coating surface to be overlapped at the seam cannot be brushed use a non-impact means such as power brushing or sanding to create a mechanical profile.

CURE TIME @ 70°F:

Re-coat Window:	1/2 to 3-1/2 hours
Light loading:	12 hours
Immersion (Aqueous)	30 hours
Full or Chemical Service	7 days

SPEED CURING: The cure time varies with temperature variations. If speed curing is desired, cure time can be reduced and product performance enhanced by artificially applying heat during the curing process. A temperature of 150°F for 2 hours is recommended for speed curing before placing the coating into full service.

CLEAN-UP: Use a mixture of MIBK and Butyl Acetate (50/50), No.71 Thinner, or MEK for clean up.

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: This product is not intended for general consumer use. It 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.