

WILKO PAINT, Inc.

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MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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WILKOPON COAL TAR EPOXY WILKO NO. 336.07

PRODUCT DESCRIPTION: No.336.07 Wilkopon 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 when used with 336.07C activator. 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: 19 volumes of Base No. 336.07 to 1 volume of Activator No. 336.07B.

PACKAGING: 5 gallon unit: 4.75 gallons of Base 336.07A in a 5 gal. pail & .25 gallon of Activator No. 336.07B in a quart can. One gallon unit: 1 gallon of Base 336.07A and ½ pint can of 336.07B Activator.

POT LIFE, w/336.07B: 4-5 hours @ 77°F
2-3 hours @ 90°F

WEIGHT PER GALLON: 11 lbs activated

VOC: 2.05 lbs./activated gal.

SOLIDS BY VOLUME: 74.9% act.

COVERAGE: @ 1 mil DFT
Theoretical - 1201 sq. ft./act. gal.
Practical - 961 sq. ft./act. gal.

RECOMMENDED DRY FILM PER COAT: 8-10 mils
16-20 total DFT

TEMPERATURE RESISTANCE: To 300°F dry

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.

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

@ 77°F.: @ 90°F.:

To Recoat: 6 hours 4 hours

Dry Hard: 12 hours 8 hours

Full Cure: 7 days 5 days

At temperatures of 40-70°F., use 336-07C to achieve faster dry.

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

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-SP6. 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.

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 2001 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:

Thinning: Do not use more than 74 ounces of thinner per gallon of activated paint to stay within the AIM VOC limit of 3.8#/gal for industrial maintenance coating.

1. Stir No. 336.07A Wilkopon Coal Tar Part A until the material is uniform, then add 1 part Activator No. 336.07B to 19 parts of Base No. 336.07A and thoroughly stir the mixture for five minutes.

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APPLICATION PROCEDURE: (cont'd)

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.1 Thinner per activated gallon.
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 – the concentration must be below the TLV as stated in the MSDS. The use of a self-contained respirator is recommended.

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.

If inhaled, remove to fresh air. If not breathing, give artificial respiration, preferably mouth to mouth. In case of contact with eyes, flush with plenty of water for 15 minutes and secure medical attention.

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: 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