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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WILKO GATOR-KURE "K" TAR EPOXY
WILKO NO. 336.36

PRODUCT DESCRIPTION: No.336.36 Wilkopon Gator-Kure "K" Tar Epoxy is two component, high solids, flake-glass-reinforced 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 40°F). It has the capability of adhering to damp surfaces and of curing underwater and under high humidity conditions, making it ideal for coating pipes and sealing flanges prior to burying underground. 336.36 is reinforced with Aramid fibers for better application properties and greater abrasion, wear and impact resistance.

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: 1 part of 336.36A to 1 part of 336.36B.

POT LIFE 45 min @ 65°F
35 min @ 77°F
15-30 min @ 90°F
Thinning will extend the potlife of the activated material

WEIGHT PER GALLON: 9.9 lbs activated

VOC: .32 lbs./activated gal.

SOLIDS BY VOLUME: 96% act.

COVERAGE: @ 1 mil DFT
Theoretical - 1540 sq. ft./act. gal.
Practical - 1232 sq. ft./act. gal.

RECOMMENDED DRY FILM PER COAT: 12-16 mils

RECOMMENDED DRY FILM THICKNESS: 16 Mils minimum, 32 mils maximum.

TEMPERATURE RESISTANCE: To 250°F dry

RECOMMENDED PRIMERS: May be applied DTM. For additional corrosion resistance, use Wilko No. 349-10 Primer Organic Zinc Rich. It may be applied over existing epoxy primers.

RECOMMENDED SUBSTRATE: Steel and concrete

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

DRYING TIME: Although this coating is moisture-tolerant during application, avoid exposure to heavy condensation for at least 30 minutes. This coating may be submerged one hour after it is applied. Coated pipes may be buried and backfilled in 1-3 hours. It will continue to fully cure thereafter.

	@ 35°F.:	@ 60°F.:	@ 90°F.:
To Recoat:	may be recoated immediately		
Dry Hard:	36 hours	12 hours	8 hours
Full Cure:	14 days	10 days	5 days

SURFACE PREPARATION: This coating will adhere to superficial rust and marginally prepared metal surfaces. For maximum performance, 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.

APPLICATION EQUIPMENT:
Airless Spray: Standard airless spray equipment such as Graco Bulldog Hydra-Spray or larger, with 0.027-0.030 inch fluid tip. Plural component is preferred.
Conventional Spray: Industrial equipment such as DeVilbiss MBC or JGA, or a Binks 18, 62 or 95 spray gun with an 86 nozzle and a pressure material pot with mechanical agitator. A moisture and oil trap in main air supply line is essential. Some thinning may be required for proper application. Separate pressure regulators for air and fluid pressure are recommended. Activate enough material that can be used in the useable pot life.

APPLICATION PROCEDURE:
1. Stir No. 336.36A Wilkopon Coal Tar Part A until the material is uniform, then add 1 part Activator No. 336.36B to one part of Base No. 336.36A and thoroughly stir the mixture for five minutes. Do not use a mechanical mixer nor mix for more than five minutes as these will shorten the workable potlife of the mixed material. No induction time is necessary.

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APPLICATION PROCEDURE: (cont'd)

2. Thinning is normally not required when applying with paint gloves or mittens or spatula. For airless and conventional spray, thin only as is necessary for atomization. At lower temperatures, use up to one pint of No.71 Thinner per activated gallon.
3. Spray: 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 the 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 Rasor Model M-1.
7. When applying in confined area, ventilate during application and curing to remove solvent vapors.
8. Damp surfaces and areas that are subject to condensation must be dried as much as possible by wiping with a cloth. Immediately apply the coating using mittens or brush, working the material into the residual surface moisture.
9. Rusty areas must be wire brushed to remove loose rust, then use a tack cloth or lint free rag to remove any powdery rust residue. Immediately apply the coating using mittens or brush, working the material into the residual surface rust.
10. When repairing deep-profiled areas, use fiberglass mesh for reinforcement. Apply the first coat, lay the fiberglass and cover with another coat.

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 35°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.

ALTERNATE PRODUCT: Use 336.31 where abrasion, wear and impact resistance is not pertinent.

ORDERING INFORMATION:

Kit Sizes: 1 Gallon, 1 quart, and 1 pint. A Kit consists of 1 container of 336.36A and another container of 336.36B - when mixed together it will yield the kit size. Each kit comes with Parts A and B, one stir stick, and one 2" brush. A can opener will be provided with each boxed kit(s). Containers are partial filled for ease of mixing and for thinning if needed.

For Additional Information Call: Don Holt 918-299-0170
Tim Taylor 316-838-4288

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: 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