WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

POST OFFICE BOX 4089 • 2727 OHIO • PHONE (316)838-4288 • FAX(316)838-6328

HEAT RESISTANT FLAT BLACK WILKO NO. 836.01

PRODUCT DESCRIPTION: No. 836.01 Silicone Flat Black is a zinc free silicone-based heat resistant coating which protects thermally insulated steel from chloride induced stress cracking. This coating is formulated with the least attainable amounts of halides, sulfides, nitrates, and metals which are known to induce embrittlement of austenitic stainless steel. The binder used in this coating is stripped of chlorides to the lowest level possible.

TYPICAL USES: As exterior finish for mufflers, hot piping, exhaust stacks, and process vessels operating to 800°F.

GENERIC TYPE:	Silicone
COLOR:	Flat Black
WEIGHT PER GALLON:	8.9 <u>+</u> .5 lbs
VOC:	4.42 lbs/gallon
HAPS:	4. 13 lbs/gallon
SOLIDS BY VOLUME:	36.4 <u>+</u> 1.0%
COVERAGE: @1 mil DFT	Theoretical - 584sq. ft./gal. Practical - 467 sq. ft./gal.
RECOMMENDED DFT:	0.75 to 1.25 mils per coat 1.5 to 2.5 mils total
DRYING TIME @77°F	To Touch: 1-2 hours To Handle: 3-4 hours To Recoat: 8 hours

Full Cure: Slowly increase service temperature to 350° F to 450° F over a two hour time period before exposing to high operating temperature to obtain optimum properties. Coating will remain thermoplastic for a period of time, especially at temperatures between 150° F and 500° F

RECOMMENDED THINNER: Wilko No. 1, No.8 or No. 13. For lower HAPS use No.158 HAPS Free Thinner.

REDUCTION: This coating is supplied ready-to-spray. It may be thinned as needed for workability, but do not use more than 25% to avoid settling. Use No. 1 or No, 13 for temperatures below 85 °F and use No.13 or No.8 for temperatures above 85°F. AIM RULE: Do not use more than 68 ounces of thinner per gallon of 836.01 to keep VOC level below the AIM limit of 5.4#/gal for high temperature coatings.

CLEAN UP THINNER:

No. 13 or MEK

RECOMMENDED PRIMERS: Material may be applied directly to properly prepared metal. For enhanced corrosion resistance use Wilko No. 809.01 Silicone Primer.

RECOMMENDED SUBSTRATE: May be applied over a variety of steel surfaces including austenitic stainless steel.

SURFACE PREPARATION:

Over Primers: Must abrasive blast clean to conform to NACE#1 or SSPC-SP5 White Metal Blast prior to application of primer. Refer to Product Data of primer for detailed application procedures.

Direct To Metal: Remove grease and oil by wiping surfaces with clean rags soaked in Wilko Thinner No. 13, or using an appropriate degreaser. At temperatures under 500°F, degreasing and application of pretreatment may be sufficient. For difficult to adhere substrates like galvanized steel, stainless steel, aluminum, etc., check for adhesion and use a pretreatment when necessary. An abrasive dry sandblast cleaning conforming to SSPC-SP5 White Metal Blast is required for optimum performance at temperatures above 500°F, regardless of the type of metal.

EQUIPMENT REQUIRED:

Conventional Spray:

1.Pressure pot with dual air regulator.

- 2.Spray gun such as a DeVilbiss MBC with an AV-601 EX fluid tip, 496 DEX needle and 704 or 64 air cap, or Binks No. 18 heavy duty spray gun with a 66 PB nozzle
- 3. A 25-50 foot length of fluid hose $\frac{1}{2}$ inch ID minimum.
- 4. A minimum of 75psi continuous air supply to each spray gun.

Airless Spray: Airless spray equipment with pump ratio of 28:1 or 30:1 and spray tip with orifice diameter of 0.012 to 0.015 should be used.

APPLICATION PROCEDURE:May be applied by brush, roller or spray. Spray application is preferred for production of film depth consistency & optimum cosmetic value. Apply a uniform coat, allowing 2-hour solvent release following each coat (use a cross-coat method). Do not apply excessive thickness to prevent thermal stress that will lead to early coating failure.

Topcoating Inorganic Zinc: The primer must exhibit full cure. Refer to product data, No. 809.01. Apply 1 coat No. 836.01 Silicone Flat Black reduced 50% with No. 1 Thinner, in a full wet tack coat to reduce any pinholing or bubbling. An 8 hour solvent release period must be allowed. Follow with a second coat reduced 1/2 to 1 pint No. 1 Thinner at 1.0-1.5 mils DFT.

ALTERNATE PRODUCT: Use 846.01 in place of 836.01 if a high gloss finish is desired. Use 836.06 if 3.5#/gal is required and for lower HAPS of less than 1#/gal

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 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 airsupplied mask to avoid breathing concentrated vapors in enclosed areas. For additional safety information, refer to Material Safety Data Sheets. 01/18/12