WILKO PAINT, INC.
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COATING RECOMMENDATIONS
With Attached Product Data

Coating System No. 32C
Interior Tank Lining For Food Storage

For: **Date:**

Prepared By: WILKO PAINT, INC.

SURFACE DESCRIPTION Interior of Steel Food Storage Tanks operating to 350*F.

COATING SYSTEM High Solids FDA Approved Novolac Epoxy Interior Lining

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 epoxy novolac 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.

PRIME COAT

Product	331-3215 Wilkopon HS Novolac Epoxy White 332-3215 Wilkopon HS Novolac Epoxy Gray or other color if required.)
No. Coats	One.
Application	Brush, roller or spray.
Dry Film Thickness	10 mils.
Wet Film Thickness	12.00-14.0 mils.

Holiday Detection: After 1st coat is applied the entire surface is to be checked with 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 pin hole area. After repair apply another coat of novolac epoxy unthinned. Recheck for holidays in repaired and make additional repairs if necessary.

TOP COAT

Product	331-3215 Wilkopon HS Novolac Epoxy White 332-3215 Wilkopon HS Novolac Epoxy Gray
No. Coats	One.
Application	Brush, roller or spray.
Dry Film Thickness	10 mils.
Wet Film Thickness	12.00-14.0 mils.

***A Third Coat may be applied if additional dry film milage is desired.**

Holiday/Pin Hole Detection: After 2nd coat is applied the entire surface is to be checked with 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

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

Questions: contact Don L. Holt, VP/Technical Sales @ (918) 299-0170 Wilko Corp. 1-800-658-3799
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