

COATING RECOMMENDATIONS
With Attached Product Data

Coating System No. 32 B
Interior Tank Lining

For:

Date:

Prepared By: WILKO PAINT, INC.-Don Holt

SURFACE DESCRIPTION

Interior of Steel Fuel Storage Tanks operating to 350°F.

COATING SYSTEM

High Solids Novolac Epoxy Interior Lining
For fuels such as gasoline and diesel, strong acids,
and chemicals.

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 primer 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	332-215 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	332-215 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.

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***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

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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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