

Coating Application Guide Easy Kote

RECEIVING OF PRODUCT

- **Protect these products from direct sun and the cold freezing weather. This product can freeze if the temperatures are below 32°F degrees for 24 hours. Freezing will harm the product so care should be taken. The shipping of this material in the cold months requires heated trucks due to the possibility of freezing. Be sure to mention to the freight company that freezing is a problem and any dock time should be monitored to protect the product.**

MIXING ONSITE REQUIREMENTS

- To ensure that the product is thoroughly mixed, use a drum mixer paddle with at least an 8-inch width and agitate with ½ to ¾ horse electric drill for at least 5-10 minutes.
- **In cold weather the viscosity will thicken. Use of drum heaters will help in the application, as it will thin the viscosity of the product. The product should be maintained between 70-80°F degrees. Do not exceed 95 degrees.**
- **In cold weather use a covered area and enclose the sides to help contain the heat, propane heaters or any heating device to control temps in that area only helps control temperature of the drums 70-80°F.**
- In the warmer times of the year use of a covered area is recommended to eliminate the direct sun on the product. Closing the sides in would not be recommended at this time.

PRODUCT SPECIFICATION

- **Potable Water Tanks /** A typical recommendation for Easy Kote Black, Grey, and Red for potable water would be, apply a two-coat system at 8-10 DFT per coat, total film thickness would be 16-20 mils (black, grey and red). Inspect for dry between the coats before moving on to the grey application. Allow 24 hours before adding drinking water to the tank. Inspect the surfaces to ensure a thoroughly dry coating. The use of DH units in cold climates may be necessary.
- **Blast Tanks /** apply one coat system at 6-8 mills dft. Apply forced air immediately and let it dry for at least 12-16 hours. Inspect the surfaces to ensure a completely dry film.

SURFACE PREPARATIONS NEW CONSTRUCTION

- All areas shall be free of Oil, Grease, Wax, Standing Water, Rust or any other surface contaminants prior to application. The standard will be SSPC-SP-1.
- Damage to the pre-construction primer, weld splatter, smoke, soot, sharp edges or other irregularities formed during the construction shall be removed by hand tool cleaned to SSPC-SP-2.
- All surfaces shall be blown down with compressed air and vacuumed or broom-swept to remove dust and other surface containments before coating.

SURFACE PREP FOR REPAIR, BALLAST AND POTABLE WATER

- Removal of all surface containments such as oil, grease, dirt, wax, trash, heavy rust, etc. by using at least 4000-5000 psi pressure wash to clean the surface.
- Dry out the voids by using air horns or whatever means are at your disposal.
- You will be left with a clean surface with a light rust dust. This is acceptable per the manufacturer for application.
- **Ballast Tanks** / Apply Easy Kote Grey at 6-8 mils dft per the application guide below. You can expect years of service without any loss of steel in your voids. Easy Kote will remain flexible for the life of the coating, which usually is the life of the barge. Easy Kote is not suitable for Salt-water usage.
- **Potable Water Tanks** Application over soft coating you would need 4000-5000 psi and wash any old coatings off the surface, remove and dry the tank before applying Easy Kote Black, Grey and Red per the manufacturer's data sheet.
- **Application over old epoxy systems** you should pressure wash with 4000-5000 psi and apply Easy Prep per the data sheet recommendations. Rinse out and remove Prep and water and then dry before applying the Easy Kote Black, Grey and Red per the manufacturer's data sheet.

APPLICATION TIPS, EQUIPMENT AND DRYING RECOMMENDATIONS

- 30:1 airless sprayer
- Winter months, you should insulate any exposed hoses to stop heat loss.
- Ideal tip size should be 23-31 thousandths depending on viscosity, temperatures and time of the year. Smaller tips can be used in summer and larger tips in winter.
- Remove all filters from the system. This includes pencil filters at the gun and surge filters in the pump. This product is very viscous and will plug most filters.
- A drum cover would be beneficial to help keep dirt, trash and any other particles from getting into the product during application.
- Use water if needed to achieve proper spray viscosity. With a Zahn #4 cup using 35-45 seconds as your base line check after agitation is complete. Start with ½ gallon increments of water and check, working out to a maximum of 2 gallons per 55-gallon drum.

- It is recommended to use a wet film guage to determine the amount of product being applied. A good exercise is to apply some material on a piece of scrap steel to get your eyes used to the wet film thickness desired to achieve the dry film thickness
- Forced air ventilation is recommended for at least 12-16 hours in the warmer periods and 18-24 during the winter. A good test to check dryness of the product is to go to the back of the tank and fill the material to see if it moves. It is very important to dry this product; once the film has formed this product will protect the surface.

CLEAN-UP TECHNIQUES

- Flush the lines and pump with water at the end of the day to get any good product out of the lines. This will eliminate loss of material and save money.
- Following this wash with Xylene to clean the lines and pumps.
- Next morning flush the pump and lines with water and follow with product. This will wash any Xylene out of the line before product hits, because Xylene is not compatible with these products.
- You could use WD-40 or any oily cleaner to help remove any residue from the pump and lines. You should be able to reuse this a number of times because the product should separate, this also should help condition your pumps and lines as well.

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