



MARINE - INDUSTRIAL

TECHNICAL DATA

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DETAILED INSTRUCTIONS FOR APPLYING EASY KOTE

- 1). Remove all silt, mill scale, sheet scale, cement, grease and Cathodic Protection. You must be able to see some mother metal. Clean to SP-2. For tanks we recommend first hammering the surface, hand scraping, and then pressure washing to 6000 lbs. or higher (340 BAR). We recommend applying EASY KOTE over at worst a clean tight bonded rusty surface. Royal recommends two simple test prior to application. First using a small hammer, lightly hit the walls, if sheet scale falls off continue to clean. Or as another alternative use a dull putty knife. You should not be able to remove anything from the surface with the putty knife. Second after swiping the walls with your bare hand, you should only have a slight rust stain. All trash should be removed, as well as loose paint, grease and drops of water.
- 2). Pump tanks or voids dry prior to spraying. This product dries by evaporation. Cold temperatures below 45^o F or 7^o C inhibit this evaporation process, so do not spray without a dehumidifier.
- 3). If necessary use an air hose to sweep the surface of excess moisture and remove. For best results use a dehumidifier for several hours prior to application, if weather conditions dictate (below 45^oF or 7^oC). However, a dry surface is preferred.
- 4). Agitate EASY KOTE to ensure it is thoroughly mixed. Add 1-2 gallons of if needed to achieve suitable spray viscosity.
- 5). Use an airless spray gun with a 19 to 24 tip. You may also use a paint pot system with an E tip or smaller. EASY KOTE may be brushed or rolled on but you should always use two coats when applying by brush. **CAUTION:** Have forced air ventilation when applying EASY KOTE and do not immediately close the tank.
- 6). Apply EASY KOTE (Black) to a wet film thickness of 8-10 mils or 200-250 microns. Thoroughly dry the coating for 24 hours with forced ventilation and then apply EASY KOTE (Grey) to a wet film thickness of 8-10 mils or 200-250 microns. Thoroughly dry the second coat for 24 hours with forced ventilation. Do not apply the second coat unless the first coat is dry.

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- 7). Clean equipment with soap and water before drying. After drying use a good penetrating oil (WD40) and let it set for several minutes.
- 8). If the steel is below 8°C (45°F) the air temperature should be raised to 12°C (53°F).
- 9). To prevent EASY KOTE from adhering to skin or boots during application, coat with Vaseline, baby oil or equivalent.
- 10). For void areas that are not used as ballast a single coat of 10-12 mils WFT (250-300 microns) is sufficient. Always inspect for holidays and touch up as necessary.
- 11). When used as a paint primer, clean as per paragraph one. Apply EASY KOTE to a 6-7 mil WFT (150-175 microns) and let dry for four hours at 72°F (22°C). Top coat with water based or waterborne acrylics or urethanes. Test for compatibility first.
- 12). In cold weather store the paint in a heated warehouse. If air temperature is below 45°F (8°C) we recommend using an inline paint heater (Graco, Coverkat, etc.).
- 13). EASY KOTE must be thoroughly inspected by a Royal representative prior to filling tanks.
- 14). It is a good sanitary practice to fill and rinse the tanks prior to use as drinking water.

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