

Section 60.0600 - COATINGS

1.0 PAINTING.

1.1 General. This section covers the requirements for shop and field application of protective coatings and painting. Each painting system shall provide an optimum life expectancy of 10 years from the time of original painting. The environment shall be considered a Severe Environment - Heavy Industrial and Chemical Plant area with high levels of fumes and fallout as defined by SSPC. Coatings are also subjected to seawater attack common for a coastal environment. The optimum life of a coating system will be considered the time until first maintenance painting/touchup should occur, when 3 percent to 5 percent breakdown of the topcoats occurs, before active rusting begins. Surfaces which will be inaccessible after assembly shall be protected for the life of the equipment.

Painting work shall include the protection of surfaces not to be painted and surface preparation, furnishing and applying paint materials, and other work incidental to painting which is required to properly execute the painting work.

All external metallic surfaces of equipment provided under these specifications which is subject to corrosion shall be cleaned and prepared in accordance with the Coating System Data Sheets included at the end of this section, and shall be protected by the specified coatings. Surfaces which will be inaccessible after assembly shall be protected for the life of the equipment.

Piping shall be painted in accordance with JEA's color scheme.

1.2 Scope of Painting. Except for those surfaces excluded hereinafter, all exposed surfaces of all facilities constructed or otherwise incorporated into the scope of work shall be painted.

Exposed surfaces shall mean all interior and exterior surfaces which are not encased or covered by the finished building structure or equipment and which are visible and accessible for painting. In addition, surfaces of equipment and piping to be insulated shall be prime painted with one coat of primer per Coating System Data Sheet E45.

Areas which would be difficult or impossible to paint after all construction is complete shall be painted at a stage during construction when painting is possible.

Abraded or damaged areas of shop primed surfaces shall be cleaned and touchup painted before applying finish paint system. Abraded or damaged areas of shop finish painted surfaces shall be repaired by spot priming and repainting.

Motors and accessories for equipment shall be painted with the same paint system and color specified for the equipment.

Exposed surfaces of electrical conduit, conduit boxes, and fittings shall be painted only where they are adjacent to painted parts of the building structure or equipment. These surfaces shall be painted the same color as the adjacent building surfaces.

1.2.1 Surfaces to be Painted. Exposed surfaces of the interior and exterior of all building structures and components and the exposed surfaces of all equipment, piping, valves, and hangers, unless excluded hereinafter shall be finish painted.

Stainless steel piping and other stainless steel surfaces to be insulated, or exposed to a chloride bearing atmosphere shall be painted in accordance with the paint manufacturers' recommendations.

1.2.2 Surfaces Not to be Painted. Except as otherwise specified or directed by JEA, the surfaces of the following shall not be painted:

Aluminum surfaces.
 Brass.
 Bronze.
 Bus duct enclosures.
 Cable trays and supports.
 Chromium plated metals.
 Concrete floors, sidewalks, curbs, and paving.
 Electrical conductors, insulated or uninsulated.
 Electrical conduits, wireways, and junction boxes (except as otherwise specified).
 Embedments (galvanized).
 Floor plates.
 Gauges.
 Galvanized ductwork, dampers, and fan boxes, unless exposed to view in finished areas.
 Galvanized grating and handrailing.
 Galvanized structural steel.
 Glazing.
 Hardware.
 Light fixtures, except supports.
 Polished or machined surfaces.
 Porcelain enameled surfaces.
 Porcelain bushings.
 Rotating shafts and couplings.
 Rubber belts, skirting, gaskets, and idler disks.
 Stainless steel surfaces.

Bearing surfaces and nameplates shall not be painted, but shall be coated with an easily removable rust-preventive. Sliding surfaces and threads shall not be painted, but shall be properly lubricated. Surfaces to be field welded shall be left unpainted for a distance of 3 inches from the weld and painted after the welding is complete.

1.2.3 Surfaces to be Touchup Painted. Damaged areas of shop painted surfaces shall be repaired by spot priming as required and repainting with materials of a type and color equal to the shop paint system. Repair painting shall be applied as required to produce a finish equal to the shop paint finish.

1.3 Paint Systems. Paint systems shall be in accordance with the following listing. Paint system designations refer to the Coating System Data Sheets at the end of this section:

<u>Material/Equipment Designation</u>	<u>Paint System Designation</u>
Structural steel and miscellaneous metals	System A1
Structural steel and miscellaneous metals not shop finish painted	System A1P
Structural steel and miscellaneous metals in the exposed FGD areas (Slurry Recycle Pump Area)	System A31
<u>Material/Equipment Designation</u>	<u>Paint System Designation</u>

Machinery, equipment, piping, valves, and pipe supports with operating temperatures as indicated

200 to 450° F

System A8

450 to 750° F

System A9

750 to 1,000° F

System A10

Touchup for damaged galvanizing

System A19

Finish for galvanized metals

System A22

Finish for shop primed metals, including doors

System A25F

Pipe support components with operating temperatures below 200° F air handling units and condensing units

System A30

Interior of wastewater tanks

System A58

Masonry and plaster walls

System C1

All chemical waste manholes and all curbed areas listed below. All horizontal surfaces including floor, top of curb, and top of equipment bases and all vertical surfaces of the curb and equipment bases shall be coated.

System C8

Cycle chemical feed equipment area

Drywall

System D1

Interior coating for main steam blow-down tanks

System E12

Electrical equipment, including panels, switchgear, secondary unit substations, motor control centers, transformers, and other similar equipment

System E20

Control Panels

System E21

Machinery, equipment, piping, and valves with operating temperatures below 200° F

System E45

1.4 Materials. Paint materials shall be as indicated on the Coating System Data Sheets at the end of this section.

Paint materials shall be stored in sealed, original labelled containers bearing manufacturer's name, type of paint, brand name, color designation, and instructions for mixing and/or reducing. The manufacturer's recommended application instructions for each type of paint shall be included with each shipment of paint.

Except for catalyzed coatings, all paint shall be factory mixed in correct proportions and consistency suitable for direct application in warm weather without addition of thinners. Pigments shall be fully ground maintaining a soft paste consistency, capable of being readily and uniformly dispersed to a complete homogeneous mixture.

Materials from the same manufacturer shall be applied for all coats in each coating system.

1.4.1 Manufacturers. Except as otherwise acceptable to JEA, coatings shall be formulated and compounded by manufacturers named in the Coating System Data Sheets at the end of this section.

1.4.2 Colors. Finish paint colors will be generally selected from the manufacturer's standard line of colors. Sample boards showing the proposed color scheme for each area shall be prepared and submitted to JEA for color selection. The sample boards shall include samples of each finish material labeled with the manufacturer and color name of each sample. A minimum of three final sample boards shall be submitted after final JEA selection.

1.4.3 Preservative Coatings. Ferrous surfaces which should not be painted and are subject to corrosion shall be protected with preservative coatings. All preservative coatings which are used to protect surfaces of equipment that are exposed to the feedwater or steam shall be completely water soluble. Other surfaces shall be coated with rust-preventive compound, equivalent to Houghton "Rust Veto 344" or Rust-Oleum "R-9." The manufacturer and manufacturer's designation of all preservative coatings proposed to be used shall be submitted to JEA for acceptance prior to application.

Machined surfaces of weld-end preparations and surfaces within 3 inches of field welds shall be coated with consumable rust-preventive coating equivalent to "Deoxalumite" manufactured by Special Chemicals Corp. or "Bloxide" manufactured by Tempil Division of Big Three Industries.

1.4.4 Galvanizing. Galvanizing specified in the detailed specifications will be in accordance with the following requirements.

Structural steel members and steel assemblies shall be "pickled" after all cutting, punching, reaming, drilling, tapping, and other fabrication processes which would damage galvanizing have been completed. The pickling shall be done in accordance with the latest accepted practice and shall continue until all scale, rust, grease, and other impurities have been completely removed. The steel shall then be hot-dip galvanized in accordance with ASTM A123. Where either member to be bolted is galvanized and where required by the detailed specifications, erection and structural bolts shall be galvanized in accordance with ASTM A153.

1.4.5 Manufacturer's Recommended Practices. Storage, surface preparation, and application for coating materials shall be in accordance with the manufacturer's recommendations.

2.0 UNDERGROUND PROTECTIVE COATINGS. The Contractor shall furnish and apply a protective coating to the exterior surface of all underground, buried steel piping.

The exterior surface of buried steel piping shall be cleaned, coated, tested, and handled in accordance with AWWA C203 together with the applicable sections in the appendices of those specifications, or JEA approved equal. The applicable sections of those specifications have been incorporated herein. The interior of the pipe shall be cleaned, grit or sand blasted, and coated in the shop.

2.1 Coatings. The protective coating for the exterior surfaces of steel pipe shall consist of a coat of coal-tar primer, a 3/32 inch thick coating of hot coal-tar enamel, a fibrous glass mat, a 4 mil thick coating of hot coal-tar enamel, a bonded wrap of nonasbestos felt, and a coating of white wash. The exterior surface of pipe to be totally encased in concrete shall be coated with the coal-tar primer only.

2.2 Application. The protective coating shall be applied as specified below.

2.2.1 General. The protective coatings shall be shop applied after fabrication and before erection except for the surfaces at the pipe ends. The coating shall be left off of pipe ends for a distance of approximately 6 inches to permit the welding of joints without injury to the coatings.

After the sections of pipe are welded together, the areas left uncoated and all damaged areas shall be cleaned and coated.

2.2.2 Workmanship. All work shall be done in a thorough workmanlike manner. The entire operation of priming the pipe and heating and applying the coal-tar epoxy and enamel coatings shall be performed under the supervision of and by experienced personnel skilled in the application of coal-tar enamel and coal-tar epoxy coating systems.

2.2.3 Equipment. The Contractor's equipment for all blasting, priming, enameling, and painting shall be designed and manufactured for the specific application and shall be in such condition as to permit applicators to follow the procedure and obtain results prescribed in these specifications.

2.2.4 Preparation of Surfaces. All surfaces of piping shall be thoroughly cleaned in accordance with Steel Structures Painting Council (SSPC) Surface Preparation Specification No. 1, Solvent Cleaning to remove all oil, grease, moisture, dirt, rust, mill scale, weld scale, and other foreign materials prior to the application of any coating. This shall be accomplished by the use of suitable solvents to remove oil and grease, followed by sandblasting. The solvent shall be Xylol or some other suitable coal-tar base solvent. Dirty solvent shall not be used. Dirty and/or oily rags shall also not be used. The Contractor shall place all used solvent and rags in a suitable container and remove them from the site for disposal in an environmentally safe manner.

Exterior surfaces shall be dry grit blasted in accordance with Steel Structures Painting Council (SSPC) Surface Preparation Specification No. 10, Near-White Blast Cleaning. Interior surfaces shall be dry grit blasted in accordance with SSPC-SP5, White Metal Blast-Cleaning. Grit and dust shall be removed thoroughly by blowing before primer is applied.

All other foreign matter not removable by blasting shall be removed by suitable means. Blasted surfaces that rust before a priming coat has been applied shall be cleaned of all rust by buffing or wire brushing or, at the discretion of JEA, shall be reblasted. Adequate air separators shall be used to remove all oil and free moisture from the air supply to the blaster.

After cleaning, the pipe shall be protected from and maintained free of all oil, grease, moisture, and dirt that might fall upon the pipe from whatever source until it has received its final enamel coat. Any pipe showing pits after beginning of blasting shall be set aside immediately, pending examination by JEA, for approval, reconditioning, or rejection.

Blast cleaned surfaces shall be checked for the specified profile depth and degree of cleanliness prior to application of coating materials. Profile depth shall be checked. Degree of cleanliness shall be checked using Swedish Pictorial Standard in accordance with SSPC-Vis-1-92 T.

2.2.5 Priming. All blasted steel surfaces shall be cleaned of dust and grit and shall be primed immediately following blasting and cleaning. The surfaces shall be dry at the time the primer is applied, and no primer shall be applied during rain, fog, or dusty conditions unless protected from the weather by suitable housing.

At the option of the Contractor, the application of the primer shall be by hand brushing, air gun spraying, or spraying and brushing, and shall be in accordance with instructions for application as supplied by the manufacturer of the primer. The apparatus to be used for application of the primer shall be approved by JEA. Spray gun apparatus to be used shall include a mechanically agitated pressure pot and an air separator that will remove all oil and free moisture from the air supply.

The use of coal-tar primer that becomes fouled with foreign substances or has thickened through evaporation of the solvent oils will not be permitted.

After application, the priming coat shall be uniform and free from floods, runs, sags, drips, holidays, or bare spots. Any bare spots or holidays shall be recoated with an additional application of primer. All runs, sags, floods, or drips shall be removed by scraping and cleaning and the cleaned area retouched, or, at the discretion of JEA, all such defects shall be remedied by reblasting and repriming. Suitable measures shall be taken to protect the wet primer from contact with rain, fog, mist, spray, oil, grease, dust, insects, or other foreign matter until completely hardened and the epoxy or enamel coating has been applied.

Any time when moisture collects on the steel, the steel shall be warmed to a temperature of approximately 86° F-100° F for sufficient time to dry the pipe prior to priming. To facilitate spraying and spreading, the primer may be heated and maintained during the application at a temperature of not more than 120° F. In no case shall the coatings be applied when the surface temperature is less than 38° F above the dew point.

The minimum and maximum allowable drying time of the primer between application of primer and application of coal-tar epoxy or enamel shall be in accordance with instructions issued by the manufacturer of the primer unless otherwise directed by JEA. If the epoxy or enamel coat is not applied within the maximum time after priming, as required by the manufacturer or as directed by JEA, the pipe shall be reprimed with an additional light coat of primer, or, at the discretion of JEA, the entire prime coat shall be removed by reblasting and the pipe reprimed.

2.2.6 Preheating of Primed Pipe. When moisture tends to collect on cold pipe, enameling shall be preceded by warming the pipe.

Warming shall be done by any method which will heat the pipe uniformly to the recommended temperature without injury to the primer. Steel temperature of the pipe shall not exceed 160° F.

After heating and while the pipe is at its highest temperature, the inside lining epoxy shall be applied, and then the exterior coatings applied.

2.2.7 Preparation of Coal-Tar Enamel Coating. The enamel shall be heated in approved heating kettles equipped with accurate and easily read thermometers. In addition, JEA reserves the right to provide recording thermometers; such thermometers shall be installed on the heating kettles as directed by JEA and at the expense of the Contractor. Such thermometers will be checked and adjusted by JEA whenever necessary. The charts therefrom shall constitute a basis for acceptance or rejection of any enamel because of improper heating or handling, or both.

The operating or supply kettles, or both, shall be provided in sufficient numbers so that the enamel may be heated and coordinated with the application procedure. No enamel shall be held in the operation kettles at application temperatures for a longer period than recommended by the manufacturer or stated in his instructions. The enamel heated in supply kettles shall not exceed the temperatures and melting periods recommended by the coating manufacturer. Operating kettles shall not be used as a continuous source of supply by adding unmelted enamel during the time they are in use but shall be completely emptied of one charge and cleaned, if necessary, before the next charge of unmelted enamel is added; except when mechanically agitated kettles are used or if the kettle capacity does not exceed 53 gallons. Kettles shall be covered with hinged lids which may be securely fastened down and shall be tightly closed during the heating and application of enamel except for necessary loading and stirring.

The enamel shall be maintained moisture and dirt free at all times prior to, and at the time of, heating and application.

In loading the kettles, the enamel shall be broken into pieces suitable for the heating equipment used.

In heating the enamel, the charge shall be melted and brought up to application temperature as rapidly as possible without injury to the enamel. The temperature at which the enamel will be applied shall be in accordance with the recommendation furnished by the manufacturer.

The hot enamel shall be thoroughly stirred at intervals not exceeding 15 minutes regardless of whether the enamel is being used from kettles or is being held ready for use. Iron paddles shall be used for stirring. Wooden paddles will not be permitted.

Enamel that has been heated in excess of the maximum allowable temperature, or that has been held at application temperature for a period in excess of that specified, shall be condemned and rejected. Fluxing the enamel will not be permitted.

Excess enamel remaining in a kettle at the end of any heat shall not be included in a fresh batch in an amount greater than 10 percent of the batch. Kettles shall be emptied and cleaned frequently as required. The material removed in cleaning the kettles shall be dumped and wasted.

2.2.8 Coal-Tar Enamel Application to Exterior Steel Surfaces. The primed exterior steel surface to be enameled shall be dry and clean at the time the enamel is applied. Any damage occurring to the primer coat shall be repaired by retouching before application of the enamel. The brush strokes of enamel shall be made in the direction of flow. All brush strokes shall overlap and form a continuous coating. The daubing may be done by the double-lap or "shingling" method. The work shall be done in a workmanlike manner, and no indiscriminate smearing of the enamel will be permitted. On all welds the strokes of the first coat of enamel shall be applied along the weld.

The fibrous glass mat shall be applied simultaneously with the first coat of coal-tar enamel. Sufficient tension shall be applied to the roll of fibrous glass mat to embed it in the enamel before the enamel sets or cools. The fibrous glass mat shall not be pulled through the hot enamel to the metal surface. The thickness of the coal-tar enamel under the mat shall be 3/32 inch, and the allowable variation in thickness shall not exceed 4 mils. The mat shall be spiral wrapped smoothly with an overlap of 1/2 inch.

The second coat of hot coal-tar enamel (4 mils minimum thickness) shall be applied over the fibrous glass mat simultaneously with the bonded wrap of nonasbestos coal-tar saturated felt. The coating of whitewash shall then be applied over the nonasbestos felt.

Enameling buckets shall be filled from the heating kettles with ladles or from spigots attached to the kettles and shall not be dipped for filling. Buckets shall be kept clean and free of dirt at all times and shall not be set directly upon the ground or on enameled surfaces but shall be set upon suitable pads or blocks. Buckets shall not be allowed to accumulate excess chilled enamel but shall be kept clean.

Enamel shall not be used from enameling buckets below the minimum temperature specified by the manufacturer.

All drips and splashes of enamel on primed surfaces shall be carefully scraped off before the hand brushed coat of enamel is applied. This pertains particularly where overhead hand enameling is necessary inside of pipe or specials.

Hand enameling daubers shall be of the size best adapted for the work. Daubers shall be made of the best grade of Tampico Fiber set in solid hardwood handles. Mops, sweeps, or knot daubers shall not be used. Long hand horseshoe daubers will be acceptable for large areas and flat work.

The enameled pipe shall not be rolled or supported on its enameled surface until thoroughly cooled and hardened.

After field pressure tests have been completed, the exterior field weld areas and any exterior damaged areas shall be cleaned and primed. When the primer is dry, the surfaces shall be coated to the specified thickness. Enamel shall overlap the coating on each side of the field joint to form a continuous external coating free from defects.

2.3 Testing. Both before and after erection, 100 percent of all coated areas shall be inspected by the Contractor using an electric holiday detector. Holiday detector voltage shall be between 12,000 and 14,000 volts, unless recommended at another voltage setting by the holiday detector manufacturer. Any flaws or holidays found in the coated areas shall be repaired by the Contractor.

2.4 Handling of Coated Pipe. Coated pipe shall be handled with equipment such as stout, wide belt slings and wide padded skids designed to prevent damage to the coating. Bare cables, chains, hooks, metal bars, or narrow skids shall not be permitted to come in contact with the coating.

The Contractor shall use every precaution to prevent damage to protective coating on the pipe. No metal tools or heavy objects shall be unnecessarily permitted to come in contact with the finished coating. Workers will be permitted to walk upon the coating only when necessary, and in case of such necessity the workers shall wear shoes with rubber or composition soles and heels. This shall apply to all surfaces, whether bare, primed, epoxied, or enameled.

Pipe shall be stored along the trench side, supported on wooden timbers placed under the uncoated ends to hold the pipe off the ground.

Pipe shall be hoisted from the trench side to the trench by means of a wide belt sling. Chains, cables, tongs, or other equipment likely to cause damage to the enamel coating will not be permitted, nor will dragging or skidding the pipe. The Contractor shall allow inspection of the coating on the underside of the pipe while suspended from the sling. Any damage shall be repaired before lowering the pipe into the trench.

3.0 SPECIAL CONCRETE COATINGS AND SEALERS.

3.1 General. This article covers special concrete coatings and finishes.

3.2 Coatings. Each of the following surfaces shall receive the specified coating system or equal. Surfaces shall be prepared and the coatings shall be applied in accordance with the manufacturer's instructions:

Surface Coating System

Precast architectural concrete wall panels	C13
Concrete floors and surfaces in the following areas:	C8
Cycle chemical feed areas	

COATING SYSTEM DATA SHEET SYSTEM A1

DESCRIPTION: *Structural Steel and Miscellaneous Metals*

Environmental Zones 1B (exterior, normally dry), 2A (frequently wet by fresh water), 2B (frequently wet by salt water), and 3B (chemical, neutral)

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1 to 2 mils (25 µm to 50 µm) or as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	3 mils (75 µm)	Two component inorganic zinc Class "A" Slip Co-Efficient ("Specification for Structural Joints Using ASTM A325 or A490 Bolts")
TOUCHUP	3 mils (75 µm)	Organic zinc or modified epoxy Power tool clean damaged surfaces only
SECOND COAT	4-6 mils (100-150 µm)	Polyamide epoxy tie coat Apply by mist coat-full coat technique
THIRD COAT	2-3 mils (50-75 µm)	Aliphatic polyurethane
TOTAL SYSTEM	9-12 mils (225-300 µm)	

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Dimetcote 21-9	Amercoat 68HS or Amercoat 385PA	Amercoat 385	Amercoat 450HS
Carboline	Carbo Zinc 11HS	858 or Carbomastic 15LO	893	134HS
Devoe	Catha-Coat 304V	Catha-Coat 303H or Bar Rust 236	Devran 224HS	Devthane 379
Sherwin-Williams	B69VZ1/B69VZ3/ B65W301/B60V30 B69D11	B69A45	B67 Series/B60V3	
Tnemec	90-96	90-97	Series 69	Series 74

**COATING SYSTEM DATA SHEET
SYSTEM A1P**

DESCRIPTION: *Structural Steel and Miscellaneous Metals*

*Environmental Zones 1A (interior, normally dry), 1B (exterior, normally dry),
2A (frequently wet by fresh water), and 2B (frequently wet by salt water)*

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1 to 2 mils (25 to 50 μ m) or as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	3 mils (75 μ m)	Two component inorganic zinc Class "A" Slip Co-Efficient ("Specification for Structural Joints Using ASTM A325 or A490 Bolts")
TOUCHUP	3 mils (75 μ m)	Organic zinc or modified epoxy Power tool clean damaged surfaces only (shop or field applied)
SECOND COAT		
THIRD COAT		
TOTAL SYSTEM	3 mils (75 μ m)	

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Dimetcote 21-9	Amercoat 68HS or Amerlock 400		
Carboline	Carbo Zinc 11HS	858 or Carbomastic 15LO		
Devoe	Catha-Coat 304V	Catha-Coat 303H or Bar Rust 236		
Sherwin-Williams	B69VZ1/ B69VZ3/ B69D11	B69A45		
Tnemec	90-96	90-97		

**COATING SYSTEM DATA SHEET
SYSTEM A8**

DESCRIPTION: *Ferrous Metal Surfaces*

Surface Temperatures from 200 F to 450 F (93 C to 232 C)

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1 to 2 mils (25 to 50 μ m) or as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	3 mils (75 μ m)	Two component inorganic zinc primer
TOUCHUP	3 mils (75 μ m)	Inorganic zinc rich primer Spot blast clean damaged surfaces only (shop or field applied)
SECOND COAT	1.5-2 mils (40-50 μ m)	Silicone aluminum
THIRD COAT		
TOTAL SYSTEM	4.5-5 mils (115-125 μ m)	Follow manufacturer's instructions for curing

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Dimetcote 21-9	Dimetcote 21-9	Amercoat 892HS	
Carboline	Carbo Zinc 11HS	Carbo Zinc 11HS	1248	
Devoe	Catha-Coat 304V	Catha-Coat 304V	HT-10	
Sherwin-Williams	B69AW9	B69AW9	100-A-518	
Tnemec	90-96	90-96	39-661	

**COATING SYSTEM DATA SHEET
SYSTEM A9**

DESCRIPTION: *Ferrous Metal Surfaces*

Surface Temperatures from 450 F to 750 F (232 C to 400 C)

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1 to 2 mils (25 to 50 μ m) or as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	<i>3 mils (75 μm)</i>	<i>Two component inorganic zinc primer</i>
TOUCHUP	<i>3 mils (75 μm)</i>	<i>Inorganic zinc rich primer Spot blast clean damaged surfaces only (shop or field applied)</i>
SECOND COAT	<i>1-2 mils (25-50 μm)</i>	<i>Silicone aluminum</i>
THIRD COAT		
TOTAL SYSTEM	<i>4-5 mils (100-125 μm)</i>	<i>Follow manufacturer's instructions for curing</i>

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Ameron</i>	<i>Dimetcote 21-9</i>	<i>Dimetcote 21-9</i>	<i>Amercoat 892HS</i>	
<i>Carboline</i>	<i>Carbo Zinc 11HS</i>	<i>Carbo Zinc 11HS</i>	<i>4674</i>	
<i>Devoe</i>	<i>Catha-Coat 304V</i>	<i>Catha-Coat 304V</i>	<i>HT-10</i>	
<i>Sherwin-Williams</i>	<i>B69V11/B69D11</i>	<i>B69V11/B69D11</i>	<i>100-A-518</i>	
<i>Tnemec</i>	<i>90-96</i>	<i>90-96</i>	<i>39-1061</i>	

**COATING SYSTEM DATA SHEET
SYSTEM A10**

DESCRIPTION: *Ferrous Metal Surfaces*

Surface Temperatures from 750 F to 1,000 F (400 C to 540 C)

SURFACE PREPARATION: *SSPC-SP10 Near White Metal Blast Cleaning
Profile depth as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	0.5-2 mils (15-50 μm)	Silicone aluminum*
TOUCHUP	0.5-2 mils (15-50 μm)	Silicone aluminum* Spot blast clean damaged surfaces only
SECOND COAT	0.5-2 mils (15-50 μm)	Silicone aluminum
THIRD COAT		
TOTAL SYSTEM	1-4 mils (25-100 μm)	Follow manufacturer's instructions for curing

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	892HS	892HS	892HS	
Carboline	Carbo Zinc 11HS*	Carbo Zinc 11HS	4631	
Devoe	HT-12	HT-12	HT-12	
Keeler & Long	3731	3731	3731	
Sherwin-Williams	100-A-518	100-A-518	100-A-518	
Tnemec	39-1061	39-1061	39-1061	

*Carboline requires 3 mils (75 μm) of two component inorganic zinc instead of silicone aluminum with total system thickness of 4 to 4.5 mils (100-115 μm).

**COATING SYSTEM DATA SHEET
SYSTEM A19**

DESCRIPTION: *Structural Steel and Miscellaneous Metals*

Touchup for Galvanized Surfaces Not to be Finish Painted

SURFACE PREPARATION: *SSPC-SP1 Solvent Cleaning and SSPC-SP3 Power Tool Cleaning.
Remove oil, grease, and loose rust*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	2-3 mils (50-75 μ m)	Organic zinc rich - light gray
TOUCHUP		
SECOND COAT		
THIRD COAT		
TOTAL SYSTEM	2-3 mils (50-75 μ m)	

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Devoe</i>	<i>Catha-Coat 303H Gray</i>			
<i>Keeler & Long</i>	<i>6500</i>			
<i>Subox</i>	<i>Galvanox Type I</i>			
<i>Sherwin-Williams</i>	<i>Zinc Clad Cold Galvanizing</i>			
<i>Tnemec</i>	<i>90-97</i>			
<i>ZRC</i>	<i>ZRC Cold Galvanizing Compound</i>			

**COATING SYSTEM DATA SHEET
SYSTEM A22**

DESCRIPTION: *Galvanized Steel, Sheet Metal, and Piping*

Environmental Zones 1A (interior, normally dry) and 1B (exterior, normally dry)

SURFACE PREPARATION: *SSPC-SP1 Solvent Cleaning and SSPC-SP7 Brush-Off Blast Cleaning
Surface shall be clean and dry as recommended by paint manufacturer.*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	0.5 mil (15 µm) or 2-3 mils (50-75 µm)	Wash primer or Epoxy primer
TOUCHUP	N/A	
SECOND COAT	4 mils (100 µm)	Semi-gloss polyamide epoxy
THIRD COAT	1.5-2 mils (40-50 µm)	Aliphatic polyurethane (exterior surfaces only)
TOTAL SYSTEM	4.5-7 mils (115-175 µm) 6-9 mils (150-225 µm)	Interior Exterior

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron 450HS	Amercoat 385PA	N/A	Amerlock 385	Amercoat 450HS
Carboline	Rustbond Penetrating Sealer	N/A	890	134HS
Devoe	Derran 201H	N/A	Devran 224HS	Devthane 379
Keeler & Long	Not required	N/A	9600	N-1 Series
Sherwin-Williams	Not required	N/A	B67 Series/ B60V3	B65W301/ B60V30
Tnemec	Not required	N/A	Series 69	Series 74

**COATING SYSTEM DATA SHEET
SYSTEM A25F**

DESCRIPTION: *Shop Primed Ferrous Metal Surfaces (Architectural elements)*

Environmental Zones 1A (interior, normally dry) and 3D (chemical, mild)

SURFACE PREPARATION: *SSPC-SP3 Power Tool Cleaning of areas to be touchup painted; Clean and dry as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	<i>Varies</i>	<i>Shop applied. Spot test for adhesion</i>
TOUCHUP	<i>2-3 mils (50-75 μm)</i>	<i>Barrier coat</i>
SECOND COAT	<i>2-3 mils (50-75 μm)</i>	<i>Barrier coat</i>
THIRD COAT	<i>4-6 mils (100-150 μm)</i>	<i>Polyamide epoxy</i>
TOTAL SYSTEM	<i>6-9 mils (150-225 μm)</i>	<i>Not including shop applied first coat</i>

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Ameron</i>	<i>N/A</i>	<i>Amercoat 385PA</i>	<i>Amercoat 385PA</i>	<i>Amercoat 385</i>
<i>Carboline</i>	<i>N/A</i>	<i>893</i>	<i>893</i>	<i>890</i>
<i>Devoe 224HS</i>	<i>N/A</i>	<i>Bar-Ox P-50</i>	<i>Bar-Ox P-50</i>	<i>Devran</i>
		<i>Low VOC</i>	<i>Low VOC</i>	
<i>Keeler & Long</i>	<i>N/A</i>	<i>9600</i>	<i>9600</i>	<i>9600</i>
<i>Sherwin-Williams</i>	<i>N/A</i>	<i>HSB50NZ3</i>	<i>HSB50NZ3</i>	<i>B67 Series/ B60V3</i>
<i>Tnemec</i>	<i>N/A</i>	<i>163</i>	<i>163</i>	<i>163</i>

**COATING SYSTEM DATA SHEET
SYSTEM A30**

DESCRIPTION: *Structural Steel and Miscellaneous Metals*

Environmental Zones 2A (frequently wet by fresh water), 2B (frequently wet by salt water), and 3A, 3B, and 3C (chemical; acidic, neutral, alkaline)

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1 to 2 mils (25 to 50 μ m) or as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	4-6 mils (100-150 μ m)	Polyamide epoxy primer
TOUCHUP	4-6 mils (100-150 μ m)	Polyamide epoxy Power tool clean damaged surfaces only
SECOND COAT	5 mils (125 μ m)	High-build polyamide epoxy
THIRD COAT		
TOTAL SYSTEM	9-11 mils (225-275 μ m)	

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Amercoat 385PA	Amercoat 385PA	Amercoat 385	
Carboline	893	893	890	
Devoe	Devran 224HS	Devran 224HS	Devran 224HS	
Keeler & Long	9600	9600	9600	
Sherwin-Williams	B62W201/ B60V20	B62W201/ B60V20	B62W201/ B60V20	
Tnemec	Series 69	Series 69	Series 69	

**COATING SYSTEM DATA SHEET
SYSTEM A31**

DESCRIPTION: *Structural Steel and Miscellaneous Metals*

Environmental Zones 2A (frequently wet by fresh water), 2B (frequently wet by salt water), and 3A, 3B, and 3C (chemical; acidic, neutral, alkaline)

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1 to 2 mils (25 to 50 μm) as recommended by paint manufacturer*

COATING	DRY FILM THICKNESS	SPECIAL NOTES
FIRST COAT	<i>4-6 mils (100-150 μm)</i>	<i>Polyamide epoxy</i>
TOUCHUP	<i>4-6 mils (100-150 μm)</i>	<i>Polyamide epoxy Power tool clean damaged surfaces only</i>
SECOND COAT	<i>2-5 mils (50-125 μm)</i>	<i>Aliphatic polyurethane</i>
THIRD COAT		
TOTAL SYSTEM	<i>6-11 mils (150-275 μm)</i>	

PRODUCT IDENTIFICATION

MANUFACTURER	FIRST COAT	TOUCHUP	SECOND COAT	THIRD COAT
<i>Ameron</i>	<i>Amercoat 385PA</i>	<i>Amercoat 385PA</i>	<i>450HS</i>	
<i>Carboline</i>	<i>893</i>	<i>893</i>	<i>134HS</i>	
<i>Devoe</i>	<i>Devran 224HS</i>	<i>Devran 224HS</i>	<i>Devthane 379</i>	
<i>Keeler & Long</i>	<i>9600</i>	<i>9600</i>	<i>N-1 Series</i>	
<i>Sherwin-Williams</i>	<i>B58W101/ B58V1</i>	<i>B58W101/ B58V1</i>	<i>B65W301/ B60V30</i>	
<i>Tnemec</i>	<i>Series 69</i>	<i>Series 69</i>	<i>Series 74</i>	

**COATING SYSTEM DATA SHEET
SYSTEM A58**

DESCRIPTION: *Steel Tanks - Interior*

Process Water Immersion

SURFACE PREPARATION: *SSPC-SP5 White Metal Blast Cleaning
Profile depth 2 to 3 mils (50 to 75 μ m) as recommended by coating manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	4-6 mils (100-150 μ m)	Two component epoxy. First coat tinted darker than second coat
TOUCHUP	N/A	
SECOND COAT	4-6 mils (100-150 μ m)	Final coat shall be white
THIRD COAT		
TOTAL SYSTEM	8-12 mils (400-500 μ m)	As recommended by manufacturer

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Amercoat 395	N/A	Amercoat 395	
Carboline	Carboline 891	N/A	Carboline 891	

**COATING SYSTEM DATA SHEET
SYSTEM C1**

DESCRIPTION: *Concrete and Concrete Masonry*

SURFACE PREPARATION: *Clean, dry, and free of contaminants as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	<i>Varies</i>	<i>Masonry filler applied at rate recommended by manufacturer</i>
TOUCHUP	<i>N/A</i>	
SECOND COAT	<i>2-3 mils (50-75 μm)</i>	<i>Acrylic latex (low gloss)</i>
THIRD COAT	<i>2-3 mils (50-75 μm)</i>	<i>Acrylic latex (low gloss)</i>
TOTAL SYSTEM	<i>4-6 mils (100-150 μm)</i>	<i>Not including masonry filler</i>

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Ameron</i>	<i>Amerlock 400BF</i>	<i>N/A</i>	<i>Amercoat 220 SA</i>	<i>Amercoat 220 SA</i>
<i>Carboline</i>	<i>Flexxide Block Filler</i>	<i>N/A</i>	<i>3359</i>	<i>3359</i>
<i>Devoe</i>	<i>Bloxfil 52901</i>	<i>N/A</i>	<i>Devflex 605</i>	<i>Devflex 605</i>
<i>Keeler & Long</i>	<i>6440</i>	<i>N/A</i>	<i>K-3 Series</i>	<i>K-3 Series</i>
<i>Sherwin-Williams</i>	<i>B61W2</i>	<i>N/A</i>	<i>B66W1</i>	<i>B66W1</i>
<i>Tnemec</i>	<i>Series 130</i>	<i>N/A</i>	<i>Series 6</i>	<i>Series 6</i>

**COATING SYSTEM DATA SHEET
SYSTEM C8**

DESCRIPTION: *Cast-in-Place Concrete*

Environmental Zone 3E (chemical; severe including extreme pHs)

SURFACE PREPARATION: *Well cured concrete with surface tensile strength no less than 275 psi (1900 kPa) as required by manufacturer. Concrete shall be brush blasted or acid etched to remove dirt, dust, and laitance. Projections shall be ground*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	<i>Varies</i>	<i>Spray or roller applied primer/saturate as recommended by manufacturer</i>
TOUCHUP	<i>N/A</i>	
SECOND COAT	<i>63 mils (1.6 mm)</i>	<i>Trowel apply base coat. Press fiberglass cloth into base coat. Apply liquid and hardener</i>
THIRD COAT	<i>63 mils (1.6 mm)</i>	<i>Trowel apply topcoat and brush lightly with smoothing liquid</i>
TOTAL SYSTEM	<i>126 mils (3.2 mm)</i>	<i>Not including primer</i>

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Ceilcote</i>	<i>Prime with liquid and hardener (Ceilcrete 695)</i>	<i>N/A</i>	<i>Ceilcrete 695</i>	<i>Ceilcrete 695</i>
<i>Dudick</i>	<i>Primer 27</i>	<i>N/A</i>	<i>Protecto-Line 900</i> <i>Protecto-Line 900 Liquid</i>	<i>Protecto-Line 900</i> <i>S-30 Smoothing Liquid</i>

**COATING SYSTEM DATA SHEET
SYSTEM C13**

DESCRIPTION: *Precast Concrete*

Environmental Zone 1B (exterior, normally dry)

SURFACE PREPARATION: *Clean, dry, and free of contaminants
Spot test before general application*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	<i>Varies</i>	<i>In accordance with manufacturer's recommended application rate. Apply by low-pressure spray</i>
TOUCHUP		
SECOND COAT		
THIRD COAT		
TOTAL SYSTEM	<i>Varies</i>	<i>Distance of rundown from contact point as recommended by manufacturer</i>

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Chemstop</i>	<i>Baracade Silane 20</i>			
<i>Hydrozo Coatings</i>	<i>Hydrozo Enviroseal 20</i>			
<i>ProSoCo, Inc.</i>	<i>Sure Klean Weather Seal SL20</i>			

**COATING SYSTEM DATA SHEET
SYSTEM D1**

DESCRIPTION: *Drywall*

Environmental Zone 1A (interior, normally dry)

SURFACE PREPARATION: *Clean and dry as recommended by manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	<i>0.5-3 mils (15-75 μm)</i>	<i>Primer, sealer, or thinned finish coat as recommended by paint manufacturer</i>
TOUCHUP	<i>N/A</i>	
SECOND COAT	<i>1-2 mils (25-50 μm)</i>	<i>Acrylic latex (low gloss)</i>
THIRD COAT	<i>1-2 mils (25-50 μm)</i>	<i>Acrylic latex (low gloss)</i>
TOTAL SYSTEM	<i>2-4 mils (50-100 μm)</i>	<i>As recommended by paint manufacturer (not including first coat)</i>

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Ameron</i>	<i>Amercoat 220</i>	<i>N/A</i>	<i>Amercoat 220 SA</i>	<i>Amercoat 220 SA</i>
<i>Carboline</i>	<i>Multi-Bond 120</i>	<i>N/A</i>	<i>3359</i>	<i>3359</i>
<i>Devoe</i>	<i>Wondertones 50801</i>	<i>N/A</i>	<i>Devflex 605</i>	<i>Devflex 605</i>
<i>Keeler & Long</i>	<i>4100</i>	<i>N/A</i>	<i>K-3 Series</i>	<i>K-3 Series</i>
<i>Sherwin-Williams</i>	<i>B28W200</i>	<i>N/A</i>	<i>B30W201</i>	<i>B30W201</i>
<i>Tnemec</i>	<i>51-792</i>	<i>N/A</i>	<i>Series 6</i>	<i>Series 6</i>

**COATING SYSTEM DATA SHEET
SYSTEM E12**

DESCRIPTION: *Mechanical Equipment*

Ferrous Surfaces Subject to Corrosion Which Should Not Be Painted

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth as recommended by coating manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	<i>Varies</i>	<i>Water soluble preservative</i>
TOUCHUP		
SECOND COAT		
THIRD COAT		
TOTAL SYSTEM	<i>Varies</i>	<i>Coating thickness and application as recommended by coating manufacturer</i>

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
<i>Ardrox</i>	<i>228-M</i>			
<i>Dubois</i>	<i>200</i>			

**COATING SYSTEM DATA SHEET
SYSTEM E20**

DESCRIPTION: *Electrical Equipment*

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1.5 to 2 mils (40 to 50 μ m) or as recommended by coating manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	2-4 mils (50-100 μ m)	High build epoxy primer
TOUCHUP	N/A	
SECOND COAT	4-5 mils (100-125 μ m)	High gloss polyurethane Indoor Munsell 8.3 G 6.1/.54; outdoor Munsell 5 BG 7.0/0.4
THIRD COAT		
TOTAL SYSTEM	6-9 mils (150-225 μ m)	Interior surfaces shall be white

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Amercoat 385PA	N/A	Amershield	
Carboline	893	N/A	134HS	
Devoe	Devran 224HS	N/A	Devthane 379	
Keeler & Long	9600	N/A	N-1 Series	
Sherwin-Williams	B67H5/ B67V5	N/A	B65W301/ B60V30	
Tnemec			Series 69 N/A	Series 74

**COATING SYSTEM DATA SHEET
SYSTEM E21**

DESCRIPTION: *Control Panels*

Environmental Zone 1A (interior, normally dry)

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1.5 to 2 mils (40 to 50 μ m) or as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	3-4 mils (75-100 μ m)	Recoatible epoxy primer
TOUCHUP	N/A	
SECOND COAT	1.5-2 mils (40-50 μ m)	Low gloss polyurethane
THIRD COAT	1.5-2 mils (40-50 μ m)	Low gloss polyurethane
TOTAL SYSTEM	6-8 mils (150-200 μ m)	Interior surfaces shall be gloss white enamel

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Amercoat 385PA	N/A	450SA	450SA
Keeler & Long	3200	N/A	Y-2 Series	Y-2 Series
Sherwin-Williams	B67H5/B67V5	N/A	F63/V66V44/ R7K94	F63W72/V66V44/ R7K94
Hempel	Hempadur 4563	N/A	Hempathane 5521	Hempathane 5521
Sigma	Sigmacover ZP Primer 7412US		Sigmadur 7530	Sigmadur 7530

**COATING SYSTEM DATA SHEET
SYSTEM E45**

DESCRIPTION: *Miscellaneous Equipment*

Environmental Zones 1B (exterior, normally dry), and 3A, 3B, and 3C (chemical; acidic, neutral, alkaline)

SURFACE PREPARATION: *SSPC-SP6 Commercial Blast Cleaning
Profile depth 1 to 2 mils (25 to 50 μ m) as recommended by paint manufacturer*

<u>COATING</u>	<u>DRY FILM THICKNESS</u>	<u>SPECIAL NOTES</u>
FIRST COAT	3-5 mils (75-125 μ m)	Rust-inhibitive epoxy primer
TOUCHUP	N/A	
SECOND COAT	1.5-2 mils (40-50 μ m)	Aliphatic polyurethane
THIRD COAT		
TOTAL SYSTEM	4.5-7 mils (115-175 μ m)	

PRODUCT IDENTIFICATION

<u>MANUFACTURER</u>	<u>FIRST COAT</u>	<u>TOUCHUP</u>	<u>SECOND COAT</u>	<u>THIRD COAT</u>
Ameron	Amercoat 370	N/A	Amercoat 450HS	
Carboline	893RCP	N/A	134HS	
Devoe	Devran 224HS	N/A	Devthane 379	
Keeler & Long	3200	N/A	N-1 Series	
Sherwin-Williams	B67H5/ B67V5	N/A	B65W301/ B60V30	
Tnemec	65-1211	N/A	Series 74	
Hempel	Hempadur 1556	N/A	Hempathane 55 Series	
International	Interseal 670	N/A	Interthane 990	

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