PAINT SPECIFICATION

1.0 SCOPE

1.1 This specification describes paint coatings designed to resist board range of environment and provide a tough, durable, abrasion resistant surface that will not fade.

1.2 The colors to be used by M/S SARA SAE shall be identified by the numbering system assigned by M/S Asian Paints.

1.3 Protective coating shall be applied to All Sara Products prior to shipment.

2.0 APPROVED SUPPLIER

2.1 M/S Asian Paints (India) Limited
A-11/B-1, Mohan Co-op. Indl. Estate
1st, Floor, Main Mathura Road,
Badarpur, New Delhi-110 044

3.0 GENERAL COATING REQUIREMENTS

3.1 Sequence of Operations: The surface preparation and coating operations shall be performed after final hydrostatic testing has been performed.

3.2 Assembly: The parts to be coated shall be fully assembled unless disassembly is specified on the Sara Drawing or in the Product Assembly and Test Procedure. The areas which are not to be coated such as sealing surfaces and name plates shall be properly masked prior to the beginning of any of the surface preparation or coating operations described in this specification.

3.3 Surface Cleanliness: The surfaces that are to be coated shall be free of surface irregularities, such as, weld spatter, undercuts, slag, rough edges, burrs and laminations. These imperfections shall be removed by machining or grinding or other suitable means prior to surface preparation for the application of the coating system.

3.4 Surface preparation: The surface shall be sweep blasted or power-tool cleaned or hand-tool cleaned to make the surface clean and smooth.

4.0 MATERIAL APPLICATION

4.1 Primer Coat:

4.1.1 The primer coat of PC-1222 is to be applied as soon as possible after blasting and before any visual evidence or rust bloom or contamination appears.

4.1.2 Application is to be by conventional spray: recommended thinner T-131 with volume 0 – 10%.

4.1.3 Mixing ratio by Volume: Base (4): Hardener (1) inductions time none. Stir the base and hardener separately. If settling is observed in the base, loose the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing. Mix hardener gradually into the base continuous stirring.

4.1.4 Pot Life 2 hours at 30 ° C

4.1.5 Color: Red

4.1.6 Gloss: Semi glossy

4.1.7 Volume Solids: Approx. 80%

4.1.8 Recommended dft / coat: 75 – 125 microns.

4.1.9 Drying time at 30 ° C: Surface dry- 6 hours, hard dry – 16 hours, full cure – 7 days.

4.2 Intermediate Coat: (Asian Epoxy H B Coating)

4.2.1 The primer coat shall be dry, and free of dirt, grease or other contamination prior to application of intermediate coat.

4.2.2 Application is to be by conventional spray: recommended thinner T-141 with volume 0 – 15%.

4.2.3 Mixing ratio by Volume: Base (13): Hardener (1) induction time – 30 minutes, Stir the base and hardener separately. If settling is observed in the base, loose the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing. Mix hardener gradually into the base continuous stirring.

4.2.4 Pot Life 8 hours at 30 ° C

4.2.5 Color: Grey

4.2.6 Gloss: Matt

4.2.7 Volume Solids: Approx. 65%

4.2.8 Recommended dft / coat: 60 – 125 microns.

4.2.9 Drying time at 30 ° C: Surface dry- 2 hours, hard dry – 16 hours, full cure – 7 days.

4.3 Finish Coat: (Apcothane CF 674 – Color P.O.Red)

4.3.1 Surface to be coated must be clean and dry and prepared as above.

4.3.2 Application is to be by conventional spray: recommended thinner T-213 with volume 0 – 5%.

4.3.3 Mixing ratio by Volume: Base (4): Hardener (1) induction time – 15 minutes, Stir the base and hardener separately. If settling is observed in the base, loose the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing. Mix hardener gradually into the base continuous stirring.

4.3.4 Pot Life 4 hours at 30 ° C

4.3.5 Color: P. O. Red

4.3.6 Gloss: High Gloss

4.3.7 Volume Solids: Approx. 45%

4.3.8 Recommended dft / coat: 25 – 35 microns.

4.3.9 Drying time at 30 ° C: Surface dry- 1 hour, hard dry – 16 hours, full cure – 7 days.

4.4 Quality assurance requirements

4.4.1 Personnel applying the coating are responsible for following this specification.

4.4.2 Spraying personnel will be responsible for inspecting the film thickness and overall integrity of each coating. When coating thickness is below specification, the unacceptable areas are to receive an additional coat to conform to the specified minimum thickness. If the thickness exceeds the range allowed, it shall be the responsibility of Engineering to determine if the integrity of the coating is endangered.

4.4.3 The adhesion of the applied coating system shall be measured using a test coupon prepared and coated along with the coated parts once each day these coatings are applied. The adhesion measurement shall be performed and a 12 – 15 % - shall be allowed.