

SYSTEM 9



GALVANIZED SURFACES

DOMESTIC FLEET

AREAS TO BE COATED:

New fabrication or repainting of galvanized surfaces (including galvanized derricks).

SURFACE PREPARATION:

1. Pressure detergent wash all surfaces to be painted to remove all surface contaminants. Freshwater rinse to remove all soap residues.
2. Spotblast all corrosion to Near White Metal (SSPC-SP10) and sweepblast all remaining surfaces (SSPC-SP7).
3. If blasting is not possible, power tool clean all corrosion to bare metal (SSPC-SP11).

Coating System								
Coating Sequence	Product Identification	Film Thickness Per Coat		Overcoat interval @ 70°F		Thinner	VOC	% Solids
		Wet	Dry	Min.	Max.			
1st Coat (spot prime bare metal)	Amerlock 400 Haze Green	6 to 8	5 to 6	16 hrs	3 mos	#65	1.5	83
Stripe Coat	Amerlock 400 DODI Gray	6 to 8	5 to 6	16 hrs	3 mos	#65	1.5	83%
2nd Coat	Amerlock 400 Ivory	6 to 8	5 to 6	16 hrs	3 mos	#65	1.5	83%
3rd Coat	Amercoat 450H (colors desired)	3 to 4	2-3	4 hrs	unlimited	#101	2.6	67

1. Stripe coat all weld seams, edges, lips, crevices, nuts, bolts and hard to spray areas.