

Special PSX Application Instructions for Coast Guard Vessels

Revision 3 – May, 2007

1. Application over bare steel

Surface preparation: Steel surfaces can be prepared by abrasive blasting to condition SSPC-SP 6, “Commercial Grade” for new steel and SSPC-SP 10, “Near White Metal” for previously painted or unpainted, pitted steel. Previous blasted surfaces can also be prepared by UHP water jetting to condition SSPC-SP-12, Grade WJ-2L, (light flash rusting). Prior to the application of coatings, the surface should be clean and dry and have a profile of 1.5 – 2.5 mils

Application: By airless spray, conventional spray, HVLP spray or brush/roller, taking care to obtain the proper film thickness.

1 coat Dimetcote 302H @ 3-4 mils DFT

1 mist coat PSX700 @ 1-2 mils DFT

1 coat PSX700 @ 5-6 mils DFT

Optional Epoxy Primer: Amerlock Epoxy (Amerlock 2 for application during sustained ambient temperatures of lower than 90°F, or Amerlock 400 for application during sustained temperatures of higher than 90°F) is available when general substrate conditions following surface preparation (such as deep profile, pitted surfaces), ambient weather conditions or other factors warrant.

1 coat Dimetcote 302H @ 3-4 mils DFT

1 coat Amerlock Epoxy @ 4-6 mils DFT

1 coat PSX700 @ 5-6 mils DFT

2. Applications over bare aluminum

Surface preparation: Aluminum surfaces should be cleaned with a neutral detergent or emulsion cleaner to remove all oil, grease or soap films. The surface may be treated with an approved surface etching compound. A light abrasive blast can also be used to impart a surface profile of 1.5 –2.5 mils. The surface can also be prepared by UHP water jetting to condition WJ-2. It is imperative that a surface profile of 1.5 – 2.5 mils exists prior to the application of coatings.

Application: By airless spray, conventional spray, HVLP spray or brush/roller, taking care to obtain proper film thickness.

Full re-paints or initial applications

System 1

Mist Coat PSX700

1 coat PSX700 @ 5-6 mils DFT

System 2 – use when conditions warrant high film build of anticorrosive

1 coat Amerlock Epoxy @ 4-6 mils DFT

1 coat PSX700 @ 5-6 mils DFT

3. Applications over fiberglass

Option I – PSX direct to fiberglass

Surface Preparation: Experience has shown that PSX 700 can be applied directly to properly prepared fiberglass. Care should be taken to remove all existing wax and possible mould release compound. The surface should be roughened slightly by mechanical or hand abrasion. Abrasive blasting can be used however; care must be exercised in choosing equipment and utilizing this method. The surface should be free of all dust prior to the application of material.

Application: PSX –700 can be applied in one or two coats directly to the fiberglass using conventional spray, airless spray, HVLP spray or brush and roller

One-coat system:

1 Coat PSX 700 @ 7 mils dry. (Application by roller and brush will require 2 applications to get this thickness)

Two-coat system: (to allow sanding between coats)

1 Coat PSX 700 @ 3-4 mils dry

1 Coat PSX 700 @ 3-4 mils dry

Option II – Utilizing an epoxy primer directly to the fiberglass

Surface Preparation: Experience has shown that PSX 700 can be applied directly to properly prepared fiberglass or fiberglass primed with a suitable epoxy primer. Care should be taken to remove all existing wax and possible mould release compound. The surface should be roughened slightly by mechanical or hand abrasion. Abrasive blasting can be used however; care must be exercised in choosing equipment and utilizing this method. The surface should be free of all dust prior to the application of material.

Application: By airless spray, conventional spray, HVLP spray or brush/roller, taking care to obtain proper film thickness.

1 coat Amerlock Epoxy @ 4-6 mils DFT

1 coat PSX 700 @ 4-6 mils DFT

4. Application over previously painted surfaces:

Exceptional care should be exercised when applying PSX 700 over existing coatings systems. Experience has shown that as PSX 700 cures, the forces exerted upon the paint film can result in the delamination of the old system. In cases of questionable coating integrity, it is advised that a test patch of the PSX 700 be applied over the existing system.

All surfaces to be re-painted shall be cleaned completely by the use of Prep 88 Cleaner Mixed at a ratio of one (1) part Prep 88 to two (2) parts fresh water. Surfaces shall be wetted prior to the application of Prep 88 solution, Prep 88 applied in an even and uniform coat (best accomplished with a pump-up garden sprayer) then followed immediately with high pressure fresh water washing @ 3500-5000 PSI. Extreme care should be taken not to allow Prep 88 to dry on the surface before removal with pressure washing.

5. Brushing and Rolling Techniques:

Brushing and/or rolling applications will require 2 coats to achieve a 7 mil DFT. There will be some texture, which is typical of brush and roller applications. This may be minimized by utilizing Amercoat 851 Flow Control Additive and/or by the addition of a small amount of Amercoat 911 Thinner. The use of Amercoat 851 should not exceed ½ pint per gallon when mixed with PSX 700, and small amounts of Amercoat 911 thinner may be added to improve workability. For a smoother appearance, use of a high quality ¼ inch nap roller is recommended. The coating should be applied with smooth, even strokes, taking care not to overwork the material or roll back into partially dried areas. Immediately after rolling, the surface can be lightly tipped off using a high quality natural bristle brush, sweeping in one direction only. This operation is usually accomplished by two persons working as a team.

6. Repair of a Damaged PSX 700 Surface:

When the coating surface of a vessel becomes damaged by either impact or abrasion, an effective repair can be made by using power tools to remove all loose paint and rust. An effort should be made to feather the edges to minimize rough borders. The bare steel should be primed with Amerlock Epoxy. A topcoat of PSX 700 in the required color can then be applied by brush or roller. Care should be taken to apply the material in an even film to avoid excessive film build, drips, runs and sags. PSX 700 is self-priming and can be applied directly to the bare metal in areas that would not be considered a “severe or harsh” environment.

7. Cleaning the PSX 700 Surface:

The PSX 700 surface is relatively easy to clean with fresh water. In the event that the surface becomes stained with exhaust smoke, or other substances, a **non-abrasive biodegradable cleaner** such as PPG Protective and Marine Coatings Prep #88 can be used to remove more stubborn dirt. This in conjunction with a Scotchbrite pad has shown to be a very effective cleaning mechanism.

Unfortunately, repeated abrasive cleanings will degloss the surface making it more difficult to keep clean. Thus using the Scotchbrite pad should be a last resort. **Do not apply wax to the vessel in hopes of making it easier to clean.** This will make the vessel more difficult to clean, as the exhaust will tightly adhere to the waxed surface.

8. Amerlock and PSX700 alternate products

Alternate versions of both Amerlock Epoxy and PSX700 are available to better suit extreme ambient weather conditions. Order material as indicated below:

For application during sustained ambient temperatures of 90°F or lower

Amerlock 2
PSX700FD

Note: Pot Life of Amerlock 2 and PSX700FD is greatly reduced during temperatures over 90°F.

For application during sustained ambient temperatures of 90°F or higher

Amerlock 400
PSX700

Note: Until recently, PSX700 was the standard product and used the “FD” primer; however, problems with greatly reduced pot life during high ambient temperatures deemed it necessary to provide alternate curing agents, as noted above, to suit local conditions.

PSX 700 USCG color availability

Color

700K30010 White,	made to FED 595 Color # 17925
700K10075 CG Spar,	made to FED 595 Color # 10371
700K90000 Black,	made to FED 595 Color # 17038
700K60047 CG Red - Orange,	made to FED 595 Color # 12199
700K40041 CG Blue,	made to FED 595 Color # 15182
700K70003 Red,	made to FED 595 Color # 11105
700K20022 CG Gray,	made to FED 595 Color # 16099

Getting Technical Advice from PPG Protective and Marine Coatings

When Technical advice is required, it is recommended that you work with your local PPG Protective and Marine Coatings sales representative. Should he or she not be available, or this is your first time working with us, listed below are several other sources of information [Fax for all is: (678) 566-2698].

Mr. Jim McCarthy
USA Technical Manager
Phone: (800) 926-3766, ext 311
E-mail: Jim.McCarthy@ppg.com

Mr. Marshall Fayard
Area Technical Service Manager
Phone: (800) 926-3766 ext 309
E-mail: Marshall.Fayard@ppg.com

Mr. Paul Whitehead
Technical Service Manager
Phone: (800) 926-3766 ext 312
E-mail: Paul.Whitehead@ppg.com

Mr. Ron Glover
Technical Service Manager
Phone: (800) 926-3766 ext 329
E-mail: Ron.Glover@ppg.com

Procurement of material from PPG Protective and Marine Coatings

Prompt order processing and shipment is accomplished by ordering materials on our **GSA Multiple Awards Schedule # GF-10F-8896H** via telephone, fax or e-mail through the following Points of Contact, at the following address:

**PPG Protective and Marine Coatings
11605 Vimy Ridge Road
Alexander, AR 72002-1625**

For placement of orders, pricing and inventory information, email uscg@ppg.com or call:

West Coast customers: Phone: 800-257-4667 Fax: 501-455-5791

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Delores Eckwood	220	Delores.Eckwood@ppg.com
Dedie Watkins	211	Dedie.Watkins@ppg.com
Tracey Waddell	219	Tracey.Waddell@ppg.com

For ordering information: Phone: 800-283-6627.

Victoria Chambers 225

Victoria.Chambers@ppg.com

Victoria will be able to answer questions regarding availability and distribution issues. She will also be able to direct you to a local PPG Protective and Marine Coatings representative who will try and work with the local Coast Guard facility in addressing application issues. Additionally, Victoria will be able to put you in contact with your local PPG Protective and Marine Coatings distributor, if your facility has unique storage or delivery requirements.

For overall information and key contact person:

Linda E. Marquez, Government Business Liaison

Phone: 800-926-3766 ext. 306 — Email: Linda.Marquez@ppg.com