PPG Protective & Marine Coatings

Recommendation for paint application of Fresh Water Tanks

1) 7785 Sigmaguard CSF 585,Solvent free amine cured epoxy coating,is to be used for Fresh Water Tanks.For good & proper application,9C and 60:1pump ratio is preferable to be used.

2) The compressor air pressure should be above 6kg/cm2.

3) The nozzle orifice of 0,021inch is recommended.(refer to PDS)

4) All hot works surrounding the tank should be completed before commencement of the tank grit blasting & coating application for the fresh water tanks.

5) Scaffolding is to be erected according to the requirement of its design unit.The minimum distance between any part of staging and the substrate surface shall be about 300mm,and maximum distance shall be about 600mm.

6) The staging pipes and open ends of tubular parts of staging must be capped to avoid dust accumulation.

7) Before any pre-blasting,oil,grease and other contamination shall be removed by degreasing followed by high pressure fresh water washing.

8) The pre-blasting job shall be carried out to make the steel work to be prepared properly only after approval of the steel work, the main sand blasting can be started.

9) After approval of the main sand-blasting, before the application of the paint,the salinity test for the surface to be coated shall be carried out as per ISO 8502-6 (Bresle method) and the result shall be below 10us/cm.)

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10) Stripe-coating should be carried out in the difficult & not accessible areas for spray gun such as scallops,corners, pipes,supports,edges, backside of flat ball bar etc to achieve the specified film thickness. When stripe coating,paint drippings and sagging should be removed immediately.Stripe-coating should be done with brush only and roller is not allowed.

11) The pipes or ducting of heater and ventilation should be clean to avoid any contamination in the tanks.

12) Absolutely,no Thinner should be added.

13) The workers' overalls,shoes,brushes,rollers,etc,should be clean. Good illumination/lighting should be provided during the paint application.

14) The temperature of mixed paint should be between 15--30 degree.If necessary,spray hoses should be cleaned in as short as possible (1length only) pump should be heated.The paint should be mixed properly using clean agitator.

15) Before application,the pump and hose should be thoroughly cleaned by thinner.

16) Minimum substrate temperature should be above 10 degree during the period of application and curing time.The substrate temperature shall be 3 degree above the dew point (DP). During the period of application and curing of the coating, for the first 24 hours the maximum relative humidity (RH) must be 50% or below.

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17) The technical requirement for the paint performance should follow our
Products Data Sheet and Safety Data Sheet.

18) The DFT should be above 300microns,and WFT should be above 360 microns.Thinner cannot be added during application.When spraying, WFT comb should be used to control the wet film.The experienced sprayer should be chosen.

19) During application and curing time,the heater and ventilation equipments should be monitored.Over-pressure in the fresh water tanks should be kept to prevent the paint dust into the tanks.If problem,they must report it immediately.The ventilation pipes must be put to the dead corner.

20) Touch-up job must be carried on carefully after cleaning,and request inspection as soon as possible.After final inspection, the ventilation should be still maintained until completely curing.It is important to protect the tanks from contamination.During ventilation time,nobody can enter into the tanks if not allowed.

21) After curing,the whole tanks should be cleaned and washed according to the procedure.

22) Any detailed information can be obtained from Sigma Product Data Sheet in nearest edition.

Note:
For any concerns & clarification don't hesitate to approach the SigmaTSR.