

1.1	PROCEDURE FOR PAINTING
1.2.1	SURFACE PREPARATION:
1.2.1	Blowing by compressed air should be done for overall cleaning
1.2.2	Clean the surface with Acetone to remove the dry penetration test chemicals.
1.2.3	Clean the surface with General Purpose Thinner (White Spirit)
1.2.4	Emery paper of no. 180 can be used to remove oxide coating.
1.2.5	Wipe the surface with clean cotton cloth.
1.3	GENERAL:
1.3.1	Primer coating should be done on the same day of surface preparation.
1.3.2	All paints, primers & thinners should be stored in original sealed containers with clear identification w.r.t., manufacturer's name, shade, expiry date, and instructions for mixing and application.
1.3.3	Do not use paints after the shelf life has expired.
1.3.4	Open the containers just before application and seal the same immediately after use.
1.3.5	Thoroughly examine the surface to be painted prior to commencement of work. Correct any condition that may adversely affect cleaning & coating application.
1.3.6	Check at each step of painting operation before proceeding with the next step.
1.3.7	Verify that all painted surfaces are free from defects. If any defective area is found, repair and recheck before next operation.
1.3.8	Painting shall not be performed when the temperature is less than 3°C above the dew point of the surrounding air or when the relative humidity of the air is greater than 85%.
1.3.9	Paints shall not be applied within 50mm of edges which will later have to be welded. Such weld areas should be taped for a distance of 50mm on either side of the weld line.
1.4	PAINTING PROCEDURE (for external surface Epoxy/Enamel Paint Shed):
1.4.1	Etch primer: One coat of etch primer shall be applied within 3 – 4 hours after cleaning. Before application of Etch Primer coat, dust should be removed with brush / clean cloths. The thickness of the coat should be 5 – 10 microns.
1.4.2	First coat of primer (AA 56101 for synthetic enamel and AA 56105 for Epoxy Paint): First coat of primer shall be applied by spraying. Thickness of the coat shall be 15 – 20 microns. The painted surface shall be allowed to dry for approx. 4 hours.
1.4.3	Second coat of primer (AA 56101 for synthetic enamel and AA 56105 for Epoxy Paint): Second coat of primer shall be applied after 4 hours by spraying. The painted surface shall be allowed to air dry for approx. 4 hours. Thickness of the coat shall be 15 – 20 microns.

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