

1.1	<b>PROCEDURE FOR PAINTING</b>
1.2.	<b>SURFACE PREPARATION:</b>
1.2.1	Emery paper/Brush of can be used to remove oxide coating whenever required.
1.2.2	Cleaning of structure by water.
1.2.3	Blowing by compressed air should be done for overall cleaning.
1.2.4	Clean the surface with General Purpose Thinner (White Spirit).
1.2.5	Wipe the surface with clean cotton cloth.
1.3	<b>GENERAL:</b>
1.3.1	Paint coating should be done on the same day of surface preparation.
1.3.2	All paints & 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%.
1.4	<b>PAINTING (Epoxy Painting on Galvanized Surface)</b>
1.4.1	<b>Epoxy Painting on Galvanized Surface (RAL 7035):</b> Two to three coats of Epoxy Paint (RAL 7035) shall be applied within 30 min of surface cleaning by spraying. There should be gap in each coat to allowed air dry. The painted surface shall be allowed to air dry for approx. 4 hours. Thickness of each coat shall be 40 – 50 microns. Total DFT of painted surface shall be ≥ 125 microns.
1.5	<b>ACCEPTANCE CRITERIA:</b>
1.5.1	Painted surface shall be visually checked for defects like rundown, bubbles, blisters, wrinkles etc.,and for areas not covered by coat.
1.5.2	Dry Film Thickness (DFT) shall be checked after drying of final coat.
1.5.3	Adhesion test shall be carried out as per ASTM D 3359 – 83
1.6	<b>PRECAUTIONS:</b>
1.6.1	Mix only a sufficient quantity of paint required to be used within 02 hrs as recommended by paint manufacturer.
1.6.2	Does not use lift over paint which progressively hardens and become unusable by adding thinner.
1.6.3	Painted surface if damaged should be re-touched with similar procedure.

PREPARED BY:



APPROVED BY:

