

CITY OF AUSTIN

AUSTIN ENERGY

POWER PRODUCTION

STANDARD SPECIFICATIONS

FOR

CLEANING, SURFACE PREPARATION AND COATING OF
PVC, MASONRY, AND METALLIC SURFACES
FOR NEW CONSTRUCTION OR MAINTENANCE AT
POWER PRODUCTION FACILITIES

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1.0 GENERAL REQUIREMENTS

1.1 SCOPE

1.1.1 This specification is intended to provide requirements for acceptable material, equipment, and practices for the cleaning and preparation of surfaces and for the application of coatings for both new construction and maintenance projects.

1.1.2 Any exceptions, deviations and proposed changes to these requirements shall be pre-approved by the City of Austin, through its Austin Energy Department hereinafter AE, Owner, or Owner's representative.

1.2 CLASSIFICATIONS

Plastics, Woodwork, Masonry and Metallic surfaces at Owner's power production facilities are covered under the requirements of this Specification. Related new installation and maintenance work are governed by this Specification after the effective initial issue date.

1.3 SAFETY

1.3.1 All applicable Federal, State and Local regulations pertaining to safety in the workplace shall be observed in the performance of all work covered by these specifications.

1.3.2 Any and all precautions found in the manufacturer's Product Data and Material Safety Datasheets shall be strictly observed.

1.3.3 The contractor shall become familiar with all applicable AE safety guidelines in effect at the facility where work is to be performed and shall fully comply with all such guidelines.

1.3.4 Procedures and recommendations as found in SSPC-PA Guide 3 shall be strictly followed.

1.4 ENVIRONMENTAL

- 1.4.1 All coatings specified shall be free of lead (<0.01% by weight or volume) and shall contain no chromate pigments.
- 1.4.2 Disposal of containers, waste, rags soiled with coating material or solvent, and waste solvent shall be in accordance with Austin Electric Waste Management policies and with all applicable Federal, State and Local regulations.
- 1.4.3 Contractor shall submit to Owner all product material safety data sheets prior to bringing products on site.

2.0 **APPLICABLE CODES AND STANDARDS**

- 2.1 Paint manufacturer's Product Data Sheets
- 2.2 SSPC's Steel Structures Painting Manual Volume 2, Fifth Edition
- 2.3 ASTM-D4263-83 (test procedures for moisture content in concrete)

3.0 **MATERIALS FOR COATING**

3.1 SELECTION

- 3.1.1 Materials specified in section Appendix A of this specification are to be used without exception or deviation unless approved by Owner.
- 3.1.2 Thinners and reducers shall be those specified by the manufacturer and used only as recommended by the manufacturer's product Data Sheet.
- 3.1.3 Abrasives used shall be clean, dry, properly graded and of an appropriate size to achieve the specified anchor profile for the coating to be applied.

3.2 CONDITION

- 3.2.1 Materials shall be in original-unopened and properly labeled container and shall be stored in accordance with the manufacturer's recommendations as found on the Product Data Sheet.
- 3.2.2 Materials shall be within stated shelf life throughout the duration of the job

3.2.3 Batch numbers and date of manufacture shall be available to the Owner or the Owner's inspector upon request.

4.0 EQUIPMENT

4.1 GENERAL

All equipment, scaffolding, and rigging necessary for the performance of work shall be in good condition and in compliance with all applicable OSHA requirements and all other applicable existing Federal, State and local regulations and AE Safety guidelines.

4.2 ABRASIVE BLASTING EQUIPMENT

4.2.1 Compressors and blasting equipment shall be of sufficient capacity to provide adequate pressure at the nozzle (per nozzle) for abrasive blasting operations.

4.2.2 Compressors and blasting equipment shall have all appropriate moisture and oil traps, regulators and gauges, and shall be in good working order.

4.3 SPRAY EQUIPMENT

4.3.1 Compressors and spray equipment shall be clean, in good working order and shall produce sufficient pressure to satisfy spray application requirements of the product to be applied.

4.3.2 Compressors and spray equipment shall have all appropriate moisture and oil traps, regulators and gauges.

4.3.3 Spray guns, air caps and tips shall be in good condition and shall be the size and type specified for the product to be applied as found on the manufacturer's Product Data Sheet.

5.0 STORAGE, MIXING AND THINNING

5.1 STORAGE

5.1.1 Coating material shall be stored in a covered area, or indoors, and shall be kept between 40°F and 100°F at all times, unless otherwise specified by the manufacturer. Preferred storage temperature is 60°F to 80°F.

5.1.2 If any solvent-based material is to be stored the storage area must be suitable for storage of flammable materials and comply with all applicable codes and regulations.

- 5.13 Storage of coating material in the field, during performance of work shall be such to prevent the coating material from exceeding either minimum or maximum allowable material temperatures as found on the manufacturer's Product Data Sheet for the material being applied. The preferred material temperature, unless otherwise stated by the manufacturer, shall be 77°F.
- 5.14 Storage of abrasives shall be adequate to protect the abrasive from moisture and other contaminants.

5.2 MIXING AND THINNING

- 5.2.1 Coating material shall be mixed in strict accordance with the manufacturers mixing instructions.
- 5.2.2 Partial kit mixing (multiple component material) will not be permitted without prior approval by the manufacturer and the Owner or the Owner's representative.
- 5.2.3 Any approved partial kit mixing shall include written mixing instructions by weight or volume provided by the manufacturer.
- 5.2.4 Thinning of material shall be done only after mixing and shall be in accordance with thinning instructions on manufacturer's Product Data Sheet.
- 5.2.5 Thinners and reducers shall be those specified by the manufacturer and used only as recommended by the manufacturer's Product Data Sheet.

6.0 SURFACE PREPARATION

6.1 GENERAL

- 6.1.1 All surfaces to be coated shall be clean and dry prior to performance of any coatings work.
- 6.1.2 Surfaces indicating oil and/or grease contamination, and all galvanized surfaces, shall be cleaned in accordance with SSPC-SP 1 "Solvent Cleaning" The preferred method of solvent cleaning shall be detergent washing using a solution of **SURFACE CLEANER # 3** or owner approved equal, followed by thorough fresh water rinsing. This shall be accomplished prior to any other surface preparation that has been specified.
- 6.1.3 Existing chalking coatings that are to be over coated shall be high

pressure washed with 3000 psi fresh water and allowed to dry prior to coating application.

- 6.1.4 All sharp edges, corners, and rough welds should be ground to a 1/8" radius. Weld spatter, burs and any other sharp surface irregularities shall be ground smooth prior to any abrasive blast cleaning and as part of any other surface preparation specified for surfaces to be coated.
- 6.15 Surface preparation shall be to the degree specified by the manufacturer's Product Data Sheet or by City of Austin specifications, and shall fully comply with any referenced SSPC standards.
- 6.1.6 After preparation, and before application of any coating, the surface to be coated shall be cleaned of all dust and/or grit generated. For exterior surfaces this may be accomplished by blowing the surface off with clean air. For interior surfaces, sweeping and vacuuming is required.
- 6.1.7 Care should be taken to avoid contamination of the prepared surface by perspiration, fingerprinting, or by introduction of other contaminants from the workers or their equipment (example: dirty shoes or oily hoses).

6.2 GALVANIZED AND STAINLESS STEEL

- 6.2.1 All galvanized and stainless steel surfaces to be coated shall be detergent cleaned as described in Section 6.1.2.
- 6.2.2 Where abrasive blasting is specified to remove corrosion product, it should be limited to that degree necessary to remove visible corrosion product.
- 6.2.3 Where an abrasive "sweep blast" is specified, it should be to the degree necessary to achieve surface roughness without producing more than 2 mils anchor profile or causing damage to the surface.

6.3 FIBERGLASS, FRP MATERIAL AND PVC'S

In addition to any applicable preparation as found in Section 6.1, these materials shall receive light hand sanding prior to coating application.

6.4 CONCRETE AND CONCRETE BLOCK STRUCTURE

- 6.4.1 Concrete block shall be clean, thoroughly dry and free of all loose cementitious material and other foreign matter before the application of any coating.
- 6.4.2 Concrete shall be either abrasive blasted cleaned, acid etched, or mechanically profiled as recommended prior to the application of any

coating.

- 6.4.3 Concrete that has had a curing membrane at its surface, has a glazed finish, or has other product or material at its surface that prevents acid etching from effectively preparing the surface shall be prepared by a mechanical method as recommended or by the manufacturer or as approved by Owner.
- 6.4.4 If concrete or concrete block surfaces have been wetted within 72 hours of a planned application, the surface, shall be tested for dryness as described in ASTM-D4263-83 prior to any coating application.

7.0 APPLICATION OF COATING

7.1. ACCEPTABLE METHODS

- 7.1.1 All coating material shall be applied in accordance with the manufacturer's Product Data Sheet.
- 7.1.2 Procedures and recommendations as found in SSPC-PA shall be followed.
- 7.1.3 Coatings shall be spray applied unless the manufacturer has specifically recommended application by other methods.
- 7.1.4 Block filling material shall be brush or roll applied as required unless application by other methods has been specifically recommended by the manufacturer.

7.2 FILM THICKNESS

- 7.2.1 Each dry film thickness reading shall be within 30% of the specified dry film thickness, and the average of all dry film thickness readings shall be within 15% of the specified dry film thickness.
- 7.2.2 Areas of insufficient film thickness shall be brought up by additional application of material to satisfy requirements described in Section 7.2.1.
- 7.2.3 The use of the "wet gauge" during application shall be required to monitor wet film thickness applied.
- 7.2.4 Except where ineffective, a magnetic type dry film thickness gauge shall be used to check for correct dry film thickness.

7.3 GENERAL

- 7.3.1 All corners, angles, bolt heads and threads and other difficult access areas shall receive one brush-applied coat of the material specified as the first coat. This shall be done in addition to the specified number of coats.
- 7.3.2 Areas inaccessible by spray equipment shall be coated by brush application.
- 7.3.3 Coatings to be applied over inorganic Zinc Primer or "metalized" surfaces shall be applied first as a mist pass. This shall be done in addition to the specified number of coats.
- 7.3.4 When blasting and coating is to be done by section, coating of the blast-cleaned surface should extend no closer than 6 inches from the uncleaned surface.
- 7.3.5 When coating is applied adjacent to previously coated surface, the application should extend over the previous application by 6 inches.
- 7.3.6 Runs, drips, sags, excessive over spray and other application related conditions that adversely affect performance of the coating shall be corrected before approval.
- 7.3.7 Ambient and surface conditions shall be within limits stated in the manufacturer's Product Data Sheet during application, and should be forecast or expected to remain so for at least 4 hours after application. Surface temperature shall be a minimum of 5°F above the dew point for application.
- 7.3.8 Re-coat time, dry to handle time and cure time shall be observed carefully. Additional time, as required shall be allowed when coatings are applied below the reference temperature on the manufacturer's Product Data Sheet (77°F).

8.0 INSPECTION

8.1 GENERAL

- 8.1.1 Inspection will be performed by the Owner, the Owner's inspector or a third party as selected by the Owner to perform inspection.
- 8.1.2 Inspection will be made of the materials to be used, and of the surface prior to performance of any work, during and after surface preparation, and during and after application. A daily inspection report shall be kept.

- 8.1.3 Any work required to correct deficiencies or otherwise unacceptable work shall be subject to re-inspection after correction.
- 8.1.4 Inspection shall verify that all work is performed in accordance with this specification, the manufacturer's Product Data Sheet and any additional specific recommendations made.

9.0 REPAIRS

9.1 GENERAL

- 9.1.1 Work is necessary to correct damage to a newly applied coatings system shall be considered repair.
- 9.1.2 Re-coating over existing (old) coatings systems, when their complete removal is not necessary, shall be considered repair.
- 9.1.3 Repair shall be made with the specified material when correcting damage to new systems, and shall be made with generically same material when repairing existing systems, unless specifically recommended otherwise.

9.2 SPOT REPAIR

- 9.2.1 Prior to any repair work, the surface shall be cleaned as specified at 6.1.1 and 6.1.2 in this specification.
- 9.2.2 All intact coatings around areas of damage or failure shall be feathered by either hand sanding or abrasive blast cleaning prior to the application of material.
- 9.2.3 If corrosion exists, or if damage is to the substrate, the surface shall be spot cleaned to the degree recommended for surface preparation on the manufacturer's Product Data Sheet followed by spot application of each coat of material specified in the system.
- 9.2.4 If damage is to the topcoat only, repair may be made by additional application of the specified topcoat.

9.3 SPOT REPAIR WITH FULL TOPCOAT

- 9.3.1 A spot repair with a full topcoat may be required by the owner when spot repair alone would result in poor appearance.

9.3.2 Coatings that have exceeded a stated maximum re-coat window shall be hand sanded or abrasive sweep blast cleaned prior to re-coating.

9.3.3 Where abrasive sweep blasting is used to promote adhesion a full coat of primer material shall be applied prior to application of the topcoat.

10.0 COATING SYSTEMS SCHEDULE

ITEM NO.	DESCRIPTION	TEMP.	SYSTEM	FINISH COLOR
1	Structure, frames, beams, supports, handrails, stairs, walkways, pipes, valves and fittings.	Ambient	A - Interior B - Exterior	As delineated in main spec.
2	Boiler shell, hot piping, hot valves, stacks, other hot operating machinery and equipment	Ambient to 300 F	C	As delineated in main spec.
3	Hot duct work and stacks	200 F to 800 F	K	As delineated in main spec.
4	Stacks, hot valves, hot piping, boiler access doors, other hot operating surfaces	300Fto1000F	D	As delineated in main spec.
5	Electrical equipment, panels, motors	Ambient	E	As delineated in main spec.
6	Galvanized steel, (structure) decking, beams, supports	Ambient	F	As delineated in main spec.
7	Galvanized steel cabinets, panels, duct work, ladders and hand rails	Ambient	G	As delineated in main spec.
8	Doors, door frames, window frames, control and switch panels, misc. metal finishing	Ambient	G	As delineated in main spec.
9	Water intake piping, screens, piping and structure submerged in water	Ambient	H	As delineated in main spec.
10	Tank shells, exterior	Ambient	B See note (a)	As delineated in main spec.
11	Buildings, exterior, block or masonry	Ambient	I See note (b)	As delineated in main spec.
12	Walls, interior, block or masonry, light duty/low traffic	Ambient	I See note (b)	As delineated in main spec.
13	Walls, interior, block or masonry, heavy duty, high traffic	Ambient	A See note (b)	As delineated in main spec.
14	Buildings, exterior, metal siding	Ambient	J	As delineated in main spec.

a) Tank lining systems will be selected on a case-by-case basis, and will require a separate written specification.

b) A block filler or bug hole material may be required prior to coating application. Contact coating manufacturer to obtain filler material recommendations, (CARBOLINE SANIFILE 100).

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POWER PRODUCTION- **COATING SYSTEM A:**

SURFACE PREPARATION

- A) If paint is in good condition and complete removal is not necessary:
1. High pressure wash to remove all surface contaminants. A detergent cleaner, **CARBOLINE SURFACE CLEANER # 3**, shall be used prior to high pressure washing if oil and/or grease contamination is present, clean water rinse.
 2. Hand tool (SSPC SP-2) and/or power tool clean (SSPC SP-3), as required, any areas of corrosion or coating failure. Care should be taken to feather the edge of the existing intact coating.
- B) If the degree of corrosion or coating failure dictates complete removal of the existing paint:
1. Abrasive blast clean in accordance with SSPC SP-10 "Near White Metal".

PRIMER:

All areas of exposed bare metal shall receive one coat of **CARBOMASTIC 15** Epoxy at 4 – 6 mils dry film thickness.

FINISH:

One finish coat of **CARBOGUARD 893 SG** , if not top coated, epoxy at 3-5 MILS dry film thickness shall be applied over all surface area to paint.

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POWER PRODUCTION - COATING SYSTEM B :

SURFACE PREPARATION

- A) If paint is in good condition and complete removal is not necessary:
 - 1. High pressure wash to remove all surface contaminants. A detergent cleaner, CARBOLINE SURFACE CLEANER # 3, shall be used prior to high pressure washing if oil and/or grease contamination is present, clean water rinse.
 - 2. Hand tool (SSPC SP-2) and/or power tool clean (SSPC-SP-3), as required, any areas of corrosion or coating failure. Care should be taken to feather the edge of the existing intact coating.

- B) If the degree of corrosion or coating failure dictates complete removal of the existing paint:
 - 1. Abrasive blast clean in accordance with SSPC-10 "Near White Metal".

PRIMER:

All areas exposed bare metal shall receive one coat of CARBOMASTIC 15 Epoxy Primer or approved equal, at 4-6 mils dry film thickness. If complete removal of any existing paint has been done, this will be a full prime coat.

INTERMEDIATE COAT:

One full mid coat / tie coat of CARBOLINE 890 Epoxy or approved equal shall be applied over all areas to be painted, 4-6 mils dft.

FINISH:

One finish coat of CARBOTHANE 133 HB Acra-Clad Finish or approved equal, at 3-5 mils dry film thickness shall be applied over all surface areas to be painted.

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POWER PRODUCTION - **COATING SYSTEM C:**

SURFACE PREPARATION

- A) If paint is in good condition and complete removal is not necessary:
 - 1. High pressure wash to remove all surface contaminants. A detergent cleaner, **SURFACE CLEANER # 3** shall be used prior to high pressure washing if oil and/or grease contamination is present.
 - 2. Hand tool (SSPC SP-2) and/or power tool clean (SSPC SP-3), as required, any areas of corrosion or coating failure. Care should be taken to feather the edge of the existing intact coating.

- B) If the degree of corrosion or coating failure dictates complete removal of the existing paint:
 - 1. Abrasive blast clean in accordance with SP-10 "Near White Metal".

PRIMER:

All areas of exposed bare metal shall receive spot prime with **THERMALINE 2977** one coat or approved equal, at 2.5 mils dry film thickness.

FINISH:

One finish coat of **THERMALINE 4900 R** or approved equal, at 1.5-2.0 mils dry film thickness shall be applied over all surface areas to be painted.

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POWER PRODUCTION - COATING SYSTEM D:

SURFACE PREPARATION: Abrasive blast clean in accordance with SSPC-SP-10 "Near White Metal"

PRIMER:

Apply one prime coat of **CARBOLINE THERMALINE 4765** Silicone Zinc or approved equal, at 2 mils dry film thickness.

FINISH:

Apply one finish coat of **CARBOLINE THERMALINE 4700** Silicone Finish or approved equal, at 1.5-2.0 mils dry film thickness.

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POWER PRODUCTION - **COATING SYSTEM E:**

SURFACE PREPARATION

- A) If paint is in good condition and complete removal is not necessary:
1. High-pressure wash to remove all surface contamination.
 2. **SURFACE CLEANER # 3** shall be used prior to high pressure washing if oil and / or grease contamination is present. Clean water rinse.
 3. Hand tool (SSPC SP-2) and /or power tool cleaner (SSPC SP-3) as required any areas of corrosion or coating failure. Care should be taken to feather the edge of the existing intact coating. If the degree of corrosion or coating failure dictates complete removal of the existing paint, then abrasive blast clean in accordance with SSPC SP-6 "commercial".

PRIMER:

All areas of exposed bare metal shall receive one prime spot coat of **CARBOCRYLIC 3358** universal primer or approved equal, at 2-3 mils dry film thickness. If complete removal of any existing paint has been done, this will be a full prime coat.

INTERMEDIATE COAT:

One full mid coat/tie coat of **CARBOCRYLIC 120** universal primer or approved equal, shall be applied over any existing intact coating. No mid coat is required over surface previously primed with **CARBOCRYLIC 120**, 1-2.0 mils, dft.

FINISH:

Apply one finish coat of **CARBOCOAT 30** or approved equal, at 2-3 Film thickness.

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POWER PRODUCTION - COATING SYSTEM F:

This system is for the repair of galvanized steel

SURFACE PREPARATION:

Areas where galvanizing has degraded to the degree that corrosion of the substrate has occurred shall be cleaned by needle gun or by abrasive blast cleaning to remove all corrosion product. Areas of intact galvanizing shall be high pressure washed to remove any surface contaminants. A **SURFACE CLEANER # 3** shall be used prior to high pressure washing if oil and / or grease contamination is present.

PRIMER:

All areas where the zinc galvanizing layer has been damaged or removed shall receive one prime coat of **CARBOMASTIC 15** (spot aluminum) or approved equal, at 3-5 mils dry film thickness. a full coat of **CARBOMASTIC 15** (full) aluminum or approved equal, including application over intact galvanizing, may be applied to achieve uniform appearance, 3-5 mils, dft.

Optional topcoat with **CARBOETHANE 133 HB** for uniform appearance, 3-5 mils, dft.

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POWER PRODUCTION - PAINTING SYSTEM G:

SURFACE PREPARATION:

1. High-pressure wash to remove all surface contaminants. A **SURFACE CLEANER # 3** shall be used prior to high pressure washing if oil and / or grease contamination is present. Clean water rinse. For interior surfaces where the use of high pressure washing equipment is not practical, solvent wiping with a clean rag is acceptable cleaning prior to paint application.
2. Hand tool clean (SSPC SP-3) or hand sand, as required, any areas of corrosion or coating failure. Care should be taken to feather the edge of the existing intact coating

PRIMER:

All areas of exposed bare metal shall receive one prime coat of **CARBOCRYLIC 3358** Universal Primer or approved equal, at 2-3 mils dry film thickness. If complete removal of any existing paint has been done, this will be a full prime coat.

INTERMEDIATE COAT:

One full intermediate of **CARBOCRYLIC 3359** universal primer or approved equal shall be applied over all surface area to be painted 2-3 mils, dft.

FINISH:

Apply one finish coat of **CARBOOTHANE 133 HB** finish or approved equal; at 3-5 mils dry film thickness.

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POWER PRODUCTION - COATING SYSTEM H:

SURFACE PREPARATION:

Abrasive blast clean in accordance with SSPC SP-10 "NearWhite Metal"

PRIMER:

Apply one prime coat of **CARBOLINE'S BUTUMASTIC 300M** or approved equal, at 8 mils dry film thickness.

FINISH:

Apply one finish coat of **CARBOLINE'S BITUMASTIC 300M** or approved equal, at 8 mils dry film thickness.

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POWER PRODUCTION - COATING SYSTEM I:

SURFACE PREPARATION:

Surfaces should be clean, dry and dust free.

PRIMER:

Apply one coat of **CARBOCRYLIC 120** or approved equal, 1-2 mils Dry film thickness (one liberal coat).

FINISH:

Apply one finish coat of **CARBOCRYLIC 3359DTM** for dry fall performance, at 2-3 mils dry film.

New block / brick surfaces – Block filler **SANITILE 100**.

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POWER PRODUCTION-COATING SYSTEM J:

SURFACE PREPARATION

- A) If paint is in *good condition and complete removal is not necessary:
1. High pressure wash to remove all surface contaminants. A **SURFACE CLEANER # 3** shall be used prior to high pressure washing if oil and / or grease contamination is present.
 2. Hand tool (SSPC-SP-2) and / or power tool clean (SSPC SP-3), as required, any areas of corrosion or coating failure. Care should be taken to feather the edge of the existing intact coating.
- B) If the degree of corrosion or coating failure dictates complete removal of the existing paint. Abrasive blast clean in accordance with (SSPC-SP-6) "Commercial grade finish". Care should be taken not to deform light-gauge metal siding material.

PRIMER:

All areas of exposed bare metal shall receive one coat of **RUSTBOND SEALER** or approved equal, at 2 mils dry film thickness.

FINISH:

Apply one finish coat of **CARBOCRYLIC 3359 / 3359 DTM** where a dry fall is needed or approved equal, at 2-3 mils dry film thickness.

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POWER PRODUCTION - COATING SYSTEM K:

SURFACE PREPARATION:

Abrasive blast clean in accordance with SSPC SP-10 "Near White Metal".

PRIMER:

Apply one prime coat of **THERMALINE 2977** or approved equal at 2.5 mils dry mil thickness.

FINISH:

Apply one finish coat of **THERMALINE 2954** or approved equal, at 1.5-2.0 mils dry film thickness.