

McDuffie Paint Specification

Application Procedures for Highland Dry-Fall System

Surface Preparation:

Step I - Pressure wash all surfaces to be coated at 5000 PSI using BH Chem 88 degreasing compound (*available from B&H Distributors; Baton Rouge, LA*) or *approved equal* with potable water to remove all oil, grease, coal dust, coal debris, and other visual impurities. Use the clear tape test to confirm debris cleanliness. Use the water break test to confirm oil and grease removal. If any test is noncompliant, rewash until all tests indicate complete removal.

Step II - Abrasive blast all intact coated surfaces to be painted according to SSPC-SP7 Brush-Off Blast Standard. The edges of any remaining tightly adhered paint will be feather edged. All rusted and loose paint areas will be abrasive blasted to SSPC-SP10 Near White Standard with a 2-3 mil profile.

Step III - All areas that have been abrasive blasted to SSPC-10 Near White Metal Blast will be tested for salts --- chlorides, sulfates, and nitrates according to Chlor*Rid International's surface area test specifications (*see Table 1**) (particularly test areas of corroded steel and at the feathered edge paint/steel interface). Testing will be performed using the CSN Soluble Salts Test Kit available from B&H Distributors. The existing coating that remains after abrasive blast does not require the soluble salt test.

A. If any of these three salts are detectable, pressure wash using Chlor*Rid International Inc.'s Chlor*Rid Concentrate Soluble Salt Remover according to the manufacturer's directions and equipment specifications. Rewash until all tests are compliant.

B. Immediately ! Pressure wash following Chlor*Rid wash using Hold*Blast (according to the manufacturer's directions) from Chlor*Rid International Inc. to assure no flash rusting on the previously abrasive blasted steel surfaces. Do not allow the Chlor*Rid soluble salt remover mixture to dry on the surface prior go applying Hold*Blast.

Coating System Application:

Assure all surfaces to be coated are completely dry and contaminant free with no flash rust. The ambient air temperature is to be a minimum of 5 degrees above the dew point and, a minimum of 45°F. The steel surface is to be a minimum 40°F.

Step I - Spot Prime bare abrasive blasted steel with Highland 475C Series High Performance 2-K Epoxy Dry-Fall Primer at 4-5 mils DFT in strict accordance with the manufacturer's directions. When applying 475C Series by airless application use 2:011 or 3:011 to 4:015 tip size (depending on the surface size to be painted), at 1800 PSI and keep gun tip 12" from the surface.

Step II - Before applying 485C Series Epoxy Dry-Fall DTM allow the following dry times for the 475C Series Epoxy Dry-Fall Primer:

In temperatures above 77°F, allow 1 hour.

In temperatures below 77°F, allow 2 hours.

Recoat within a maximum of 28 days.

Apply 485C Series High Performance 2-K Epoxy Dry-Fall DTM at 5-6 mils DFT in strict accordance with the manufacturer's directions, to spot primed steel and tightly adhered existing coating. When applying 485C Series by airless application use a 2:011 or 3:011 to 4:015 tip size (depending on the surface size to be painted) at 1800 PSI and keep the gun tip 12" from the surface.

Step III - To the areas specified by the Alabama State Port Authority;

Apply Highland 68 Series High Performance 2-K Aliphatic Urethane Dry-Fall Topcoat in strict accordance with the manufacturer's directions at 2-3 mils DFT. This product is to be applied directly over the 485C Series Epoxy Dry-Fall DTM. Before applying 68 Series Dry-Fall Urethane Topcoat allow the following dry times for the 485C Series Epoxy Dry-Fall DTM:

In temperatures above 77°F, allow 1 hour.

In temperatures below 77°F, allow 2 hours.

Recoat within a maximum of 28 days.

When applying 68 Series by airless application use a 2:011 or 3:011 tip size (*depending on the surface size to be painted*), at 1800 PSI and keep the gun tip 12" from the surface.

TABLE 1*

Ft ² (m ²)	# of Tests/1000 sq. ft.
1000 (100)	5
2000 (200)	5+2=7
3000 (300)	5+2+2=9
4000 (400)	5+2+2+2=11
6000 (600)	5+2+2+2+1=12
8000 (800)	5+2+2+2+1+1=13
10000 (1000)	5+2+2+2+1+1+1=14
12000 (1200)	5+2+2+2+1+1+1+1=15
14000 (1400)	5+2+2+2+1+1+1+1+1=16
16000 (1600)	5+2+2+2+1+1+1+1+1+1=17

Paint Color:

International Paint LLC

Product Code: DC379K9500/A5GL

Product Description: DEVTHANE 379 BASE WHITE TINT CMP
STRUCTURAL GREEN

Part A: DC379B9500/5GL

Part B: DC379C0910/1GL