

Surface Preparation: SSPC-SP10 Near White Metal blast cleaning. After surface preparation and prior to painting, all unwelded seams will be filled with Tnemec Series 63-1500 Filler & Surfacer, all welded seams, crevices, and joints between structural members and steel plates must be brushed with a 25% thinned coating of Tnemec Series 20-1255 beige primer. Allow 24 hours minimum dry time before application of full primer coat.

1st Coat: Tnemec Series 91-H2O Hydro-Zinc primer @ 2.5-3.5 dry mils.
Approved Thinners: 41-2 Thinner (spray below 80 degrees F.)
41-3 Thinner (spray above 80 degrees F.)
Or 41-3 Thinner (for brush or roll application)

2nd Coat: Tnemec Series 20-1255 Beige Pota-Pox primer @ 4.0-6.0 dry mils.
Approved Thinner: 41-4 Thinner.

3rd Coat: Tnemec Series 20-15BL Tank White Pota-Pox finish @ 4.0-6.0 mils.
Approved Thinner: 41-4 Thinner.

Total dry film thickness shall be 10.5-15.5 dry mils minimum per SSPC dry film thickness measuring standards. The interior painting system shall be approved by the Virginia State Department of Health and by the EPA, and shall be in accordance with AWWA D 102 and NSF Standards (60/61). The Contractor shall furnish the "Affidavit of Compliance" required by AWWA D 102 to the Project Manager.

B. Exterior Tank Coating Systems

(Spraying shall not be an acceptable method of application for the exterior coating and painting systems.)

1. (Base Bid) System 1

Zinc Primer and Epoxy Intermediate Coat and Polyurethane Finish (Repaint Existing Tank)

Surface Preparation: SSPC-SP6 Commercial Blast Cleaning

1st Coat: Tnemec Series 91-H2O Hydro-Zinc primer @ 2.5-3.5 dry mils.
Approved Thinners: 41-2 Thinner (spray below 80 degrees F.)
41-3 Thinner (spray above 80 degrees F.)
Or 41-3 Thinner (for brush or roll application)

2nd Coat: Tnemec Series 66 Hi-build Epoxoline @ 2.5-3.5 dry mils.
Approved Thinner: 41-4 Thinner.

3rd Coat: Tnemec Series 1074 Endura-Shield @ 2.5-3.5 mils.
Approved Thinners: 41-42 Thinner
Or 41-39 Thinner (for brush or roll

application)

Project: Eugene Drive Tank Painting

Lead Abatement, Cleaning and
Painting Specification