

SPECIFICATIONS FOR: 90,000 Gallon Standpipe
Canterbury Tank
Roanoke County, Virginia

SPECIFICATIONS CONTROLLING DESIGN: AWWA D100-79, AWS D5-2-79, AWWA D102-64

MATERIAL: Plates - ASTM A36
Structural - ASTM A36
Pipe - Standard Weight Black Pipe ASTM A53
Flanges - 150# Raised Face Slip-On ASA B16.5

SURFACE PREPARATIONS OF MATERIALS: All interior surfaces to be sandblasted in accordance with SSPC SP10 (near white blast cleaning.) All exterior surfaces to be sandblasted in accordance with SSPC SP6 (commercial blast cleaning.) Mil profile to be minimum of .75 and maximum of 1.5.

INTERIOR PAINT: After surface cleaning, all interior surfaces shall receive one shop coat of Tnemec 20-1255 Pota-Pox Primer at 4 mils dry film thickness. After field erection and weld out, all welds and abraided areas shall receive one spot coat of 20-1255 Primer over surfaces cleaned to SSPC SP10. After spot priming, all interior surfaces shall receive one finish coat of Tnemec 20-2000 Pota-Pox Finish at 6 mils dry film thickness. Total dry film thickness for primer and finish coat to be minimum of 7 mils at any given test area. Paint to be as manufactured by Tnemec Paint Company, Kansas City, MO.

EXTERIOR PAINT: After surface cleaning, all exterior surfaces shall receive one shop coat of Tnemec 20-1255 Pota-Pox Primer at 4.0 to 6.0 mils dry film thickness. After erection and weld out, all welds and abraided areas to receive one spot coat of 20-1255 Pota-Pox Primer over thoroughly cleaned surfaces. For the finish, all exterior surfaces shall receive one coat Aliphatic Polyurethane Semi-Gloss 71 Color Endura-Shield with a dry film thickness of 1.5 to 2.5 mils. Total mil thickness to be 5.5 to 8.5 mils. Color selection to be made by the Owner.

UNDERSIDE OF BOTTOM PAINT: Shop prime underside of all bottom plates with one coat of Tnemec #20-1255 at 4.0 mils dry film thickness.

STERILIZATION: After the interior paint is sufficiently dry, all interior surfaces to be sterilized in accordance with AWWA C652-86, Section 4.2, Method #2. Use one ounce of HTH per 26 gallon of water to produce a strong solution of 200 ppm, available chlorine. This is accomplished by dissolving the appropriate amount of HTH into a thin paste and adding the paste directly to the 6" of water. After thoroughly mixing this solution, a portable pump is used to spray all interior surfaces and to pump the solution from the tank. Allow a minimum of one (1) hour after draining this strong solution from the tank before filling with potable water.