

\*\*\*\*\*  
USACE / NAVFAC / AFCEA / NASA                      UFGS-09 96 00 (July 2006)  
-----  
Preparing Activity:    NASA                      Superseding  
   UFGS-09 96 00 (April 2006)  
   NASA-09960 (December 2005)

## UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 9 October 2006

Revised - changes not indicated by CHG tags

\*\*\*\*\*

### SECTION TABLE OF CONTENTS

#### DIVISION 09 - FINISHES

##### SECTION 09 96 00

#### HIGH-PERFORMANCE COATINGS

07/06

#### PART 1    GENERAL

- 1.1    REFERENCES
- 1.2    SUBMITTALS
- 1.3    DELIVERY, HANDLING AND STORAGE
- 1.4    FIELD TESTS
- 1.5    PROTECTIONS AND SAFETY PRECAUTIONS
- 1.6    QUALITY ASSURANCE

#### PART 2    PRODUCTS

- 2.1    HEAT-RESISTANT COATINGS
  - 2.1.1    Category 1, 10 to 204 Degrees C 50 to 400 Degrees F
  - 2.1.2    Category 2, 149 to 316 Degrees C 300 to 600 Degrees F
  - 2.1.3    Category 3, 316 to 427 Degrees C 600 to 800 Degrees F
  - 2.1.4    Category 4, 427 to 649 Degrees C 800 to 1,200 Degrees F
- 2.2    EPOXY COATINGS
  - 2.2.1    General
  - 2.2.2    Concrete Surface Coatings
  - 2.2.3    Masonry Surfaces Coatings
  - 2.2.4    Ferrous and Galvanized Metal Surface Coatings
  - 2.2.5    Aluminum Surface Coatings
- 2.3    POLYURETHANE COATINGS
  - 2.3.1    General
  - 2.3.2    Concrete Surface Coatings
  - 2.3.3    Masonry Surface Coatings
  - 2.3.4    Ferrous and Galvanized Metal Surface Coatings
  - 2.3.5    Aluminum Surface Coatings
  - 2.3.6    Wood Surface Coatings
- 2.4    CHLORINATED-RUBBER COATINGS
  - 2.4.1    General
  - 2.4.2    Concrete Surface Coatings
  - 2.4.3    Masonry Surface Coatings

- 2.4.4 Ferrous and Galvanized Metal Surface Coatings
- 2.4.5 Aluminum Surface Coatings

### PART 3 EXECUTION

- 3.1 SURFACE PREPARATION
  - 3.1.1 Concrete Surfaces
    - 3.1.1.1 Concrete Substrates
    - 3.1.1.2 Clay Masonry Substrates
    - 3.1.1.3 Steel Substrates
    - 3.1.1.4 Galvanized-Metal Substrates
    - 3.1.1.5 Aluminum Substrates
    - 3.1.1.6 Wood Substrates
- 3.2 COATING MATERIAL PREPARATION
  - 3.2.1 General
  - 3.2.2 Thinning
  - 3.2.3 Tinting
- 3.3 APPLICATION OF COATING MATERIALS
  - 3.3.1 General
  - 3.3.2 Brush Application
  - 3.3.3 Roller Application
  - 3.3.4 Spray Application
- 3.4 ACCEPTANCE PROVISIONS
  - 3.4.1 Repairing
  - 3.4.2 Cleaning

-- End of Section Table of Contents --

\*\*\*\*\*  
USACE / NAVFAC / AFCEA / NASA                      UFGS-09 96 00 (July 2006)  
-----  
Preparing Activity:    NASA                      Superseding  
   UFGS-09 96 00 (April 2006)  
   NASA-09960 (December 2005)

## UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated 9 October 2006

Revised - changes not indicated by CHG tags

\*\*\*\*\*

### SECTION 09 96 00

#### HIGH-PERFORMANCE COATINGS 07/06

\*\*\*\*\*

NOTE: Delete, revise, or add to the text in this section to cover project requirements. Notes are for designer information and will not appear in the final project specification.

This section covers special coatings as required for harsh indoor locations or operations (any area subjected to chemical and/or abrasive action), and all outdoor installations.

Comments and suggestions on this guide specification are welcome and should be directed to the technical proponent of the specification. A listing of technical proponents, including their organization designation and telephone number, is on the Internet.

Recommended changes to a UFGS should be submitted as a Criteria Change Request (CCR).

Use of electronic communication is encouraged.

Brackets are used in the text to indicate designer choices or locations where text must be supplied by the designer.

\*\*\*\*\*

## PART 1    GENERAL

### 1.1    REFERENCES

\*\*\*\*\*

NOTE: This paragraph is used to list the publications cited in the text of the guide specification. The publications are referred to in the text by basic designation only and listed in this paragraph by organization, designation, date, and title.

Use the Reference Wizard's Check Reference feature when you add a RID outside of the Section's Reference Article to automatically place the reference in the Reference Article. Also use the Reference Wizard's Check Reference feature to update the issue dates.

References not used in the text will automatically be deleted from this section of the project specification when you choose to reconcile references in the publish print process.

\*\*\*\*\*

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

ASTM INTERNATIONAL (ASTM)

IEEE/ASTM SI 10 (2002) American National Standard for Use of the International System of Units (SI): The Modern Metric System

MASTER PAINTERS INSTITUTE (MPI)

MPI (2004) Architectural Painting Specification Manual

THE SOCIETY FOR PROTECTIVE COATINGS (SSPC)

SSPC SP 7 (2000) Brush-Off Blast Cleaning (NACE-No. 4)

U.S. GENERAL SERVICES ADMINISTRATION (GSA)

QPL-TNT-AP-28 (2004) Paint, Aluminum, Heat Resisting (1200 Degrees F)

## 1.2 SUBMITTALS

\*\*\*\*\*

NOTE: Review Submittal Description (SD) definitions in Section 01 33 00 SUBMITTAL PROCEDURES and edit the following list to reflect only the submittals required for the project. Submittals should be kept to the minimum required for adequate quality control.

A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G"

designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy, Air Force, and NASA projects.

Choose the first bracketed item for Navy, Air Force and NASA projects, or choose the second bracketed item for Army projects.

\*\*\*\*\*

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.] [for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] Submit the following in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

#### SD-01 Preconstruction Submittals

Submit [Material, Equipment and Fixture List](#) in accordance with paragraph entitled, "Delivery, Handling and Storage," of this section.

#### SD-03 Product Data

Submit manufacturer's catalog data for the following items including manufacturer's name and identification. Data shall include detailed analysis of each special coating material required for the project, with all the coating constituents measured as percentages of the total weight of the coating. Manufacturer's data concerning application, thinning, and average coverage per [liter gallon](#) shall be included.

[Heat-Resistant Coatings](#)  
[Epoxy Coatings](#)  
[Polyurethane Coatings](#)  
[Chlorinated-Rubber Coatings](#)

#### SD-04 Samples

Submit sample [Color Chips](#) in accordance with paragraph entitled, "Delivery, Handling and Storage," of this section.

#### SD-07 Certificates

Submit certificates for following items showing conformance with the referenced standards contained in this section.

[Heat-Resistant Coatings](#)  
[Epoxy Coatings](#)  
[Polyurethane Coatings](#)  
[Chlorinated-Rubber Coatings](#)

### 1.3 DELIVERY, HANDLING AND STORAGE

Special coating materials must be delivered to the project in their original containers bearing manufacturer's name, descriptive label, and coating formulations. Provide new and unopened containers.

Special coating materials must be stored in tightly closed containers in a covered, well-ventilated area where they will not be exposed to excessive heat, fumes, sparks, flame, or direct sunlight. Protect water-based coatings against freezing.

Solvents, thinners, and equipment cleaners must be stored with the same care as the coating materials with ambient temperatures continuously maintained at a minimum 7 degrees C 45 degrees F.

Submit Material, Equipment and Fixture List consisting of a list of proposed equipment to be used in performance of construction work.

Submit three color chips 75 millimeter by 100 millimeter 3 inch by 4 inch or manufacture pull-down of each finish color and gloss as scheduled.

### 1.4 FIELD TESTS

Government may take dry-film tests from time to time on finished surfaces. Apply additional coatings to surfaces where there is less than the minimum specified dry-film thickness.

### 1.5 PROTECTIONS AND SAFETY PRECAUTIONS

Protect adjacent materials and equipment against damage from spillage, dripping, and spatter of coating materials. Building materials and equipment must be left clean and with all damaged surfaces corrected. Provide "WET PAINT" signs to indicate newly painted surfaces.

Provide forced ventilation for interior spaces during application and drying of coatings to prevent the buildup of toxic or explosive concentrations of solvent vapors.

Provide fire extinguishers of the required quantity and correct type to combat flammable liquid fires.

Dispose of rags that are used to wipe up coating materials, solvents, and thinners by drenching them with water and placing in a covered metal container.

### 1.6 QUALITY ASSURANCE

Comply with Master Painters Institute (MPI) Standards indicated and listed in "MPI Approved Products List." Comply with the requirements in "MPI Architectural Painting Specification Manual" before any project is started.

## PART 2 PRODUCTS

### 2.1 HEAT-RESISTANT COATINGS

\*\*\*\*\*

NOTE: Heat-resistant coatings are divided into four categories, with upper temperature limits of 204 degrees C, 316 degrees C, 427 degrees C and 649

degrees C. 400 degrees F, 600 degrees F, 800 degrees F and 1,200 degrees F

Coatings above 649 degrees C 1,200 degrees F must be ceramic coatings. Generally, coatings applied to substrates where surface temperatures vary radically, will not have a long life span due to vehicle solid degradation and thermoshock of the metallic pigments. In areas such as this, flame deposition of sacrificial metal coatings must be considered.

\*\*\*\*\*

#### 2.1.1 Category 1, 10 to 204 Degrees C 50 to 400 Degrees F

\*\*\*\*\*

NOTE: Use the following for ferrous surfaces where surface temperature will not exceed 204 degrees C 400 degrees F.

\*\*\*\*\*

Coatings for surface temperatures not exceeding 204 degrees C 400 degrees F must be alkyd resin-based material using IEEE/ASTM SI 10. Apply a minimum two coats of coating with a dry-film thickness of a minimum 0.1 millimeter 4 mils.

First coat must be an epoxy zinc primer conforming to MPI, No. 20 with the resin solids and zinc pigment not less than 80 percent of the total weight of the material.

White and color pigmented finish coats must be an alkyd resin-based material with the resin solids and pigments not less than 85 percent of the total weight of the material. Pigments must be heat-stable materials, formulated to colors as scheduled.

Black-pigmented finish coats must be an alkyd resin, carbon-black pigmented material with resin solids and pigments not less than 50 percent of the total weight of the material.

Aluminum pigmented finish coats must be an alkyd resin-based material with resin solids and pigments not less than 50 percent of the total weight of the material.

#### 2.1.2 Category 2, 149 to 316 Degrees C 300 to 600 Degrees F

\*\*\*\*\*

NOTE: Use the following for ferrous surfaces where surface temperature will not exceed 316 degrees C 600 degrees F.

\*\*\*\*\*

Coatings for surface temperatures not exceeding 316 degrees C 600 degrees F must be based on modified silicone and silicone-based resins. Coatings must be applied in not less than two coats with a dry-film thickness of not less than 0.07 millimeter 3 mils.

Provide a silicone-based resin zinc-pigmented material with the resin solids and zinc pigment for the first coat not less than 80 percent of the total weight of the material.

Color pigmented finish coats must be silicone-based resin material with the resin solids and pigments not less than 80 percent of the total weight of the material. Pigments must be heat-stable materials, formulated to colors as scheduled.

Black-pigmented finish coat must be a silicone-based resin carbon-black pigmented material with resin solids and pigments not less than 50 percent of the total weight of the material.

Aluminum-pigmented finish coats must be modified, silicone-based-resin material with the resin solids and pigments not less than 50 percent of the total weight of the material.

#### 2.1.3 Category 3, 316 to 427 Degrees C 600 to 800 Degrees F

\*\*\*\*\*  
NOTE: Use the following for ferrous surfaces where  
surface temperature will not exceed 427 degrees C  
800 degrees F.  
\*\*\*\*\*

Provide a modified silicone or a silicone-based material of coating for surface temperatures not exceeding 427 degrees C 800 degrees F. Apply a minimum two coats with a dry-film thickness of a minimum 0.07 millimeter 3 mils.

Provide a silicone-based resin, zinc-pigmented material first coat with the resin solids and zinc pigment for the first coat not less than 80 percent of the total weight of the material.

Black-pigmented finish coat must be a silicone-based resin, carbon-black pigmented material with resin solids and pigments not less than 50 percent of the total weight of the material.

Aluminum-pigmented finish coat must be a modified, silicone-based-resin material with the resin solids and pigments not less than 50 percent of the total weight of the material.

#### 2.1.4 Category 4, 427 to 649 Degrees C 800 to 1,200 Degrees F

\*\*\*\*\*  
NOTE: Use the following for ferrous surfaces where  
surface temperature will not exceed 649 degrees C  
1,200 degrees F.  
\*\*\*\*\*

Coatings for surface temperatures not exceeding 649 degrees C 1,200 degrees F must be an aluminum-pigmented, silicone-resin-based material using IEEE/ASTM SI 10 and conforming to QPL-TNT-AP-28, as modified.

Apply a minimum two coats with a dry-film thickness of a minimum 0.05 millimeter 2 mils.

Coating pigment must contain a minimum of 28 percent aluminum based on the total weight of the material. Vehicle must contain a minimum of 22 percent silicone resin and a maximum of 49 percent of volatile thinners and driers based on the total weight of the material.



## 2.2 EPOXY COATINGS

\*\*\*\*\*

NOTE: Epoxy resin coatings must be used where surfaces to be coated require high corrosion resistance, chemical resistance, bond strength, UV resistance, and toughness.

Amine-cured epoxy coatings have higher resistance to chemical attack and better color retention than polyamide-cured epoxy coatings. Polyamide-cured epoxy coatings have higher water resistance and bond strength than amine-cured coatings.

\*\*\*\*\*

### 2.2.1 General

Conform to MPI, No. 116 for epoxy coatings and epoxy block filler, as modified.

\*\*\*\*\*

NOTE: Dry-film thickness given must be considered minimum and may be revised as required to suit conditions and surface use.

\*\*\*\*\*

Vehicle resins for finish coats must be based on a polyamide-cured, epoxy-resin material. Apply finish coats with a dry-film thickness of not less than 0.1 millimeter 4 mils per coat. Finish color and gloss must be as indicated.

### 2.2.2 Concrete Surface Coatings

Apply a [epoxy coating system in conformance with MPI, No. 77] [water-based epoxy coating system in conformance with MPI, No. 115] for vertical concrete surfaces. Apply an epoxy slip-resistant deck coating system in conformance with MPI, No. 82. Prime coat must fill concrete surface pores with a total dry-film thickness of not less than 0.05 millimeter 2 mils.

### 2.2.3 Masonry Surfaces Coatings

Apply a [Water-Based, Light-Industrial Coating System in conformance with MPI, No. 110] [Epoxy Coating System in conformance with MPI, No. 77] [Water-Based Epoxy Coating System in conformance with MPI, No. 115] [Polyurethane, Pigmented, Over Epoxy Coating System in conformance with MPI, No. 72]. Block filler must fill surface pores with a total dry-film thickness of not less than 0.2 millimeter 7 mils.

### 2.2.4 Ferrous and Galvanized Metal Surface Coatings

Coatings on ferrous and galvanized metal surfaces must be a prime coat and not less than two finish coats. Comply with MPI, No. 101 for an epoxy zinc primer with a metallic-zinc pigment for the substrate to be coated and the end use of the coated surface. Resin solids and zinc pigment must not be less than 80 percent of the total weight of the coating material. Apply prime coat with a total dry-film thickness of not less than 0.1 millimeter 4 mils. Provide an epoxy-based finished coat as specified.

### 2.2.5 Aluminum Surface Coatings

Apply an Epoxy Coating System in conformance with MPI, No. 80 and MPI, No. 77. Apply prime coat with a total dry-film thickness of not less than 0.1 millimeter 4 mils.

## 2.3 POLYURETHANE COATINGS

\*\*\*\*\*

NOTE: Polyurethane-based coatings must be used where surfaces to be coated require high abrasion resistance, good flexibility and chemical resistance, UV resistance, and must be a two-part, prepolymer, catalytic-cured resin material.

The two-part prepolymer, catalytic-cured, resin based materials must be used for heavy-duty coatings where abrasion resistance and chemical resistance are required. Catalytic-cured resins are formulated as clear coatings and in a limited range of pigmented coatings.

\*\*\*\*\*

### 2.3.1 General

Polyurethane coatings must use IEEE/ASTM SI 10 and conform to MPI for each substrates indicated.

\*\*\*\*\*

NOTE: Dry-film thickness given must be considered minimum and may be revised as required.

\*\*\*\*\*

Vehicle resins for finish coats must be based on a two-part, prepolymer, catalytic-cured, polyurethane material. Apply catalytic-cured coatings with a total dry-film thickness of not less than 0.25 millimeter 10 mils per coat. Indicate finish color and gloss on the schedules.

### 2.3.2 Concrete Surface Coatings

\*\*\*\*\*

NOTE: Policy is to avoid coating of exposed concrete unless it is considered aesthetically desirable.

\*\*\*\*\*

Apply a [Polyurethane, Pigmented Coating System in conformance with MPI, No. 72 and MPI, No. 80] [Polyurethane, Clear, Two-Component Coating System in conformance with MPI, No. 78]. Prime coat must fill surface pores with a total dry-film thickness of not less than 0.05 millimeter 2 mils. Finish coats must be a polyurethane-based material as specified.

### 2.3.3 Masonry Surface Coatings

Apply a Polyurethane, Clear, Two-Component Coating System in conformance with MPI, No. 78. Block filler must fill surface pores with a total dry-film thickness of not less than 0.2 millimeter 7 mils. Finish coats must be a polyurethane-based material as specified.

#### 2.3.4 Ferrous and Galvanized Metal Surface Coatings

Apply a [Polyurethane, Pigmented Coating System in conformance with MPI, No. 72, MPI, No. 77, and MPI, No. 101] [High-Performance Architectural Latex Coating System in conformance with MPI, No. 134, MPI, No. 138, and MPI, No. 140]. Apply prime coat with a dry-film thickness of not less than 0.05 millimeter 2 mils. Finish coats must be a polyurethane-based material as specified.

#### 2.3.5 Aluminum Surface Coatings

Apply a water base, light industrial coating system in conformance with [MPI, No. 95] [MPI, No. 77 and MPI, No. 80 for epoxy coating] [MPI, No. 80 for polyurethane] coats on aluminum surfaces. Prime coat must use IEEE/ASTM SI 10 and or a polyurethane-resin material as recommended by the coating manufacturer for the substrate to be coated and the end use of the coated surfaces. Apply prime coat with a dry-film thickness of not less than 0.05 millimeter 2 mils. Finish coats must be a polyurethane-based material as specified.

#### 2.3.6 Wood Surface Coatings

Apply a [pigmented polyurethane coating in conformance with MPI, No. 72] [clear polyurethane two-component coating in conformance with MPI, No. 13 and MPI, No. 78]. Apply prime coat with a dry-film thickness of not less than 0.12 millimeter 5 mils. Finish coats must be a polyurethane-based material as specified.

### 2.4 CHLORINATED-RUBBER COATINGS

\*\*\*\*\*

NOTE: Chlorinated-rubber-based coatings must be used where surface to be coated requires high resistance to water, salt spray, moist gases, and inorganic acids at 24 degrees C 75 degrees F.

Chlorinated rubber resins cannot be used in the unmodified state; they tend to be deteriorated by heat and ultraviolet light. Chlorinated-rubber resins are generally modified with phenolic resins.

Chlorinated rubber coatings must be based on modified, chlorinated-rubber, phenolic-resin materials. Coatings are formulated as grey and white coating with a wide range of tints for white base material.

\*\*\*\*\*

#### 2.4.1 General

\*\*\*\*\*

NOTE: Dry-film thickness given shall be considered minimum and may be revised to suit conditions and surface use.

\*\*\*\*\*

Vehicle resins for finish coats must be based on a modified, chlorinated-rubber, phenolic-resin material. Coating material must contain not less than 20 percent chlorinated rubber resin, based on the total

weight of the material. Apply finish coats with a dry-film thickness of not less than 0.07 millimeter 3 mils per coat. Finish coating color must be as indicated.

#### 2.4.2 Concrete Surface Coatings

\*\*\*\*\*  
**NOTE: Policy is to avoid coating of exposed  
concrete unless it is considered aesthetically  
desirable.**  
\*\*\*\*\*

Apply a minimum three coats on concrete surfaces. Prime coat must be based on a chlorinated-rubber resin material as recommended by the coating manufacturer for the substrate to be coated and the end use of the coated surfaces. Prime coat must fill concrete surface pores with a total film thickness of not less than 0.05 millimeter 2 mils. Finish coats must be chlorinated-rubber-based coatings as specified.

#### 2.4.3 Masonry Surface Coatings

Apply a minimum two finished coats on masonry surfaces must be a masonry block filler. Block filler must be based on an epoxy-ester resin material as recommended by the coating manufacturer for the substrate to be coated and the end use of the coated surface. Block filler must fill surface pores with a total film thickness of not less than 0.2 millimeter 7 mils. Finish coats must be chlorinated-rubber-based coatings as specified.

#### 2.4.4 Ferrous and Galvanized Metal Surface Coatings

Apply a minimum two coats of high performance architectural latex coating in conformance with MPI, No. 79 on ferrous and galvanized metal surfaces. Apply prime coat with a dry-film thickness of not less than 0.07 millimeter 3 mils. Finish coats must be chlorinated rubber-based coatings as specified.

#### 2.4.5 Aluminum Surface Coatings

Apply a minimum three coats of quick drying primer for aluminum surfaces. Prime coat must conform to IEEE/ASTM SI 10 and MPI, No. 80 for aluminum coating system.

### PART 3 EXECUTION

#### 3.1 SURFACE PREPARATION

##### 3.1.1 Concrete Surfaces

Conform to MPI for substrates indicated. Remove plates, machined surfaces, and similar items already in place that are not to be coated. Provide surface-applied protection before surface preparation and coating where removal is impractical or impossible. After completing coating operations, reinstall items that were removed.

Clean dirt, oil, grease, and incompatible paints from substrates to ensure bonding. Coordination of shop-applied prime coats with high-performance coatings is critical. Remove incompatible primers. Reprime substrate with compatible primers as required to produce coating systems indicated.

#### 3.1.1.1 Concrete Substrates

Remove release agents, curing compounds, efflorescence, and chalk. Maximum Moisture Content of concrete is 12 percent. Moisture content must be measured with electronic moisture meter.

Clean surfaces with pressurized water. Use pressure range of [ 10 350 to 27 580 kPa 1500 to 4000 psi at 150 mm to 300 mm 6 inch to 12 inch] [ 27 580 to 68 950 kPa 4000 to 10,000 psi].

Comply with **SSPC SP 7** (NACE No. 4), "Brush-Off Blast Cleaning" for abrasive cleaning.

#### 3.1.1.2 Clay Masonry Substrates

Remove efflorescence and chalk. Do not coat surfaces if moisture content or alkalinity of surfaces to be coated exceeds that permitted in manufacturer's written instructions.

Clean surfaces with pressurized water. Use pressure range of [690 to 4140 kPa 100 to 600 psi] [10 350 to 27 580 kPa 1500 to 4000 psi] at 150 to 300 mm 6 inch to 12 inch.

\*\*\*\*\*  
NOTE: Delete paragraph below if primers are shop  
applied and will not be removed in the field.  
\*\*\*\*\*

#### 3.1.1.3 Steel Substrates

Remove rust and loose mill scale. Clean using methods recommended in writing by coating manufacturer. Conform to **SSPC SP 7** (NACE No. 4) for blast cleaning.

\*\*\*\*\*  
NOTE: Galvanized-metal substrates should not be  
chromate passivated (commercially known as  
"bonderized"). If galvanized metal is chromate  
passivated, consult manufacturers for appropriate  
surface preparation and primers.  
\*\*\*\*\*

#### 3.1.1.4 Galvanized-Metal Substrates

Remove grease and oil residue from galvanized sheet metal fabricated from coil stock by mechanical methods to produce clean, lightly etched surfaces that promote adhesion of subsequently applied coatings.

#### 3.1.1.5 Aluminum Substrates

Remove surface oxidation.

#### 3.1.1.6 Wood Substrates

Prep substrates by scraping and cleaning small, dry, seasoned knot. Sand surfaces smooth. Apply a thin coat of knot sealer before applying an interior latex-based wood primer. Prime edges, ends, faces, undersides, and back sides of wood. After priming, fill holes and crevices to the finished surface with putty or plastic wood filler. After finished surface

is dry, smooth surface by sanding. For a finished product.

### 3.2 COATING MATERIAL PREPARATION

#### 3.2.1 General

Mix and prepare coating materials in accordance with the coating manufacturer's printed instructions for the particular material and coat to be applied. Keep materials which are not in actual use in closed containers.

Coating materials that have been mixed with an automatic shaker must be allowed to stand to let air bubbles escape, then given a final hand mixing before application. Stir materials so as to produce a mixture of uniform density. Stir at frequent intervals during application to prevent skinning. Do not stir film which may form on the surface of the material. Remove film and strain, if necessary.

#### 3.2.2 Thinning

Thinning must be done in accordance with coating manufacturer's printed directions for the particular material and coat.

#### 3.2.3 Tinting

Prime and intermediate coats of paint must be a slightly different tint from the finish coat to facilitate identification of each coat. Tinting must be done by the coating manufacturer and clearly identified as to color and coat.

### 3.3 APPLICATION OF COATING MATERIALS

#### 3.3.1 General

Do not perform exterior painting in damp or rainy weather. Interior painting must not be allowed until the building is enclosed and has thoroughly dried out. Do not allow painting below 10 degrees C 50 degrees F and above 35 degrees C 95 degrees F. Painting application must be in accordance with the coating manufacturer's recommendations, and as specified.

Application of coatings must be done by skilled applicators. Apply coatings to clean and properly prepared surfaces. Apply coatings carefully with clean, high-quality application equipment. Allow sufficient time between coats to ensure complete drying and curing. Surfaces must be sanded and dusted between coatings, as required, to produce a surface free of visible defects. High gloss coatings and clear finishes must be lightly sanded between coats to ensure bond of following coats.

Apply coats to the surfaces in an even film. Do not accept cloudiness, spotting, holidays, laps, application marks, runs, sags, and other similar surface imperfections. Remove defective coating applications and recoat as directed.

Coating lines such as wainscots must be sharp, true, and well-defined. Tape may be used to establish coating lines, providing tape is removed before ragging or sawtooth edges form.

Surfaces, including edges, corners, crevices, welds, and other similar

changes in surface plane, must receive a dry-film thickness not less than specified.

#### 3.3.2 Brush Application

Brushes must be clean and the proper size and type for high-quality application of the specified coating materials. Slow-dry coatings must be brushed out. Quick-dry coatings must be brushed only enough to spread out evenly.

#### 3.3.3 Roller Application

Roller covers must be clean and of the proper nap length, nap texture, and material for high-quality application of the specified coating materials.

Roller application must be done carefully and must be equivalent in all respects to the same coats applied by high-quality brush application.

#### 3.3.4 Spray Application

[Do not allow spray application of coatings.]

[Spray application equipment must be limited to airless-spray equipment and electrostatic-spray equipment. Equipment must be clean and operated by workmen skilled in high quality application of coating materials.]

Spray application of coatings must be limited to finish coats on metal frame works, siding, decking, wire mesh, and other surfaces where hand work would be inferior. Sprayed coatings must be carefully applied and equivalent in all respects to the same coats applied by high quality brush application. Each spray coat must be permitted to cure before the succeeding coat is applied. Do not permit doubling back with application equipment, for the purpose of building up film thickness of two coats in one operation.

Surfaces adjacent to areas to be spray coated shall be covered to prevent damage from overspray, coating rebound, and spray drift.]

### 3.4 ACCEPTANCE PROVISIONS

#### 3.4.1 Repairing

Remove damaged and unacceptable portions of completed work and replace with new work to match adjacent surfaces at no additional cost to the Government.

#### 3.4.2 Cleaning

At end of each workday, remove rubbish, empty cans, rags, and other discarded materials from Project site.

After completing coating application, clean spattered surfaces. Remove spattered coatings by washing, scraping, or other methods. Do not scratch or damage adjacent finished surfaces.

Application equipment must be cleaned promptly and thoroughly with a suitable solvent after each use and stored in a clean, covered, well-ventilated container.

Protect work of other trades against damage from coating operation.

Correct damage by cleaning, repairing, replacing, and recoating, as approved by Architect, and leave in an undamaged condition. At completion of construction activities of other trades, touch up and restore damaged or defaced coated surfaces.

-- End of Section --