
**TECHNICAL SPECIFICATION
CONVEYOR SYSTEM**

11 PAINTING

11.1 General

All structural steel components need to be protected permanently and effectively against any formation of rust thus avoiding weakening of the cross-sections. Protection against corrosion shall be achieved by painting. The paint coating is effective only if it adheres completely and permanently to the steel surfaces and if the paint resists quick wears.

11.2 Preparation of Surfaces for Painting

11.2.1 All surfaces of components to be painted shall be thoroughly cleaned of all foreign matters adhering to the steel surface to Swedish Standard specification Sa 2½ by means of blasting with shot. Use of scraper wire brush and pig hammer is acceptable wherever blasting is not possible due to lack of access.

11.2.2 The thoroughly cleaned surfaces shall receive the paint within 6 hours following the removal of rust. If this period of 6 hours is not observed, due to any reasons whatsoever, the surfaces intended to be painted shall have to receive a new cleaning by sand blasting before the coat of paint is applied.

11.2.3 Any removal of rust adherent to steel surfaces by means of chemical solvent is prohibited.

Subsequent to the removal of rust, oil and grease deposits shall be removed with chemical solvents. Wet surfaces shall be dried and painting shall generally be done immediately after cleaning.

11.2.4 Welding areas shall not be painted until after the completion of welding operations.

However, wherever welding has to be carried out after erection at site, the shop coat of paint shall be removed thoroughly unless specifically permitted because of use of appropriate electrodes and paints, before welding and the adjoining steel surface including welding area shall be repainted after proper cleaning as specified herein.

11.2.5 In case of interrupted welding seams, the front points shall be thoroughly cleaned from rust.

11.2.6 The surfaces intended to be painted shall be inspected and approved by the Engineer prior to painting.

11.2.7 Shot blasting shall be carried out in fully enclosed shed complying with all statutory & environmental norms. In case shot blasting to be carried out in monsoon season necessary precautions shall be ensured.

11.2.8 The approved manufacturers for all paints shall be SHALIMAR, ASIAN PAINTS, BERGER PAINTS, JOTUN, AKZO NOBEL, or any other equivalent paint, but approved by the Employer.

11.3 Specifications of Painting

11.3.1 Two coats of epoxy base zinc rich primer (92% zinc on dry film) shall be applied by airless spray. The dry film thickness of two coats shall be 60 microns minimum. The tenderer may quote with Single Coat of suitable DFT if in the opinion of the tenderer the same will provide better life of painting system.

Opca Painting Specification Manual

**Master Painters Institute, Painting &
Decorating Contractors of America**

A red circular graphic with a gradient, appearing as a partial circle or a thick arc, located to the right of the text box.

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Painter and Decorator Canada. Human Resources Development Canada, Canada. Interprovincial Partnerships and Occupational Information Division, 2000 This analysis is directed at the painter decorator who is capable of applying decorative and or protective finishes to a wide variety of materials in residential commercial institutional and industrial settings The analysis identifies tasks and sub tasks performed by a painter decorator arranged in blocks of distinct operations relevant to that occupation These blocks include workplace safety basic job skills surface preparation paints coatings wall coverings wood finishing and specialty finishes For each task the document outlines the element of skill and knowledge needed to perform the task adequately identifies any shifts or changes in technology that affect the task lists tools and equipment required for the task and provides an indication of whether the task has been validated by each province and territory The appendix includes a list of tools and equipment used in the occupation and a tabulation of the percentage of time a worker spends performing each block and task in a given year by province territory and for Canada as a whole

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