

Coded Note Number: **Y2480**

Revision: **C006**

Date: **March 2, 2023**

Title: **PAINT NOTE FOR CARBON STEEL AND STAINLESS FOUNDATIONS**

This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.

Change from Revision C003 – Editorial change to reformat to current standard. Bolded font indicates changed/added content.

[Text deleted] inserted in the document indicates the removal of content.

Purchased foundations may include one or both types of material.

Prepare surface to Near-White Metal Blast Cleaning requirements of SSPC-SP 10. Apply one coat of Formula 150, Green, MIL-DTL-24441, Type IV paint at 4 to 6 mils Dry Film Thickness (DFT).

Coating shall be applied as soon as practicable after cleaning but no longer than four hours unless the cleanliness condition specified herein has been verified prior to coating. Coating shall be applied in accordance with the coating manufacturer's product data sheet.

DFT shall be determined by the average of no less than five random spot measurements for each 1,000 sq ft (or less) of painted surface. DFT shall be measured in accordance with SSPC-PA 2. A visual inspection for holidays shall be performed. Any holidays found shall be marked and touched up.

The areas within 2 inches of welding for installation shall be taped off to eliminate coating application in these areas. The item will be cleaned in way of welding, touched up and final painted to match surrounding area after installation.

Stainless Foundations:

When blasting or mechanical tools are used for cleaning, care shall be taken to only slightly roughen the surface to provide a good paint bond. To prevent contamination of the substrate during blasting, only clean non-metallic abrasive media shall be used. Recycled grit shall not be used. Unless otherwise specified, solvent clean in accordance with SSPC-SP 1 and abrasive blast similar to SSPC-SP 10 to achieve a recommended average surface profile of 1-3 mils.

Items shall be coated as follows:

1st Coat - Formula 150, Green, MIL-DTL-24441 Type IV at 4.0-6.0 mils DFT.

2nd Coat - Formula 150, Green, MIL-DTL-24441 Type IV at 4.0-6.0 mils DFT.