

PAINT SPECIFICATIONS - COATING SYSTEMS FOR STEEL AND ALUMINIUM

NON FERROUS (ALUMINIUM, BRASS) COATINGS:

1. DEGREASE TO AS 1627.1
2. WHIP BLAST TO REMOVE ALL EXISTING COATINGS USING A FINE GARNET SAND (NO STEEL GRIT OR SHOT SHALL BE USED) PROFILE TO BE LESS THAN 10 MICRONS. NEW MATERIALS THAT HAVE NO COATINGS NEED NOT BE BLASTED.
3. ETCH PRIME USING PPG MULTIETCH 302 OR EQUIVALENT, 6-12 MICRONS
4. MID COAT USE PPG AMERLOC 2 OR EQUIVALENT HIGH BUILD EPOXY, TO 125 TO 150 MICRONS.
5. TOP COAT USE PPG 450N POLYURETHANE OR EQUIVALENT, TO 40 TO 50 MICRONS.

FERROUS (STEEL) MATERIALS:

1. ALL STRUCTURAL AND NON STRUCTURAL STEELWORK OF THICKNESS 5MM AND ABOVE SHALL BE HOT DIP GALVANISED AFTER FABRICATION
2. INTERNAL MEMBERS TO BE PAINTED SHALL BE:
 - DEGREASED TO AS1627.1 2003
 - WHIP BLAST TO AS1627.4 2005 APPROXIMATELY CLASS 1. THIS IS TO REMOVE THE SHINE FROM THE SURFACE AND CREATE A PROFILE. IT DOES NOT REMOVE THE GALVANISED ZINC LAYER.
 - PRIMED WITH TWO PACK EPOXY ZINC PHOSPHATE (182 ZPK OR EQUIVALENT) AT 50 MICRONS
 - TOP COAT WITH TWO PACK POLYURETHANE (450N OR EQUIVALENT) TO 60 MICRONS
3. ALL EXTERNAL MEMBERS (EXTERNAL PAINTING AFTER HOT DIP GALVANISING) SHALL BE:
 - DEGREASED TO AS1627.1
 - WHIP BLAST TO AS1627.4 2005 APPROXIMATELY CLASS 1. THIS IS TO REMOVE THE SHINE FROM THE SURFACE AND CREATE A PROFILE. IT DOES NOT REMOVE THE GALVANISED ZINC LAYER.
 - PRIMED WITH TWO PACK EPOXY ZINC PHOSPHATE (AMERCOAT 182 ZPK OR EQUIVALENT) AT 50 MICRONS
 - INTERMEDIATE COAT HIGH BUILD EPOXY (AMERLOCK 2 OR EQUIVALENT) TO 125 TO 150 MICRONS
 - TOP COAT WITH TWO PACK POLYURETHANE (450N OR EQUIVALENT) TO 60 MICRONS

REPAIRS TO HOT DIP GALVANISED MEMBERS DUE TO WELDING CUTTING (HOT DIP GALVANISING REPAIR):



1. DAMAGED ZINC COATED AREAS SHALL BE DEGREASED IN ACCORDANCE WITH AS1627.1 2003
2. REMOVE ALL LOOSE AND DAMAGED GALVANISING COATINGS WITH POWER SANDER USING SHARP 80 GRIT SAND PAPER TO ACHIEVE A CLEAN BARE METAL. REMOVE ALL DUST PRIOR TO PAINTING.
3. APPLY ONE COAT OF TWO PACK EPOXY ZINC RICH PAINT (GREATER THAN 92% ZINC) (AMERCOAT 307 OR EQUIVALENT) AT 75MICRONS

REPAIRS TO EXTERNAL STEELWORK PAINT/GALVANISING COMBINATION:

1. PAINTED AREA SHALL BE FEATHERED UNIFORMLY AT NO LESS THAN 1:100 (IE 200 MICRONS CREATES A FEATHER TAPER OF 20MM WIDTH), USING A GRINDER WITH SHARP 80 GRIT SANDPAPER.
2. FIRSTLY REPAIR ZINC COATING IF DAMAGED, AS PER "HOT DIP GALVANISING REPAIR" ABOVE
3. REPAIR PAINT SYSTEM AS PER "EXTERNAL PAINTING", AS DETAILED ABOVE EXCEPT EXCLUDE DEGREASING AND WHIP BLASTING
4. OVERLAP EACH COAT BY AT LEAST 50MM

GENERAL NOTES

1. ALL COATINGS SHALL BE FROM THE SAME MANUFACTURER
2. APPLICATION SHALL BE IN ACCORDANCE WITH THE MANUFACTURERS RECOMMENDATIONS
3. ALL WELD SPATTER SHALL BE REMOVED, RADII CORNERS SHALL BE TO NOT LESS THAN 2MM.
4. TESTING OF THE CONTINUITY AND THICKNESS OF THE FINISHED PAINT SYSTEM SHALL BE UNDERTAKEN BY THE PRINCIPAL AT THEIR DISCRETION WITH FAILURE OF COATINGS TO BE REPAIRED BY THE CONTRACTOR
5. COLOUR OF PRIMER, INTERMEDIATE AND TOP COATS TO BE SUFFICIENTLY DIFFERENT IN COLOUR TO ALLOW IDENTIFICATION IN THE EVENT OF A DESTRUCTIVE TOOKE TEST.
6. COLOURS OF REPAIR PAINTING SHALL MATCH ADJACENT SURFACE COLOURS OR COLOURS AS DEFINED IN SPECIFICATION
7. PAINT THICKNESS SHALL BE WITHIN THE RANGE OF -10% TO +20% OF ALL READINGS. THE AVERAGE OVER EACH METRE SQUARED AREA SHALL NOT BE LESS THAN THE REQUIRED THICKNESS FOR THE OVERALL COATING THICKNESS SPECIFIED.
8. ALL BOLTS AND FIXINGS LOCATION DETERMINES FIXING TYPE.
 - WITHIN 300M SURF ZONE 316 STAINLESS STEEL
 - 300M TO 1KM 304 STAINLESS STEEL, ELSE HOT DIP GALVANIZED.
9. ALL STAINLESS STEEL TO BE ELECTRICALLY ISOLATED USING NYLON BUSHES AND WASHERS.
10. ALL FAYING STRUCTURAL CONNECTIONS (BOLTED TOGETHER SURFACES) SHALL BE SEALED TO PREVENT MOISTURE INGRESS WITH NEUTRAL CURE SEALANT

				SCALE	 LIVEABLE CITY INFRASTRUCTURE MANAGEMENT SERVICES	APPROVED:	THE CITY OF NEWCASTLE PAINT SPECIFICATION FOR ROAD AND LANDSCAPE STEEL AND ALUMINIUM FURNITURE	NCC PLAN No.	SHEET No.
				AS SHOWN		SIGNED:  INFRASTRUCTURE MANAGEMENT SERVICES MANAGER DATE: 29.09.2016		A3800	1 OF 1 SHEETS
0	CONSTRUCTION	05.07.16	T.A.						
No.	AMENDMENT DETAILS	DATE	INITIALS						
A3 ORIGINAL THIS SHEET WAS PREPARED IN COLOUR AND WILL BE INCOMPLETE IF COPIED				COORDINATE SYSTEM:	HEIGHT DATUM: AHD	REVIEWED: J.C.		AMENDMENT No.	