GENERAL NOTES

BEFORE SANDBLASTING BVEGINS THE SUPPORT SECTION SHALL BE INSPECTED FOR AREAS THAT ARE CONTAMINATED BY BITUMINOUS MATERIAL, GREASE, OIL, ETC. THESE CONTAMINATED AREAS SHALL IMMEDIATLY BE SOLVANT CLEANED WITH METHYL ETHYL KEYTONE AND CLEAN RAGS.

AFTER THE SPOT CLEANING OF THE CONTAMINATED AREAS IS PREFORMED AND THE SOLVENT IS ALLOWED TO DRY, SANDBLASTING CAN BE DONE. SANDBLASTING SHALL REMOVE ALL THE RUST DOWN TO BARE METAL PER SPECIFICATION AFTERWARDS, THE TOTAL AREA OF THE SUPPORT, INCLUDING THE SANDBLASTING AREAS AND NON-SANDBLASTED AREAS SHALL BE SOLVENT WIPED WITH METHYL ETHYL KEYTONE AND CLEAN RAGS. SUFFICIENT TIME SHOULD BE ALLOWED FOR THE SOLVENT TO DRY.

ALL SAND BLASTING AND CLEANED SURFACES SHALL BE DRY AND APPROVED BY THE ENGINEER PRIOR TO COATING. THE EPOXY PRIMER COAT SHALL BE APPLIED BEFORE THE SAND BLASTED AND CLEANED SURFACES HAVE DEGRADED FROM THE PRESCRIBED STANDARDS AND BEFORE SURFACE RUST BEGINS TO APPEAR. THEREFORE, IMMEDIATE APPLICATION OF THE EPOXY PRIME COAT SHALL BE DONE ON THE SAME DAY THAT THE SURFACES ARE SANDBLASTED CLEAN.

THE BASIS OF PAYMENT SHALL INCLUDE ALL LABOR, EQUIPMENT, HANDLING, TRANSPORTATION COSTS, AND MATERIALS NECESSARY TO ACCOMPLISH THIS ITEM OF WORK PER MAJOR SUPPORT SECTION.

BASIS OF PAYMENT WILL BE AS FOLLOWS:
SPECIAL SURFACE PREPARATION, EXISTING SUPPORT SECTIONS AT CONTRACT BID PRICE PER EACH MAJOR SUPPORT SECTION.

SURFACE PREPARATION, NEW SUPPORT SECTIONS

NEW, UNWEATHERED GALVANIZED SUPPORT SECTIONS SHOULD HAVE THEIR SURFACE PREPARATION AS WELL AS THEIR PROTECTIVE COATING DONE AT THE MANUFACTURER OF THE SUPPORT SECTIONS. BETTER QUALITY AND TREATMENT SHOULD BE ABLE TO BE PREFORMED AT THE MANUFACTURER.

THE SUPPORT SECTIONS SHALL BE SOLVENT DEGREASED BY IMMERSION IN METHYL ETHYL KEYTONE BEFORE A WASH PRIMER IS APPLIED. THE WASH PRIMER TO BE USED IS AS SPECIFIED IN THE DOD-P-15328 (FORMULA 117). IT SHOULD BE SPRAY APPLIED TO GIVE 0.3 TO 0.5 MIL DRY THICKNESS. CERTIFICATION BY THE MANUFACTURER OF THIS PROCEDURE WILL BE REQUIRED.

BEFORE THE PREPARED SURFACE DEGRADES FROM THE PRESCRIBED STANDARDS, THE PRIME COAT SHALL BE APPLIED. IN EVERY CASE, THE SURFACE SHALL BE COATED WITH ALUMINUM PIGMENTED EPOXY PRIME COAT ON THE SAME DAY OF SURFACE PREPARATION. CAREFUL HANDLING AND STORAGE WILL BE REQUIRED TO PREVENT ANY SCRAPING, MARRING, OR OTHER SURFACE DAMAGE TO THE PREPARED SURFACE.

PAYMENT SHALL BE INCLUDE ALL LABOR, EQUIPMENT, HANDLING, TRANSPORTATION COSTS AND MATERIALS NECESSARY TO ACCOMPLISH THIS ITEM OF WORK PER MAJOR SUPPORT SECTION.

BASIS OF PAYMENT WILL BE AS FOLLOWS:
SPECIAL SURFACE PREPARATION, NEW SUPPORT SECTIONS AT CONTRACT BID PRICE PER EACH MAJOR SUPPORT SECTION.

COATING, EPOXY-PRIME COAT, SUPPORT SECTIONS

THIS ITEM SHALL CONSIST OF THE APPLICATION OF ONE (1) COAT OF AN EPOXY PRIMER TO SUPPORT SECTIONS. THE TOTAL DRY FILM THICKNESS OF THIS COAT SHALL BE BETWEEN 1.5 TO 2.0 MILS. IF MORE THAN ONE PASS IS NECESSARY TO OBTAIN THE REQUIRED MIL THICKNESS THAT COST SHALL BE BORNE BY THE CONTRACTOR. THE COLOR OF THIS COAT SHALL BE ALUMINUM.

THIS COAT SHALL IN ALL CASES BE APPLIED OVER SURFACES THAT WERE PREPARED EARLIER THAT SAME DAY. THIS COAT SHALL BE APPLIED BY BRUSH. THE THINNING OF THE EPOXY MATERIAL IS STRICTLY PROHIBITED. MATERIAL NOT CAPABLE OF BEING APPLIED AS SPECIFIED SHALL NOT BE USED.

WHEN THE AVERAGE DRY FILM THICKNESS OF THIS COAT OVER THE ENTIRE SUPPORT SECTION IS LESS THAN THE SPECIFIED 1.5 TO 2.0 MILS BUT IS AT LEAST 1.25 MILS, THE CONTRACT BID PRICE FOR THIS ITEM SHALL BE REDUCED IN DIRECT PROPORTION TO THE PERCENT DEFICIENCY OF COATING UP TO 16-2/3%. IF THE DEFICIENCY OF COATING IS MORE THAN 16-2/3% (I.E., THE AVERAGE DRY FILM THICKNESS IS LESS THAN 1.25 MILS) THE WORK FOR THIS ITEM SHALL BE CONSIDERED UNSATISFACTORY AND SHALL BE RECOATED AT THE FULL EXPENSE OF THE CONTRACTOR, INCLUDING ALL LABOR, EQUIPMENT, AND MATERIAL.

THE EPOXY PRIME COAT CHOSEN BY THE CONTRACTOR SHALL BE ONE OF THE FOLLOWING TWO-COMPONENT COMPOSITIONS CONFORMING TO ITS LISTED PROPERTIES:

AMERCOAT 71
% SOLIDS BY VOLUME 47% +/- 2%
POT LIFE: 8 HRS. @ 77 DEGREES F (25 DEGREES C)
DRYING TIME: 4 HRS. @ 77 DEGREES F

EPOXY CHROMATE METAL PRIMER NO. 5251/5252:
% SOLIDS BY VOLUME: 32.2% +/- 2%
POT LIFE: 24 HRS. @ 80 DEGREES F, 5 HRS. @ 100 DEG. F
DRYING TIME: 1 HR. TO TOUCH, 3-4 HRS. RECOAT
VISCOSITY: BASE 71-75 KU (STORMER)
CURING AGENT 56-60 KU (STORMER)
% SOLIDS BY WEIGHT: 51.5% +/- 2%

INTERGUARD EPA 130/131:
% SOLIDS BY VOLUME: 63% +/- 2%
POT LIFE: 8 HRS. @ 77 DEGREES F
DRYING TIME: 5 HRS. TO TOUCH, 16 HRS. RECOAT @ 77 DEG. F

ZINC CHROMATE EPOXY PRIMER:
% SOLIDS BY VOLUME: 48% +/- 2%
POT LIFE: 16-20 HRS. @ 75 DEGREES F
DRYING TIME: 1 HR. TO TOUCH, OVERNIGHT FOR BRUSH APPL.
VISCOSITY: 70-75 KREBSUNITS

MARK-60 (ULTRAPOX):
% SOLIDS BY WEIGHT: 70-75% +/- 2%
POT LIFE: 6 HRS. @ 75 DEGREES F
DRYING TIME: 2-3 HRS. INITIAL SET @ 75 DEGREES F
VISCOSITY: 300-500 CPS @ 75 DEGREES F

FOR NEW SUPPORT SECTIONS THIS PRIME COAT SHOULD BE DONE AT THE MANUFACTURER OF THE SUPPORT SECTIONS. CERTIFICATION BY THE MANUFACTURER FOR THIS PRIME COAT PROCEDURES WILL BE REQUIRED. EXISTING WEATHERED, GALVANIZED, SUPPORT SECTIONS WILL BE DONE AT THE FIELD LOCATION OR THE CONTRACTOR'S STORAGE YARD. CAREFUL HANDLING AND STORAGE WILL BE REQUIRED TO PREVENT ANY SCRAPING, MARRING, OR OTHER SURFACE DAMAGE TO THE PRIME COAT.

THE PAYMENT SHALL INCLUDE ALL LABOR, EQUIPMENT, HANDLING COSTS, AND MATERIALS NECESSARY TO ACCOMPLISH THIS ITEM OF WORK. THIS PRIME COAT SHALL BE MANUFACTURED BY THE SAME COMPANY SUPPLYING THE INTERMEDIATE AND TOP COATS. A PROPERLY CALIBRATED DRY FILM THICKNESS INSTRUMENT WILL BE USED TO CHECK THE COATING.

BASIS OF PAYMENT WILL BE AS FOLLOWS:
SPECIAL COATING, EPOXY PRIME COAT, SUPPORT SECTIONS
AT CONTRACT BID PRICE PER EACH MAJOR SUPPORT SECTION.

COATING, EPOXY INTERMEDIATE COAT, SUPPORT SECTIONS

THIS ITEM SHALL CONSIST OF THE APPLICATION OF ONE (1) COAT OF EPOXY TO SUPPORT SECTIONS. THE TOTAL DRY FILM THICKNESS OF THIS COAT SHALL NOT BE LESS THAN SIX (6.0) MILS. IF MORE THAN ONE PASS IS NECESSARY TO OBTAIN THE REQUIRED MIL THICKNESS THAT COST SHALL BE BORNE BY THE CONTRACTOR. THE COLOR OF THIS COAT SHALL BE LIGHT GREY. THIS COAT SHALL BE APPLIED BY BRUSH. THE THINNING OF THE EPOXY MATERIAL IS STRICTLY PROHIBITED. MATERIAL NOT CAPABLE OF BEING APPLIED AS SPECIFIED SHALL NOT BE USED.

WHEN THE AVERAGE DRY FILM THICKNESS OF THIS COAT OVER THE ENTIRE SUPPORT SECTION IS LESS THAN THE SPECIFIED SIX (6.0) MILS BUT IS AT LEAST (5.0) MILS, THE CONTRACT PRICE FOR THIS ITEM SHALL BE REDUCED IN DIRECT PROPORTION TO THE PERCENT DEFICIENCY OF COATING UP TO 16-2/3%. IF THE DEFICIENCY OF COATING IS MORE THAN 16-2/3% (I.E. THE AVERAGE DRY FILM THICKNESS IS LESS THAN 5.0 MILS) THE WORK FOR THIS ITEM SHALL BE CONSIDERED UNSATISFACTORY AND SHALL BE RECOATED AT THE FULL EXPENSE OF THE CONTRACTOR, INCLUDING ALL LABOR, EQUIPMENT, AND MATERIAL.

THE EPOXY INTERMEDIATE COAT CHOSEN BY THE CONTRACTOR SHALL BE ONE OF THE FOLLOWING TWO-COMPONENT COMPOSITIONS CONFORMING TO ITS LISTED PROPERTIES.

AMERLOCK 400:
% SOLIDS BY VOLUME: 83% +/- 2%
POT LIFE: 2-1/2 HRS. @ 70 DEGREES F
DRYING TIME: 20 HRS. @ 70 DEGREES F

GLID-GUARD EPOXY CHEMICAL RESISTANT FINISH NO. 5240 SERIES:
% SOLIDS BY VOLUME: 44.7% +/- 2%
POT LIFE: 10 HRS. @ 80 DEGREES F
DRYING TIME: 4 HRS. @ 77 DEGREES F TO HANDLE
VISCOSITY: 68-72 KU
% SOLIDS BY WEIGHT: 58.0% +/- 2%

INTERGARD TAA SERIES/TAA 423 HS EPOXY:
% SOLIDS BY VOLUME: 90% +/- 2%
POT LIFE: 8 HRS. @ 77 DEGREES F
DRYING TIME: 5 HRS. TO TOUCH @ 77 DEGREES F

MOBIL HIGH SOLIDS EPOXY76 SERIES:
% SOLIDS BY VOLUME: 85% +/- 2%
POT LIFE: 4 HRS. @ 75 DEGREES F
DRYING TIME: 8 HRS. @ 75 DEGREES F TO TOUCH
VISCOSITY: 85-90 KU @ 75 DEGREES F

MARK-60 ULTRAPOX:
% SOLIDS BY WEIGHT: 70-75% +/- 2%
POT LIFE: 6 HRS. @ 75 DEGREES F
DRYING TIME: 2-3 HRS. INITIAL SET @ 75 DEGREES F
VISCOSITY: 300-500 CPS @ 75 DEGREES F

AT LEAST 24 HOURS BUT NO MORE THAN THREE (3) DAYS SHALL ELAPSE AFTER THE APPLICATION OF THE ALUMINUM PIGMENTED EPOXY PRIME COAT AND BEFORE THE APPLICATION OF THE EPOXY INTERMEDIATE COAT. SURFACES SHALL IN ALL CASES BE CLEAN BEFORE THE INTERMEDIATE COAT IS APPLIED.

FOR NEW SUPPORT SECTIONS, THIS INTERMEDIATE COAT SHOULD BE DONE AT THE MANUFACTURER OF THE SUPPORT SECTIONS. CERTIFICATION BY THE MANUFACTURER FOR THE INTERMEDIATE COAT PROCEDURE WILL BE REQUIRED. EXISTING WEATHERED, GALVANIZED SUPPORT SECTIONS WILL BE DONE AT THE FIELD LOCATION OR THE CONTRACTOR'S STORAGE YARD. CAREFUL HANDLING AND STORAGE WILL BE REQUIRED TO PREVENT ANY SCRAPING, MARRING OR OTHER SURFACE DAMAGE TO THE INTERMEDIATE COAT.

THE PAYMENT SHALL INCLUDE ALL LABOR, EQUIPMENT, HANDLING COSTS, AND MATERIAL NECESSARY TO ACCOMPLISH THIS ITEM OF WORK. THIS INTERMEDIATE COAT WHALL BE MANUFACTURED BY THE SAME COMPANY SUPPLYING THE PRIME AND TOP COATS. A PROPERLY CALIBRATED DRY FILM THICKNESS INSTRUMENT WILL BE USED TO CHECK THE COATING.

BASIS OF PAYMENT WILL BE AS FOLLOWS:
SPECIAL COATING, EPOXY INTERMEDIATE COAT, SUPPORT SECTIONS AT CONTRACT BID PRICE PER EACH MAJOR SUPPORT SECTION.

COATING, URETHANE TOP COAT, SUPPORT SECTIONS

THIS ITEM SHALL CONSIST OF THE APPLICATION OF ONE (1) COAT OF URETHANE TO SUPPORT SECTIONS. THE TOTAL DRY FILM THICKNESS OF THIS COAT SHALL NOT BE LESS THAN ONE AND ONE-HALF (1.5) MILS. IF MORE THAN ONE PASS IS NECESSARY TO OBTAIN THE REQUIRED MIL THICKNESS THAT COST SHALL BE BORNE BY THE CONTRACTOR. THE COLOR OF THIS COAT SHALL BE MEDIUM GREY. THIS COAT SHALL BE APPLIED BY BRUSH. THE THINNING OF THE EPOXY MATERIAL IS STRICTLY PROHIBITED. MATERIAL NOT CAPABLE OF BEING APPLIED AS SPECIFIED SHALL NOT BE USED.

WHEN THE AVERAGE DRY FILM THICKNESS OF THIS COAT OVER THE ENTIRE SUPPORT SECTION IS LESS THAN THE SPECIFIED ONE AND ONE-HALF (1.5) MILS BUT IS AT LEAST ONE (1.0) MIL, THE CONTRACT PRICE FOR THIS ITEM SHALL BE REDUCED IN DIRECT PROPORATION TO THE PERCENT DEFICIENCY OF COATING UP TO 33 1/3%. IF THE DEFICIENCY OF COATING IS MORE THAN 33-1/3% (I.E., THE AVERAGE DRY FILM THICKNESS IS LESS THAN 1.0 MIL) THE WORK FOR THIS ITEM SHALL BE CONSIDERED UNSATISFACTORY AND SHALL BE RECOATED AT THE FULL EXPENSE OF THE CONTRACTOR, INCLUDING ALL LABOR, EQUIPMENT, AND MATERIAL.