

By observation of Ford B cup viscosity, pot life is deemed exceeded if the viscosity rose more than 30% or if gelled particles appear in the mix. A one liter (quart) container of mixed material is used.

5. Curing Time:
 - a. Set-to-touch, ASTM D 1640: 4 hours Maximum @ 25°C (77°F)
 - b. DRY To Recoat, ASTM D 1640: 24 hours Maximum @ 25°C (77°F)
 - c. Full cure: 7 days @ 10°C (50°F), Maximum
No pick-up when rubbed with a cloth soaked in MEK
6. Fineness of Grind, ASTM D 1210: Hegman 3 minimum
7. V.O.C. maximum, ASTM D 3960: 0.419 g/mL (3.5 lbs./gal.), as applied.

B. Material Quality Assurance

| Test | Variance* |
|-------------------------------------|-------------------|
| 1. Density | +/- 2% |
| 2. Viscosity | Dependent on test |
| 3. Total Solids, % by weight | ± 2 |
| 4. Pigment, % by weight | ± 2 |
| 5. Nonvolatile Vehicle, % by weight | ± 2 |

*Variance shall be within the noted range based upon the test average of the previously submitted sample.

Urethane Finish Coat

This coating shall be a two component polyester and/or acrylic aliphatic urethane and shall be suitable for use as a finish coat over the white epoxy polyamide intermediate coat.

A. Physical Requirements

1. Finish: Specular Gloss, 60 degree, ASTM D 523: 85% minimum;
70% minimum after 3000 hours weathering resistance
2. Volume Solids, ASTM D 2697: 42% minimum
3. Cure (Dry) Time at 25°C (77°F) and 50% RH
Set to touch ASTM D 1640: 30 Minutes, minimum
4 Hours, maximum
4. Pot Life: 4 hours minimum at 25°C (77°F)

By observation of Ford B cup viscosity, pot life is deemed exceeded if the viscosity rose more than 30% or if gelled particles appear in the mix. A one liter (quart) container of mixed material is used.

5. V.O.C. ASTM D 3960: maximum, 0.419 g/mL (3.5 lbs./gal.), as applied
6. Colors**
 - a. Gray FS-595B - 16440 - Use for the gloss test
 - b. Green FS-595B - 14260
 - c. Blue FS-595B - 15450

**Contractor's choice unless specified on plans.

B. Material Quality Assurance

1. Analysis (for each component)

| Test | Variance* |
|-----------------------------------|-------------------|
| a. Density | +/- 2% |
| b. Viscosity, | Dependent on test |
| c. Total Solids, by Weight | ± 2% |
| d. Pigment, by Weight | ± 2% |
| e. Nonvolatile Vehicle, by weight | ± 2% |

*Variance shall be within the noted range based upon the test average of the previously submitted sample.

910.03 Performance Requirements. The coating system, which consists of the organic zinc prime coat, the epoxy intermediate coat, and the urethane topcoat, shall be tested prior to use.

Three panels for each of the specified tests shall be prepared to the requirements of the ASTM D 609 except that the thickness shall be 3 mm (1/8 inch) minimum and the steel shall be ASTM A 36/A 36 M hot rolled steel. The surface shall be blast cleaned (using coal slag abrasive) to equal, as nearly as is practical, the standard Sa 2-1/2 of ASTM D 2200 (Steel Structures Painting Council SSPC-SP10 meets this requirement), and the surface shall have a nominal height of profile of 25 to 88 µm (1 to 3.5) mils verified by using appropriate replica tape. The panels shall be coated and permitted to cure in accordance with the manufacturer's printed instructions. The dry film coating thickness in the system to be tested shall be as follows: