

<b>AMENDMENT OF SOLICITATION/MODIFICATION OF CONTRACT</b>			1. CONTRACT ID CODE	PAGE OF PAGES 1   1
2. AMENDMENT/MODIFICATION NO. 0002	3. EFFECTIVE DATE 9/09/2002	4. REQUISITION/PURCHASE REQ. NO.	5. PROJECT NO. (If applicable)	
6. ISSUED BY  Contracting Division USACE, Little Rock (DACW) 700 W. Capitol Ave, Room 7412 Little Rock, AR 72203-0867	CODE M4P0000	7. ADMINISTERED BY (If other than Item 6)		CODE
8. NAME AND ADDRESS OF CONTRACTOR (No., street, county, State and ZIP Code)			( <input checked="" type="checkbox"/> ) 9A. AMENDMENT OF SOLICITATION NO. DACW03-02-B-0032	( <input type="checkbox"/> ) 9B. DATED (SEE ITEM 11) 9/09/02
			10A. MODIFICATION OF CONTRACTS/ORDER NO.	
			10B. DATED (SEE ITEM 13)	
CODE	FACILITY CODE			

**11. THIS ITEM ONLY APPLIES TO AMENDMENTS OF SOLICITATIONS**

The above numbered solicitation is amended as set forth in Item 14. The hour and date specified for receipt of Offers  is extended,  is not extended.

Offers must acknowledge receipt of this amendment prior to the hour and date specified in the solicitation or as amended, by one of the following methods:  
 (a) By completing Items 8 and 15, and returning 1 copies of the amendment; (b) By acknowledging receipt of this amendment on each copy of the offer submitted; or (c) By separate letter or telegram which includes a reference to the solicitation and amendment numbers. FAILURE OF YOUR ACKNOWLEDGMENT TO BE RECEIVED AT THE PLACE DESIGNATED FOR THE RECEIPT OF OFFERS PRIOR TO THE HOUR AND DATE SPECIFIED MAY RESULT IN REJECTION OF YOUR OFFER. If by virtue of this amendment you desire to change an offer already submitted, such change may be made by telegram or letter, provided each telegram or letter makes reference to the solicitation and this amendment, and is received prior to the opening hour and date specified.

12. ACCOUNTING AND APPROPRIATION DATA (If required)

**13. THIS ITEM APPLIES ONLY TO MODIFICATIONS OF CONTRACTS/ORDERS, IT MODIFIES THE CONTRACT/ORDER NO. AS DESCRIBED IN ITEM 14.**

() A. THIS CHANGE ORDER IS ISSUED PURSUANT TO: (Specify authority) THE CHANGES SET FORTH IN ITEM 14 ARE MADE IN THE CONTRACT ORDER NO. IN ITEM 10A.

B. THE ABOVE NUMBERED CONTRACT/ORDER IS MODIFIED TO REFLECT THE ADMINISTRATIVE CHANGES (such as changes in paying office, appropriation date, etc.) SET FORTH IN ITEM 14, PURSUANT TO THE AUTHORITY OF FAR 43.103(b).

C. THIS SUPPLEMENTAL AGREEMENT IS ENTERED INTO PURSUANT TO AUTHORITY OF:

D. OTHER (Specify type of modification and authority)

**E. IMPORTANT:** Contractor  is not,  is required to sign this document and return \_\_\_\_\_ copies to the issuing office.

14. DESCRIPTION OF AMENDMENT/MODIFICATION (Organized by UCF section headings, including solicitation/contract subject matter where feasible.)  
 Solicitation DACW03-09-B-0032 is amended to replace the painting Section 09965 with Section 09965A (Amendment 0002).

Everything else remains unchanged.

Except as provided herein, all terms and conditions of the document referenced in Item 9A or 10A, as heretofore changed, remains unchanged and in full force and effect.

15A. NAME AND TITLE OF SIGNER (Type or print)		16A. NAME AND TITLE OF CONTRACTING OFFICER (Type or print)	
15B. CONTRACTOR/OFFEROR	15C. DATE SIGNED	16B. UNITED STATES OF AMERICA	16C. DATE SIGNED
_____ (Signature of person authorized to sign)		BY _____ (Signature of Contracting Officer)	

SECTION 09965A (Amendment 0002)

PAINTING: HYDRAULIC STRUCTURES

PART 1 GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to in the text by basic designation only.

AMERICAN NATIONAL STANDARDS INSTITUTE (ANSI)

ANSI Z87.1 (1989; Errata; Z87.1a) Occupational and Educational Eye and Face Protection

ANSI Z358.1 (1990) Emergency Eyewash and Shower Equipment

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

ASTM D 1186 (1993) Nondestructive Measurement of Dry Film Thickness of Nonmagnetic Coatings Applied to a Ferrous Base

ASTM D 1400 (1994) Nondestructive Measurement of Dry Film Thickness of Nonconductive Coatings Applied to a Nonferrous Metal Base

ASTM D 4417 (1993; R 1999) Field Measurement of Surface Profile of Blast Cleaned Steel

CODE OF FEDERAL REGULATIONS (CFR)

29 CFR 1910 Occupational Safety and Health Standards

29 CFR 1910.20 Access to Employee Exposure and Medical Records

29 CFR 1910.94 Ventilation

29 CFR 1910.134 Respiratory Protection

29 CFR 1910.146 Permit-required Confined Spaces

29 CFR 1910, Subpart I Personal Protective Equipment

29 CFR 1926 Safety and Health Regulations for Construction

29 CFR 1926.62 Lead

#### ENGINEERING MANUALS (EM)

EM 385-1-1 (1996) U.S. Army Corps of Engineers Safety and Health Requirements Manual

#### FEDERAL STANDARDS (FED-STD)

FED-STD-595 (Rev B, Notice 1) Colors Used in Government Procurement

#### NATIONAL FIRE PROTECTION ASSOCIATION (NFPA)

NFPA 70 (1999) National Electrical Code

#### NATIONAL INSTITUTE FOR OCCUPATIONAL SAFETY AND HEALTH (NIOSH)

NIOSH Pub No. 98-119 (1998, 4<sup>th</sup> Ed., 2<sup>nd</sup> Supplement) NIOSH Manual of Analytical Methods

#### THE SOCIETY FOR PROTECTIVE COATINGS (SSPC)

SSPC QP 1 (1998) Standard Procedure for Evaluating Qualifications of Painting Contractors

SSPC Paint 16 (1991) Coal Tar Epoxy-Polyamide Black (or Dark Red) Paint

SSPC SP 1 (1982) Solvent Cleaning

SSPC SP 5/NACE 1 (1994) White Metal Blast Cleaning

## 1.2 SUBMITTALS

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government. The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

SD-04 Samples

#### Specification and Proprietary Paints ; G,

The Contractor shall submit samples of all special paint formula, Military, Master Painter Institute, Commercial Item Description, and SSPC paints. For products that are specified to be applied in accordance with the manufacturer's recommendations the Contractor shall submit the paint producers product data sheet or other written instructions for those products. When the required quantity of any type is 50 gallons or less, the Contractor shall submit in lieu of the liquid paint sample:

- a. A certified test report showing the results of required tests made on the material and a statement that it meets all of the specification requirements.
- b. A certified test report showing the results of required tests made on a previous batch of paint produced by the same firm using the same ingredients and formulation except for minor differences necessitated by a color change and a statement that the previous batch met all of the specification requirements. A report of tests on the proposed batch showing the following properties applicable to the material specifications shall be furnished: color, gloss, drying time, opacity, viscosity, weight per gallon (liter), and fineness of grind.

#### Thinners ; G,

Samples shall be submitted of the thinners which are those solvents used to reduce the viscosity of the paint.

#### SD-06 Test Reports

##### Inspection and Operation Records ; G,

The Contractor shall submit records of inspections and operations performed in accordance with paragraph INSPECTION. Submittals shall be made on a daily basis.

#### SD-07 Certificates

##### Qualifications and Experience ; G,

The Contractor shall submit certification pursuant to paragraph QUALIFICATIONS for all job sites. Submittal of the qualifications and experience of any additional qualified and competent persons employed to provide on-site environmental, safety, and health shall also be provided. Acceptance of this submission must be obtained prior to the submission of other required environmental, safety, and health submittal items.

##### Qualified Painting Contractor ; G,

The Contractor shall submit a copy of their current SSPC QP 1 certification.

Qualified Coating Thickness Gages ; G,

Documentation of manufacturer's certification shall be submitted for all coating thickness gages.

### 1.3 QUALIFICATIONS

Qualifications and experience shall comply with the following.

#### 1.3.2 Certified Laboratory

The Contractor shall provide documentation, which includes the name, address, and telephone number of the laboratories to be providing services. In addition, the documentation shall indicate that each laboratory is an EPA National Lead Laboratory Accreditation Program (NLLAP) accredited laboratory and that each is rated proficient in the NIOSH/EPA Environmental Lead Proficiency Analytical Testing Program (ELPAT) and will document the date of current accreditation. Certification shall include accreditation for heavy metal analysis, list of experience relevant to analysis of lead in air, and a Quality Assurance and Quality Control Program.

#### 1.3.3 Qualified Painting Contractor

The Contractor shall be a certified SSPC-QP 1 Painting Contractor.

#### 1.3.4 Qualified Paint Applicator

Documentation of certification shall be submitted for all paint applicators. Prior to the initiation of any work all paint applicators shall be tested and certified as meeting the requirements of the qualified paint applicator. Certification shall be administered by the Government-approved independent third party Test Agency. Applicators failing the certification test shall not be permitted to apply any paint on the project.

##### 1.3.4.1 Test Plate

The test plate shall consist of a 6 feet by 6 feet steel plate with a 3/8- inch minimum thickness. The test plate shall have at least six bolts, three with bolt heads exposed and three with threads exposed, a 12-inch wide flange and a 6-inch diameter pipe each 18 inches long welded perpendicular to the test panel and a 6-inch deep T-beam with sealed ends welded horizontal across the test panel one foot up from the bottom all within the area to be painted on one side. Bolts shall be 1- inch minimum diameter.

##### 1.3.4.2 Certification Test Procedure

Certification testing of paint applicators shall be conducted at the job site in coordination with the Contracting Officer. The Contractor shall supply the fabricated test plates to be used for the tests and shall provide crane service, rigging, and any other work necessary to provide accessibility for the certification testing and inspection. In preparation, the Contractor shall clean and prepare the test plates in accordance with the requirements of the contracted work. Abrasive blasting shall be performed with the blast media to be used in the contract. The paints to be applied shall be the Contractor supplied materials and shall be those previously tested and approved for use on the contract. Paints shall be applied as specified in the contract. The painter being tested shall mix and thin the paints to be used in the test and shall set up and adjust the application equipment for use. Each painter shall apply each of the types of paint comprising the specified system. The test plate shall be painted in a near vertical position.

#### 1.3.4.3 Certification Criteria

The paint applicator shall be evaluated based on the conformance of the applied paint system to the requirements of the specifications. Deficiencies in the coatings, improper mixing or improper application methods are basis for failure. The Test Agency shall be the sole judge as to the acceptability of each paint applicators performance.

#### 1.3.5 Coating Thickness Gage Qualification

Documentation of certification shall be submitted for all coating thickness gages. Magnetic flux thickness gages as described in ASTM D 1186 shall be used to make all coating thickness measurements on ferrous metal substrates. Eddy current thickness gages as described in ASTM D 1400 shall be used to measure coating thickness on all nonferrous metal substrates. Gages shall have an accuracy of +/- 3 percent or better. Gages to be used on the job shall be certified by the manufacturer as meeting these requirements.

### 1.4 SAMPLING AND TESTING

The Contractor shall allow at least 30 days for sampling and testing. Sampling may be at the jobsite or source of supply. The Contractor shall notify the Contracting Officer when the paint and thinner are available for sampling. Sampling of each batch shall be witnessed by the Contracting Officer unless otherwise specified or directed. A 1-quart sample of paint and thinner shall be submitted for each batch proposed for use. The sample shall be labeled to indicate formula or specification number and nomenclature, batch number, batch quantity, color, date made, and applicable project contract number. Samples shall be submitted to US Army CERL, ATTN: Paint Laboratory, 2902 Farber Drive, Champaign, IL 61821. Testing will be performed by the Government. Costs for retesting rejected material will be borne by the Contractor.

## 1.5 SAFETY AND HEALTH PROVISIONS

Work shall be performed in accordance with the requirements of 29 CFR 1910, 29 CFR 1926, EM 385-1-1, and other references as listed herein. Matters of interpretation of the standards shall be submitted to the Contracting Officer for resolution before starting work. Where the regulations conflict, the most stringent requirements shall apply. Paragraph SAFETY AND HEALTH PROVISIONS supplements the requirements of EM 385-1-1, paragraph (1). In any conflict between Section 01 of EM 385-1-1 and this paragraph, the provisions herein shall govern.

### 1.5.1 Abrasive Blasting

The Contractor shall comply with the requirements in Section 06.H of EM 385-1-1.

#### 1.5.1.1 Hoses And Nozzles

In addition to the requirements in Section 20 of EM 385-1-1, hoses and hose connections of a type to prevent shock from static electricity shall be used. Hose lengths shall be joined together by approved couplings of a material and type designed to prevent erosion and weakening of the couplings. The couplings and nozzle attachments shall fit on the outside of the hose and shall be designed to prevent accidental disengagement.

#### 1.5.1.2 Workers Other Than Blasters

Workers other than blasting operators working in close proximity to abrasive blasting operations shall be protected by utilizing MSHA/NIOSH-approved half-face or full-face air purifying respirators equipped with high-efficiency particulate air (HEPA) filters, eye protection meeting or exceeding ANSI Z87.1 and hearing protectors (ear plugs and/or ear muffs) providing a noise reduction rating of at least 20 dBA or as needed to provide adequate protection.

### 1.5.2 Cleaning with Compressed Air

Cleaning with compressed air shall be in accordance with Section 20.B.5 of EM 385-1-1 and personnel shall be protected as specified in 29 CFR 1910.134.

### 1.5.3 Cleaning with Solvents

#### 1.5.3.1 Ventilation

Ventilation shall be provided where required by 29 CFR 1910.146 or where the concentration of solvent vapors exceeds 10 percent of the Lower Explosive Limit (LEL). Ventilation shall be in accordance with 29 CFR 1910.94, paragraph (c)(5).

### 1.5.3.2 Personal Protective Equipment

Personal protective equipment shall be provided where required by 29 CFR 1910.146 and in accordance with 29 CFR 1910, Subpart I.

### 1.5.4 Pretreatment of Metals and Concrete with Acids

#### 1.5.4.1 Personal Protective Equipment

Personnel shall be protected in accordance with 29 CFR 1910, Subpart I.

#### 1.5.4.2 Emergency Equipment

In addition to the requirements of Section 05 of EM 385-1-1, the Contractor shall provide an eyewash in accordance with ANSI Z358.1, paragraph (6).

### 1.5.5 Mixing Epoxy and Polyurethane Resin Formulations

#### 1.5.5.1 Exhaust Ventilation

Local exhaust ventilation shall be provided in the area where the curing agent and resin are mixed. This ventilation system shall be capable of providing at least 100 linear fpm of capture velocity measured at the point where the curing agent and resin contact during mixing.

#### 1.5.5.2 Personal Protective Equipment

Exposure of skin and eyes to epoxy resin components shall be avoided by wearing appropriate chemically resistant gloves, apron, safety goggles, and face shields meeting or exceeding the requirements of ANSI Z87.1.

#### 1.5.5.3 Medical Precautions

Individuals who have a history of sensitivity to epoxy or polyurethane resin systems shall be medically evaluated before any exposure can occur. Individuals who are medically evaluated as exhibiting a sensitivity to epoxy resins shall not conduct work tasks or otherwise be exposed to such chemicals. Individuals who develop a sensitivity shall be immediately removed from further exposure and medically evaluated.

#### 1.5.5.4 Emergency Equipment

A combination unit, comprised of an eyewash and deluge shower, within close proximity to the epoxy or polyurethane resin mixing operation shall be provided in accordance with ANSI Z358.1, paragraph (9).

## 1.5.6 Paint Application

### 1.5.6.1 Ventilation

When using solvent-based paint in confined spaces, ventilation shall be provided to exchange air in the space at a minimum rate of 5,000 cubic feet per minute per spray gun in operation. It may be necessary to install both a mechanical supply and exhaust ventilation system to effect adequate air changes within the confined space. All air-moving devices shall be located and affixed to an opening of the confined space in a manner that assures that the airflow is not restricted or short circuited and is supplied in the proper direction. Means of egress shall not be blocked. Ventilation shall be continued after completion of painting and through the drying phase of the operation. If the ventilation system fails or the concentration of volatiles exceeds 10 percent of the LEL (except in the zone immediately adjacent to the spray nozzle), painting shall be stopped and spaces evacuated until such time that adequate ventilation is provided. An audible alarm that signals system failure shall be an integral part of the ventilation system. The effectiveness of the ventilation shall be checked by using ventilation smoke tubes and making frequent oxygen and combustible gas readings during painting operations. Exhaust ducts shall discharge clear of the working areas and away from possible sources of ignition.

### 1.5.6.2 Explosion Proof Equipment

Electrical wiring, lights, and other equipment located in the paint spraying area shall be of the explosion proof type designed for operation in Class I, Division 1, Group D, hazardous locations as required by the NFPA 70. Electrical wiring, motors, and other equipment, outside of but within 20 feet of any spraying area, shall not spark and shall conform to the provisions for Class I, Division 2, Group D, hazardous locations. Electric motors used to drive exhaust fans shall not be placed inside spraying areas or ducts. Fan blades and portable air ducts shall be constructed of nonferrous materials. Motors and associated control equipment shall be properly maintained and grounded. The metallic parts of air-moving devices, spray guns, connecting tubing, and duct work shall be electrically bonded and the bonded assembly shall be grounded.

### 1.5.6.3 Further Precautions

- a. Workers shall wear nonsparking safety shoes.
- b. Solvent drums taken into the spraying area shall be placed on nonferrous surfaces and shall be grounded. Metallic bonding shall be maintained between containers and drums when materials are being transferred.
- c. Insulation on all power and lighting cables shall be inspected to ensure that the insulation is in excellent working condition and is free of all cracks and worn spots. Cables shall be further inspected to ensure that no connections are within 50 feet of the operation, that lines are not overloaded, and that they are suspended with sufficient slack to prevent undue stress or chafing.

#### 1.5.6.4 Ignition Sources

Ignition sources, to include lighted cigarettes, cigars, pipes, matches, or cigarette lighters shall be prohibited in area of solvent cleaning, paint storage, paint mixing, or paint application.

#### 1.5.7 Health Protection

##### 1.5.7.1 Air Sampling

The Contractor shall perform air sampling and testing as needed to assure that workers are not exposed to contaminants above the permissible exposure limit. In addition, the Contractor shall provide the Contracting Officer with a copy of the test results from the laboratory within five working days of the sampling date and shall provide results from direct-reading instrumentation on the same day the samples are collected.

##### 1.5.7.2 Respirators

During all spray painting operations, spray painters shall use approved SCBA or SAR (air line) respirators, unless valid air sampling has demonstrated contaminant levels to be consistently within concentrations that are compatible with air-purifying respirator Assigned Protection Factor (APF). Persons with facial hair that interferes with the sealing surface of the facepiece to face seal or interferes with respirator valve function shall not be allowed to perform work requiring respiratory protection. Air-purifying chemical cartridge/canister half- or full-facepiece respirators that have a particulate prefilter and are suitable for the specific type(s) of gas/vapor and particulate contaminant(s) may be used for nonconfined space painting, mixing, and cleaning (using solvents). These respirators may be used provided the measured or anticipated concentration of the contaminant(s) in the breathing zone of the exposed worker does not exceed the APF for the respirator and the gas/vapor has good warning properties or the respirator assembly is equipped with a NIOSH-approved end of service life indicator for the gas(es)/vapor anticipated or encountered. Where paint contains toxic elements such as lead, cadmium, chromium, or other toxic particulates that may become airborne during painting in nonconfined spaces, air-purifying half- and full-facepiece respirators or powered air-purifying respirators equipped with appropriate gas vapor cartridges, in combination with a high-efficiency filter, or an appropriate canister incorporating a high-efficiency filter, shall be used.

##### 1.5.7.3 Protective Clothing and Equipment

All workers shall wear safety shoes or boots, appropriate gloves to protect against the chemical to be encountered, and breathable, protective, full-body covering during spray-painting applications. Where necessary for emergencies, protective equipment such as life lines, body harnesses, or other means of personnel removal shall be used during confined-space work.

## 1.6 PAINT PACKAGING, DELIVERY, AND STORAGE

Paints shall be processed and packaged to ensure that within a period of one year from date of manufacture, they will not gel, liver, or thicken deleteriously, or form gas in the closed container. Paints, unless otherwise specified or permitted, shall be packaged in standard containers not larger than 5 gallons, with removable friction or lug-type covers. Containers for vinyl-type paints shall be lined with a coating resistant to solvents in the formulations and capable of effectively isolating the paint from contact with the metal container. Each container of paint or separately packaged component thereof shall be labeled to indicate the purchaser's order number, date of manufacture, manufacturer's batch number, quantity, color, component identification and designated name, and formula or specification number of the paint together with special labeling instructions, when specified. Paint shall be delivered to the job in unbroken containers. Paints that can be harmed by exposure to cold weather shall be stored in ventilated, heated shelters. All paints shall be stored under cover from the elements and in locations free from sparks and flames.

## PART 2 PRODUCTS

### 2.1 SPECIAL PAINT FORMULAS

Special paints shall have the composition as indicated in the formulas listed herein. Where so specified, certain components of a paint formulation shall be packaged in separate containers for mixing on the job. If not specified or otherwise prescribed, the color shall be that naturally obtained from the required pigmentation.

### 2.2 PAINT FORMULATIONS

Special paint formulas shall comply with the following:

#### 2.2.1 Formula C-200a, Coal Tar-Epoxy (Black) Paint

The paint shall conform to SSPC Paint 16 manufactured with Type 1 pitch. In addition to standard labeling, container labels shall include the term, Corps of Engineers Formula C-200a.

## PART 3 EXECUTION

### 3.1 CLEANING AND PREPARATION OF SURFACES TO BE PAINTED

#### 3.1.1 General Requirements

Surfaces to be painted shall be cleaned before applying paint or surface treatments. Deposits of grease or oil shall be removed in accordance with SSPC SP 1, prior to mechanical cleaning. Solvent cleaning shall be accomplished with mineral spirits or other low toxicity solvents having a flash point above 100 degrees F. Clean cloths and clean fluids shall be used to avoid leaving a thin film of greasy residue on the surfaces being cleaned. Items not to be prepared or coated shall be protected from damage by the surface preparation methods. Machinery shall

be protected against entry of blast abrasive and dust into working parts. Cleaning and painting shall be so programmed that dust or other contaminants from the cleaning process do not fall on wet, newly painted surfaces, and surfaces not intended to be painted shall be suitably protected from the effects of cleaning and painting operations. Welding of, or in the vicinity of, previously painted surfaces shall be conducted in a manner to prevent weld spatter from striking the paint and to otherwise reduce coating damage to a minimum; paint damaged by welding operations shall be restored to original condition. Surfaces to be painted that will be inaccessible after construction, erection, or installation operations are completed shall be painted before they become inaccessible.

### 3.1.2 Ferrous Surfaces Subject to Severe Exposure

Ferrous surfaces subject to extended periods of immersion or as otherwise required shall be dry blast-cleaned to SSPC SP 5/NACE 1. The blast profile, unless otherwise specified, shall be 1.5 to 2.5 mils as measured by ASTM D 4417, Method C. Appropriate abrasive blast media shall be used to produce the desired surface profile and to give an angular anchor tooth pattern. If recycled blast media is used, an appropriate particle size distribution shall be maintained so that the specified profile is consistently obtained. Steel shot or other abrasives that do not produce an angular profile shall not be used. Weld spatter not dislodged by blasting shall be removed with impact or grinding tools and the areas reblasted prior to painting. Surfaces shall be dry at the time of blasting. Blast cleaning to SSPC SP 5/NACE 1 shall be done in the field and, unless otherwise specifically authorized, after final erection. Within 8 hours after cleaning, prior to the deposition of any detectable moisture, contaminants, or corrosion, all ferrous surfaces blast cleaned to SSPC SP 5/NACE 1 shall be cleaned of dust and abrasive particles by brush, vacuum cleaner, and/or blown down with clean, dry, compressed air, and given the first coat of paint. Upon written request by the Contractor, the Contracting Officer may authorize mill or shop cleaning of assembled or partially assembled components specified to receive Systems Nos. 6-A-Z employing the epoxy zinc-rich primer. The surfaces, if shop blasted, shall be shop coated with the first and second coats of the specified paint system except that the epoxy zinc-rich primed surfaces shall receive an extra single spray coat of the zinc primer at the time field painting is started, as specified in the paint system instructions. The shop coating shall be maintained in good condition by cleaning and touching up of areas damaged during the construction period. If pinpoint or general rusting appears, surfaces shall be reblasted and repainted at no added cost to the Government. Prior to the field application of subsequent coats, soiled areas of the shop coating shall be thoroughly cleaned and all welds or other unpainted or damaged areas shall be cleaned and coated in a manner to make them equivalent to adjacent, undamaged paint surfaces.

### 3.1.3 Damp and Wet Ferrous Metal Surfaces

Ferrous surfaces that are wet with condensation or standing or running water, shall be blast-cleaned to SSPC SP 5/NACE 1. The blast profile, unless otherwise specified, shall be 1.5 to 3.0 mils as measured by ASTM D 4417, Method C. Appropriate abrasive blast media shall be used to produce the desired surface profile and to give an angular anchor tooth pattern. Steel grit or shot media shall not be used. Weld spatter not dislodged by blasting shall be removed with impact or grinding tools and the areas reblasted prior to painting. Surfaces shall be as dry

as possible at the time of blasting. Immediately after cleaning and prior to the formation of extensive corrosion products, all ferrous surfaces blast cleaned to SSPC SP 5/NACE 1 shall be cleaned of residual abrasive particles, and given the first coat of paint. A slightly visible rust bloom shall be permitted on surfaces to be painted.

## 3.2 PAINT APPLICATION

### 3.2.1 General

The finished coating shall be free from holidays, pinholes, bubbles, runs, drops, ridges, waves, laps, excessive or unsightly brush marks, and variations in color, texture, and gloss.

Application of initial or subsequent coatings shall not commence until the Contracting Officer has verified that atmospheric conditions and the surfaces to be coated are satisfactory. Each paint coat shall be applied in a manner that will produce an even, continuous film of uniform thickness. Edges, corners, crevices, seams, joints, welds, rivets, corrosion pits, and other surface irregularities shall receive special attention to ensure that they receive an adequate thickness of paint. Spray equipment shall be equipped with traps and separators and where appropriate, mechanical agitators, pressure gauges, pressure regulators, and screens or filters. Air caps, nozzles, and needles shall be as recommended by the spray equipment manufacturer for the material being applied. Airless-type spray equipment may be used only on broad, flat, or otherwise simply configured surfaces, except that it may be employed for general painting if the spray gun is equipped with dual or adjustable tips of proper types and orifice sizes.

Airless-type equipment shall not be used for the application of vinyl paints.

### 3.2.2 Mixing and Thinning

Paints shall be thoroughly mixed, strained where necessary, and kept at a uniform composition and consistency during application. Paste or dry-powder pigments specified to be added at the time of use shall, with the aid of powered stirrers, be incorporated into the vehicle or base paint in a manner that will produce a smooth, homogeneous mixture free of lumps and dry particles. Where necessary to suit conditions of the surface temperature, weather, and method of application, the paint may be thinned immediately prior to use. Thinning shall generally be limited to the addition of not more than 1 pint per gallon of the proper thinner; this general limitation shall not apply when more specific thinning instructions are provided. Paint that has been stored at low temperature, shall be brought up to at least 70 degrees F before being mixed and thinned, and its temperature in the spray tank or other working container shall not fall below 60 degrees F during the application. Paint that has deteriorated in any manner to a degree that it cannot be restored to essentially its original condition by customary field-mixing methods shall not be used and shall be removed from the project site. Paint and thinner that is more than 1 year old shall be resampled and resubmitted for testing to determine its suitability for application.

### 3.2.3 Atmospheric and Surface Conditions

Paint shall be applied only to surfaces that are above the dew point temperature and that are completely free of moisture as determined by sight and touch. Paint shall not be applied to

surfaces upon which there is detectable frost or ice. Except as otherwise specified, the temperature of the surfaces to be painted and of air in contact therewith shall be not less than 45 degrees F during paint application nor shall paint be applied if the surfaces can be expected to drop to 32 degrees F or lower before the film has dried to a reasonably firm condition. During periods of inclement weather, painting may be continued by enclosing the surfaces and applying artificial heat, provided the minimum temperatures and surface dryness requirements prescribed previously are maintained. Paint shall not be applied to surfaces heated by direct sunlight or other sources to temperatures that will cause detrimental blistering, pinholing, or porosity of the film.

#### 3.2.4 Time Between Surface Preparation and Painting

Surfaces that have been cleaned and/or otherwise prepared for painting shall be primed as soon as practicable after such preparation has been completed but, in any event, prior to any deterioration of the prepared surface.

#### 3.2.5 Method of Paint Application

Unless otherwise specified, paint shall be applied by brush or spray to ferrous and nonferrous metal surfaces. Special attention shall be directed toward ensuring adequate coverage of edges, corners, crevices, pits, rivets, bolts, welds, and similar surface irregularities. Other methods of application to metal surfaces shall be subject to the specific approval of the Contracting Officer. Paint on plaster, concrete, or other nonmetallic surfaces shall be applied by brush, roller, and/or spray.

#### 3.2.6 Coverage and Film Thickness

Film thickness or spreading rates shall be as specified hereinafter. Where no spreading rate is specified, the paint shall be applied at a rate normal for the type of material being used. In any event, the combined coats of a specified paint system shall completely hide base surface and the finish coats shall completely hide undercoats of dissimilar color.

##### 3.2.6.1 Measurement on Ferrous Metal

Where dry film thickness requirements are specified for coatings on ferrous surfaces, measurements shall be made with a gage qualified in accordance with paragraph Coating Thickness Gage Qualification. They shall be calibrated and used in accordance with ASTM D 1186. They shall be calibrated using plastic shims with metal practically identical in composition and surface preparation to that being coated, and of substantially the same thickness except that for measurements on metal thicker than 1/4 inch, the instrument may be calibrated on metal with a minimum thickness of 1/4 inch. Frequency of measurements shall be as recommended for field measurements by ASTM D 1186 and reported as the mean for each spot determination. The instruments shall be calibrated or calibration verified prior to, during, and after each use.

### 3.2.7 Progress of Painting Work

Where field painting on any type of surface has commenced, the complete painting operation, including priming and finishing coats, on that portion of the work shall be completed as soon as practicable, without prolonged delays. Sufficient time shall elapse between successive coats to permit them to dry properly for recoating, and this period shall be modified as necessary to suit adverse weather conditions. Paint shall be considered dry for recoating when it feels firm, does not deform or feel sticky under moderate pressure of the finger, and the application of another coat of paint does not cause film irregularities such as lifting or loss of adhesion of the undercoat. All coats of all painted surfaces shall be unscarred and completely integral at the time of application of succeeding coats. At the time of application of each successive coat, undercoats shall be cleaned of dust, grease, overspray, or foreign matter by means of airblast, solvent cleaning, or other suitable means. Cement and mortar deposits on painted steel surfaces, not satisfactorily removed by ordinary cleaning methods, shall be brush-off blast cleaned and completely repainted as required. Undercoats of high gloss shall, if necessary for establishment of good adhesion, be scuff sanded, solvent wiped, or otherwise treated prior to application of a succeeding coat. Field coats on metal shall be applied after erection except as otherwise specified and except for surfaces to be painted that will become inaccessible after erection.

### 3.2.8 Contacting Surfaces

When riveted or ordinary bolted contact is to exist between surfaces of ferrous or other metal parts of substantially similar chemical composition, such surfaces will not be required to be painted, but any resulting crevices shall subsequently be filled or sealed with paint. Contacting metal surfaces formed by high-strength bolts in friction-type connections shall not be painted. Where a nonmetal surface is to be in riveted or bolted contact with a metal surface, the contacting surfaces of the metal shall be cleaned and given three coats of the specified primer. Unless otherwise specified, corrosion-resisting metal surfaces, including cladding therewith, shall not be painted.

### 3.2.9 Drying Time Prior to Immersion

Minimum drying periods after final coat prior to immersion shall be: epoxy systems at least 5 days, vinyl-type paint systems at least 3 days, and cold-applied coal tar systems at least 7 days. Minimum drying periods shall be increased twofold if the drying temperature is below 65 degrees F and/or if the immersion exposure involves considerable abrasion.

### 3.2.10 Protection of Painted Surfaces

Where shelter and/or heat are provided for painted surfaces during inclement weather, such protective measures shall be maintained until the paint film has dried and discontinuance of the measures is authorized. Items that have been painted shall not be handled, worked on, or otherwise disturbed until the paint coat is fully dry and hard. All metalwork coated in the shop or field prior to final erection shall be stored out of contact with the ground in a manner and location that will minimize the formation of water-holding pockets; soiling, contamination,

and deterioration of the paint film, and damaged areas of paint on such metalwork shall be cleaned and touched up without delay. The first field coat of paint shall be applied within a reasonable period of time after the shop coat and in any event before weathering of the shop coat becomes extensive.

### 3.2.11 Coal Tar-Epoxy (Black) Paint (Formula C-200a)

#### 3.2.11.1 Mixing

Component B shall be added to previously stirred Component A and thoroughly mixed together with a heavy-duty mechanical stirrer just prior to use. The use of not more than 1 pint of xylene thinner per 1 gallon of paint will be permitted to improve application properties and extend pot life. The pot life of the mixed paint, extended by permissible thinning, may vary from 2 hours in very warm weather to 5 or more hours in cool weather. Pot life in warm weather may be extended by precooling the components prior to mixing; cooling the mixed material; and/or by slow, continuous stirring during the application period. The mixed material shall be applied before unreasonable increases in viscosity take place.

#### 3.2.11.2 Application

Spray guns shall be of the conventional type equipped with a fluid tip of approximately 0.09 inch in diameter and external atomization, seven-hole air cap. Material shall be supplied to the spray gun from a bottom withdrawal pot or by means of a fluid pump; hose shall be 1/2 inch in diameter. Atomization air pressure shall not be less than 80 psi. High-pressure airless spray equipment may be used only on broad, simply configured surfaces. Brush application shall be with a stiff-bristled tool heavily laden with material and wielded in a manner to spread the coating smoothly and quickly without excessive brushing. The coverage rate of the material is approximately 110 square feet per gallon per coat to obtain 20 mils (dry thickness) in a two-coat system. The paint shall flow together and provide a coherent, pinhole-free film. The direction of the spray passes (or finish strokes if brushed) of the second coat shall be at right angles to those of the first where practicable.

#### 3.2.11.3 Subsequent Coats

Except at the high temperatures discussed later in this paragraph, the drying time between coal tar-epoxy coats shall not be more than 72 hours, and application of a subsequent coat as soon as the undercoat is reasonably firm is strongly encouraged. Where the temperature for substrate or coating surfaces during application or curing exceeds or can be expected to exceed 125 degrees F as the result of direct exposure to sunlight, the surfaces shall be shaded by overhead cover or the interval between coats shall be reduced as may be found necessary to avoid poor intercoat adhesion. Here, poor intercoat adhesion is defined as the inability of two or more dried coats of coal tar-epoxy paint to resist delamination when tested aggressively with a sharp knife. Under the most extreme conditions involving high ambient temperatures and sun-exposed surfaces, the drying time between coats shall not exceed 10 hours, and the reduction of this interval to a few hours or less is strongly encouraged. Where the curing time of a coal tar-epoxy undercoat exceeds 72 hours of curing at normal temperatures, 10 hours at

extreme conditions, or where the undercoat develops a heavy blush, it shall be given one of the following treatments before the subsequent coat is applied:

- a. Etch the coating surface lightly by brush-off blasting, using fine sand, low air pressure, and a nozzle-to-surface distance of approximately 3 feet.
- b. Remove the blush and/or soften the surface of the coating by wiping it with cloths dampened with 1-methyl-2-pyrrolidone. The solvents may be applied to the surface by fog spraying followed by wiping, but any puddles of solvent must be mopped up immediately after they form. The subsequent coat shall be applied in not less than 15 minutes or more than 3 hours after the solvent treatment.

#### 3.2.11.4 Ambient Temperature

Coal tar-epoxy paint shall not be applied when the receiving surface or the ambient air is below 50 degrees F nor unless it can be reasonably anticipated that the average ambient temperature will be 50 degrees F or higher for the 5-day period subsequent to the application of any coat.

#### 3.2.11.5 Safety

In addition to the safety provisions in paragraph SAFETY AND HEALTH PROVISIONS, other workmen as well as painters shall avoid inhaling atomized particles of coal tar-epoxy paint and contact of the paint with the skin.

### 3.3 PAINT SYSTEMS APPLICATION

The required paint systems and the surfaces to which they shall be applied are shown in this paragraph, and/or in the drawings. Supplementary information follows.

#### 3.3.1 Fabricated and Assembled Items

Items that have been fabricated and/or assembled into essentially their final form and that are customarily cleaned and painted in accordance with the manufacturer's standard practice will be exempted from equivalent surface preparation and painting requirements described herein, provided that:

- a. Surfaces primed (only) in accordance with such standard practices are compatible with specified field-applied finish coats.
- b. Surfaces that have been primed and finish painted in accordance with the manufacturer's standard practice are of acceptable color and are capable of being satisfactorily touched up in the field.

c. Items expressly designated herein to be cleaned and painted in a specified manner are not coated in accordance with the manufacturer's standard practice if different from that specified herein.

### 3.3.2 Surface Preparation

The method of surface preparation and pretreatment shown in the tabulation of paint systems is for identification purposes only. Cleaning and pretreatment of surfaces prior to painting shall be accomplished in accordance with detailed requirements previously described.

### 3.3.3 System No. 6

Paint shall be spray or brush applied with a minimum of two coats to provide a minimum total thickness at any point of 16 mils. The specified film thickness shall be attained in any event, and any additional (beyond two) coats needed to attain specified thickness shall be applied at no additional cost to the Government.

## 3.4 INSPECTION

The Contractor shall inspect, document, and report all work phases and operations on a daily basis. As a minimum the daily report shall contain the following:

- a. Inspections performed, including the area of the structure involved and the results of the inspection.
- b. Surface preparation operations performed, including the area of the structure involved, the mode of preparation, the kinds of solvent, abrasive, or power tools employed, and whether contract requirements were met.
- c. Thinning operations performed, including thinners used, batch numbers, and thinner/paint volume ratios.
- d. Application operations performed, including the area of the structure involved, mode of application employed, ambient temperature, substrate temperature, dew point, relative humidity, type of paint with batch numbers, elapsed time between surface preparation and application, elapsed time for recoat, condition of underlying coat, number of coats applied, and if specified, measured dry film thickness or spreading rate of each new coating.

## 3.5 FINAL CLEANING AND CLEARANCE TESTING FOR LEAD CONTAMINANTS

All facilities and surfaces within or directly adjacent to the regulated area shall be cleaned and decontaminated using phosphate detergents and HEPA vacuums as necessary to provide surfaces that are clean of residual lead dust. Clearance testing shall be performed. A sufficient number of wipe tests shall be performed to document the level of residual lead contamination. No surface shall have greater than 8,000 micrograms of lead per square foot.

### 3.6 PAINTING SCHEDULES

#### SYSTEM NO. 6

Items or surfaces to be coated: All ferrous surfaces of the trash racks

SURFACE PREPARATION	1st COAT	2nd COAT	3rd COAT
White metal blast cleaning	Coal tar- epoxy C-200a (black)	Coal tar- epoxy C-200a (black)	Coal tar- epoxy C-200a (black) (if needed to attain required thickness)

-- End Of Section --