

The Sherwin-Williams Co.
Marine Services Division
1408 N 23rd Street
Manitowoc, WI 54220
(715)214-6071 FAX (920)682-2269

Date April 26, 2011
Project Psub--Steel Hulled Vessel
acc. no. 5858-4957-3



Prepared By: Rick Gallenberger
 Coatings Representative
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SURFACE PREPARATION

AREAS TO BE COATED	COAT	Abrasive Blast with a non-metallic abrasive to achieve a 2.0-2.5 mil profile as per SSPC-SP10. Apply first coat of paint within 24 hours of blast. *Sharp edges of immersion surfaces must be broken for coating edge retention/protection.				VOLUME SOLIDS	WET MIL THICKNESS		DRY MIL THICKNESS		OVERCOAT TIME @ 77°F and 50% RH	Notes	PRACTICAL SPREADING RATE: FT ² /GALLON WITH 25% LOSS FACTOR
		DESCRIPTION	DATA PAGE	PRODUCT NUMBER	COLOR		MIN	MAX	MIN	MAX			
Exterior Pressure Hull--Incidental Immersion Service	1	Macropoxy 646 Fast Cure Epoxy	4.53	B58W610-Part A B58V600-Part B	White*	72%	7.0	13.5	5.0	10.0	8 hours	Stripe Coat Welds and Sharp Edges or Full Coat	
	2	Macropoxy 646 Fast Cure Epoxy	4.53	B58W610-Part A B58V600-Part B	White*	72%	7.0	13.5	5.0	10.0	8 hours		200
	3	Hi Solids Polyurethane	5.21	B65W311-Part A B65V30-Part B	White*	65%	4.5	8.0	3.0	5.0		Urethane Coatings Are Not Recommended for Extended Periods of Immersion	175

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* Variations of prime coat colors and/or topcoat based on owners discretion.

SURFACE PREPARATION

AREAS TO BE COATED	COAT	Hand Tool Clean/Power Tool Clean to the standard of SSPC-SP2/SP3.				VOLUME SOLIDS	WET MIL THICKNESS		DRY MIL THICKNESS		OVERCOAT TIME @ 77°F and 50% RH	Notes	PRACTICAL SPREADING RATE: FT ² /GALLON WITH 25% LOSS FACTOR
		DESCRIPTION	DATA PAGE	PRODUCT NUMBER	COLOR		MIN	MAX	MIN	MAX			
Interior Pressure Hull	1	EuroNavy ES301K Surface/Moisture Tolerant ER Epoxy	9.59	6501-58389-Part A 6501-58330-Part B	Light Gray	97%	4.0	6.0	4.0	6.0	16 hours	Stripe Coat Welds and Sharp Edges or Full Coat	
	2	EuroNavy ES301K Surface/Moisture Tolerant ER Epoxy	9.59	6501-58389-Part A 6501-58330-Part B	Light Gray	97%	4.0	6.0	4.0	6.0			250

All overcoat times are temperature and humidity dependent

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March 27, 2019

This Excel "work book" file contains four work sheets including this one. If you are not familiar with Excel "workbook" look at the bottom of the sheet and you will see four tabs, one for each spreadsheet; Notes, Specs without pricing, Specs with pricing and SSPC Standards.

To view a work sheet, click on the tab and that sheet will open. On both of the spec sheets I have included several copies (scroll down to view) of the format. There are several sample coatings systems and several blank forms.

When you print these forms you will need to use legal size paper for the "specs with pricing" and regular paper for the "specs without pricing".

Should you have any questions or comments, please, let me know.

Frank

SSPC STANDARDS

SSPC-SP 1	The surface is to be prepared to meet the requirements of SSPC-SP 1 Solvent Cleaning, dated Nov. 1, 1982, includes editorial changes 9/1/00
SSPC-SP 2	The surface is to be prepared to meet the requirements of SSPC-SP 2 Hand Tool Cleaning dated Nov. 1, 1982, includes editorial changes 9/1/00
SSPC-SP 3	The surface is to be prepared to meet the requirements of SSPC-SP 3 Power Tool Cleaning dated Nov. 1, 1982, includes editorial changes 9/1/00
SSPC-SP 5/NACE No. 1	The surface is to be prepared to meet the requirements of SSPC-SP 5/NACE No. 1 White Metal Blast Cleaning dated Sept. 1, 2000
SSPC-SP 6/NACE No. 3	The surface is to be prepared to meet the requirements of SSPC-SP 6/NACE No. 3 Commercial Blast Cleaning dated Sept. 1, 2000
SSPC-SP 7/NACE No. 4	The surface is to be prepared to meet the requirements of SSPC-SP 7/NACE No. 4 Brush-Off Blast Cleaning dated Sept. 1, 2000
SSPC-SP 8	The surface is to be prepared to meet the requirements of SSPC-SP 8 Pickling dated Nov. 1, 1982, includes editorial changes 9/1/00
SSPC-SP 10/NACE No. 2	The surface is to be prepared to meet the requirements of SSPC-SP 10/NACE No. 2 Near-White Blast Cleaning dated Sept. 1, 2000
SSPC-SP 11	The surface is to be prepared to meet the requirements of SSPC-SP 11 Power tool cleaning to Bare Metal dated Nov. 1, 1987, includes editorial changes 9/1/00
SSPC-SP 12/NACE No. 5 WJ-1	The surface is to be prepared to meet the requirements of SSPC-SP 12/NACE No. 5 Surface Preparation and Cleaning of Steel and Other Hard Materials by High- and Ultrahigh-Pressure Water Jetting Prior to Recoating
SSPC-SP 12/NACE No. 5 WJ-2	SSPC-SP 12/NACE No. 5 Surface Preparation and Cleaning of Steel and Other Hard Materials by High- and Ultrahigh-Pressure Water Jetting Prior to Recoating
SSPC-SP 12/NACE No. 5 WJ-3	The surface is to be prepared to meet the requirements of SSPC-SP 12/NACE No. 5 Surface Preparation and Cleaning of Steel and Other Hard Materials by High- and Ultrahigh-Pressure Water Jetting Prior to Recoating
SSPC-SP 12/NACE No. 5 WJ-4	The surface is to be prepared to meet the requirements of SSPC-SP 12/NACE No. 5 Surface Preparation and Cleaning of Steel and Other Hard Materials by High- and Ultrahigh-Pressure Water Jetting Prior to Recoating