

VRISHAL ENGINEERING PRIVATE LIMITED



PROCEDURE FOR SURFACE PREPARATION & PROTECTIVE COATING

CLIENT: AARTI INDUSTRIES LTD, JHAGADIA, ZONE-4

PROJECT: CORAL-2

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1 SCOPE

This specification covers the minimum technical requirement of surface preparation, coating systems selection, application and Quality Inspection requirement for protective coating work on the exterior surfaces of new and repair of carbon steel structural items.

2 PURPOSE

The purpose of this document is to specify minimum requirements for the surface preparation and protective coating application to external surfaces of structure and piping both in the shop or site for the CORAL-2 Project

3 DISTRIBUTION & INTENDED AUDIENCE

AIL: AARTI INDUSTRIES LTD, JHAGADIA, ZONE-4

AIL-TPI

VEPL: VRISHAL ENGINEERING PRIVATE LIMITED

4 SAFETY

Appropriate safety equipment shall be provided for blasters, painters and other workers involved in surface preparation and application of painting. Work area shall be adequately ventilated. Safety permits as necessary to carry out the operations shall be obtained.

5 CODES & STANDARDS

The surface preparation and protective coating shall be in accordance with the latest revision of the specifications, codes and standards.

- SSPC (Steel Structures Painting Council)
 - ✓ Volume 1 Good Painting Practice
 - ✓ Volume 2 Systems and Specifications
- ISO 8501-1
- Swedish Standard

- SIS 05 59 00 Pictorial Surface Preparation Standard for Painting Steel Surfaces
- RAL & Munsell Book of color
- ANSI Z53.1 Safety color code for marking physical hazards
- ANSI A13.1 Scheme for the identification of piping systems
- BS 1710 Identification of pipe lines and services

6 EXTENT OF PAINTING

Structural steel & Piping spools shall be externally painted in accordance with the applicable systems of this project specification.

The paint system shall be based on the maximum operating temperature of the structural items & piping spools.

Where the paint system is applied for low temperature service, the effect of lowest temperature shall also be considered.

7 PROCEDURE FOR NEW & REPAIR

➤ SURFACE PREPARATION (BLAST CLEANING, POWER TOOL CLEANING, SOLVENT CLEANING, HAND CLEANING)

- This surface preparation requirement shall be in accordance with the SSPC (Volume 1&2) and the Swedish standard SIS 05 5900. (Reference to Table-1).
- The type of abrasive shall be chilled iron or steel grit, copper slag, alumina, or garnet. The particle size shall be selected to give a surface profile as per applicable coating system on carbon steels.
- Where flange faces, valve components, sight glasses gauges etc. and other items could be damaged by abrasive blast-cleaning or the application of protective coatings they shall be protected by adequate means before surface preparation commences.

- Prior to surface preparation, surface shall be free from all traces of oil and grease. By utilize washing using a detergent dissolved in water followed by rinsing with clean fresh water rather than solvent washing until all traces of oil and grease are removed.
- The blasting nozzles shall be venturi type with tungsten carbide or boron carbide as the materials for liners. Nozzles orifice may vary from 3/16" to 3/4".
- Compressed air shall be free from moisture and oil.
- The abrasives shall be used at a pressure of 7kg/cm² at appropriate distance and angle depending on nozzle size maintaining constant velocity and pressure. Abrasives shall be in the form of shot or grit of size suitable for achieving required anchor profile as specified in coating system.
- Commercial surface finish shall be in accordance with SSPC-SP-6. Near white surfaces shall be in accordance with SSPC-SP-10. White metal surface finish shall be in accordance with SSPC-SP-5. After blasting, any oil, dirt, grease or foreign matter deposited on blasted surfaces shall be cleaned before priming.
- Power tools cleaning shall be in accordance with SSPC-SP 3 and to a visual standard in accordance with SIS 05 5900 to ST3. Metal surface which cannot be blast cleaned due to their location, shall be totally power tools cleaned.
- Solvent cleaning shall be done in accordance with SSPC-SP-1. All the traces or smudges of oil grease (if present) shall be removed by solvent washing after blast cleaning.
- Steel surfaces with loose mill scale, rust and paint etc. may be cleaned by hand, using either or combination of hammer chipping, sanding scrapping and wire brushing in accordance with SSPC-SP 2.
- Blasting & Painting shall only be applied when the relative humidity is less than 85%, the steel temperature is a minimum of 3°C above the dew point.
- Blasting and Painting shall not be carried out in rainy and foggy weather.

➤ PAINT APPLICATION & MIXING

- All containers of coating materials shall be stored un-opened in original condition as supplied by the manufacturer until required for use. The containers should bear the manufacturers label batch numbers and instructions.
- Materials shall be stored in accordance with the manufacturer recommendations. For material having a limited shelf life, the date of manufacture and the length of the life shall be shown. Material older than their stated shelf life shall not be used. Deteriorated coating materials during storage shall not be used.
- During bad weather, rainy area, high wind painting shall not be done. If it is raining either during or immediately after the paint application, the proper steps, such as repainting, shall be taken.
- All ingredients in any container shall be thoroughly mixed before use to have a smooth and a uniform consistency in application. The mixture shall be sufficiently agitated with a power mixture during application until all the pigments, vehicles and catalysts are thoroughly mixed and then strained while being poured into the spray pot. During application the materials shall be agitated according to the manufacturer's recommendation. Coating material shall not be mixed or kept in suspension by using a bubbling air stream.
- Where a skin has formed in the container, the skin shall be cut loose and discarded. If such skins are sufficiently thick to have a practical effect on the composition and quality, the paint shall not be used.
- All pigmented material shall be strained after mixing except where application equipment is provided with adequate strainers. Strainers shall be capable of passing the pigment and removing any skin.
- If a coating material requires the addition of a catalyst the pot life under application condition shall be clearly stated on the label. This pot life shall not be exceeded under any circumstances. When the pot life is reached, the spray pot shall be emptied, cleaned and a new material catalyzed.
- Mixing and thinning direction as furnished the manufacturer shall be followed. Only thinners specified by the manufacturer shall be used.

- When use of thinner is permissible it shall be added during the mixing process. Painters shall not add thinner after it has been thinned to the proper consistency. All thinning shall be done under supervision of one acquainted with the correct amount and type to be added.
- Mixing shall be carried out as per the manufacturer recommendation and mixing details shall be maintained with batch number & quantity wise.

➤ COATING

- Only paint brands recommended as per AIL DESIGN CODE OF SURFACE PREPARATION AND COATING OPERATION “DOC NO. AIL/CS/AMS/EXP/MEC/COD/PAIT/C16/00/03 REV.03 and color mentioned in coating system as per table – 15.
- The paint manufacturer’s recommendation shall be followed for mixing, thinning, storage, application of paint, drying time and weather condition.
- Spraying equipment shall meet the recommendations by the paint supplier. Paint application shall be carried out preferably by air less spray. The mixed coating shall be continuously stirred by mechanical spray pot agitator or other approved means. Coating shall be hand brushed (also roller application) for touch up areas and areas inaccessible to the spray gun. An additional layer of finish coat shall be hand brushed at edges, corners, welds and hard-to-spray areas to eliminate holidays in the final coats.
- Surface shall not be coated in rain, wind, fog, mist or in areas where injurious airborne elements exist, when the steel surface temperature is below 5⁰C, when the difference of steel surface temperatures & dew point is less than 3⁰C or when the relative humidity is greater than 85%.
- Blast cleaning surface shall be coated with one complete application of primer as soon as practicable but in no case later than 4 hours on the same day as abrasive blasted.

- Proper Protection / Shield shall be provided to the interference of Rain, Fog Mist, etc. during painting. The paint application area or blasting area shall be enclosed by suitable methods like enclosed sheds to avoid collection of floating abrasive dust on the wet paint during application of paint on structures, piping and equipment.
- Each coat shall be in a proper state of dryness before the application of succeeding coat. No paint shall be force dried which cause the deterioration of quality of painting. If the inter coating application time limit is exceeded to what have been specified by the paint manufacturer, then to prior re-coating remedial action shall be taken as per paint manufacturer's recommendations.
- Paint film thickness shall be maintained as indicated in coating system as per job specification, which is to be confirmed by suitable film thickness gauge. Each coat shall DFT not less than the minimum thickness indicated in coating system mentioned in specification.
- When paint has been damaged, all damaged and loosely adhering paint shall be removed and surface cleaned mechanically to bare metal. Priming shall be done in the area with primer specified to the required DFT. Then the 2nd& 3rd coat paint shall be applied.
- Proper care shall be taken to prevent damage to painted units during loading, unloading, handling and transport
- Inspection shall be carried out in presence of company representatives as per approved ITP. Inspection shall be carried out after surface preparation and after application of each coat of paint. Inspection shall be carried out to check paint thickness and to ensure that no runs and sags of paint have occurred. Inspection of wet & dry film thickness for primer and finish coat and wet film thickness for intermediate coat shall be carried out. All reading shall be recorded in the prescribe format.
- Edges of structural shapes and irregular coated surfaces shall be coated first and an extra pass made latter.

Following critical things are to be maintained while doing painting with the spray gun:

- Pressure pot, material hose and spray gun shall be kept at the same elevation where possible. When spraying inorganic zinc, the elevation difference shall not exceed 3 m.
- Traps or separators shall be provided to remove oil and condensed water from the air. These traps or separators must be of adequate size and must be drained periodically during operations, the air from the spray gun impinging against the surface shall show no condensed water or oil.
- The length of hose between the pressure pot and spray gun shall not exceed 15 m.
- An adequate moisture trap shall be installed between the air supply and each pressure pot. The trap shall be of the type that will continuously bleed off any water or oil from the air supply.
- Suitable pressure regulators and gauges shall be provided for both the air supply to the pressure pot and the air supply to the spray gun.
- The spray gun shall be held at right angle to the surface.
- Each pass with the spray gun shall overlap the previous pass by 50%.
- The spray width shall not exceed 300 mm. All runs and sags shall be immediately brushed out or the surface recoated.
- Areas inaccessible to the spray gun shall be painted by brush if not accessible by brush daubers or sheepskins shall be used. Brush shall be work paint into cracks crevices and blind spots which are not adequately painted by spray.
- Large surface shall receive two passes (except when applying inorganic zinc) at right angles to each other (crosshatched).

➤ **REPAIR OF DAMAGED AREAS**

Surface where coating is damaged after application of the finish coat shall be repaired as follows:

1. When the topcoat damaged, but base coat undamaged and the metal substrate are not exposed:

- A. Damaged coating shall be removed with a hand file and abraded back to the sound coating using emery paper or a fine grinder.
- B. The damaged area shall be wiped with a suitable solvent to remove debris. The periphery of repair area shall be feathered back for minimum distance of 25 mm into the adjacent undamaged coating by light abrasion or grinding to produce a smooth chamfered surface profile and Feathering of damaged coating edges shall be maintained.
- C. Apply a new topcoat as specified.

2. Coating damaged to base metal:

- A. The damaged area to be repaired must be fresh water washed and dry. Remove any corrosion by means of either hand tools i.e; disc sander or grinder.
- B. Abrade area immediately surrounding repair to provide key for subsequent paint applications.
- C. Checks DFT, if the DFT is as per the specification, then apply 100 micron of Interseal 547 followed by applicable MIO & Final coat as mentioned in the paint system to achieve the system coat DFT as per the specification.
- D. Brush application is acceptable. Even appearance and smooth feathering into surrounding coating in addition to correct dry film thickness and holidays must be achieved. Coating and surrounding repaired areas shall not be damaged and complete tie-in of the coating with surrounding areas shall be damaged.

8 QUALITY ASSURANCE

8.1 Inspection & Testing:

The following checking / testing shall be carried out in various stages of painting job.

➤ Coating Materials

- Check Batch No.: Manufacturing date and expiry date – Correlation with Paint TC.
- Check physical condition of material and printed containers
- Check any hard settling inside the container.
- Check pot life or mixture mentioned in data sheet/MTD
- Covering capacity and hiding power at a specified DFT.

➤ **During / After application**

- Whether conditions: Humidity and temperature of steel surface, ambient temperature & Dew Point
- Surface preparation: Cleanliness & Roughness
- Surface Salt Contamination
- Over-coating Intervals
- Wet film thickness / Dry film thickness
- Visual examination of coating
- Holiday detection
- Adhesion test

8.2 Requirements:

Annexure: - 1

9 PAINT SYSTEM

Annexure: - 2

10 COLOR OF FINAL COAT

- Approve Product list as per AIL Painting Procedure DOC NO. **AIL/CS/AMS/EXP/MEC/COD/PAIT/C16/00/03 REV.03 APPENDIX F.**
- Structural items & Chequered plate: Oxford Blue (IS 105)
- Hand Railing, Monkey ladders, : IS 356 Golden Yellow

- Detailed pipe line color codings are as per Appendix H. Color banding will be made as per IS 2379.

11 ATTACHMENT

1. ATTACHMENT-I: SURFACE PREPARATION & PRIMER PAINT INSPECTION
2. ATTACHMENT-II: MIO PAINT INSPECTION
3. ATTACHMENT-III: FINAL PAINT INSPECTION

TABLE-1

Class	ISO	SSPC	Method	Degree
White Metal Blast cleaning	Sa 3.0	SP 5 SP 8	Sand blast, Grit blast Pickling (Phosphating)	Mill scale and other foreign substances shall be removed completely as steel surface becomes to white metal.
Near-white Blast cleaning	Sa 2.5	SP 10 SP 8	Sand blast, Grit blast Acid pickling (Etching)	Mill scale and other foreign substances shall be removed to approximately 95% degree.
Commercial Blast cleaning	Sa 2.0	SP 6	Sand blast, Grit blast	Mill scale and other foreign substances shall be removed to about 2/3 degree.
Brush off Blast Cleaning	Sa 1.0	SP 7	Sand blast, Grid blast	Loose mill scale, loose rust and other foreign substances shall be removed except firmly adhering mill scale.
Power Tool cleaning	St 3.0	SP 3 *SP11	Wire brushing by disc-sander.	Loose mill scale, loose rust and other foreign substances shall be removed except firmly adhering mill scale. * SP3 + surface roughness $Ry5 > 25$
Hand Tool cleaning	St 2.0	SP 2	Brushing by Hand	Only particularly loose rust and grease shall be removed except firmly adhering mill scale.
Solvent cleaning	-	SP-1	Solvent cleaning	Oil, grease, and dust shall be removed by solvents or alkali cleaning.

Note : ISO:SIS-Swedish Standard Institution and DIN are same specification.

SSPC- Steel Structures Painting Council. (USA)

ANNEXURE-I

Inspection / Test	Parameter / Method	Acceptance Criterion	Extent / Frequency of Inspection and Testing	
			Batch Process	Individual Process
Visual examination prior to blasting	Rust, ISO 8501-1	Grade B or better	100% of all surfaces	100% of all surfaces
	Surface defects	None		
	Oil, grease, liquids	None		
	Radius of curvature	≥ 2 mm		
Environmental conditions	Ambient temperature	Minimum 5°C	At start, middle, and end of each shift	At start, middle, and end of each shift
	Steel Temperature	$T > DP + 3^{\circ}C$ minimum		
	Relative Humidity	$< 85\%$		
Cleanliness of compressed air for blast cleaning	ASTM D 4285	No oil or condensed moisture	Before start of each blast cleaning shift or change in air system	Before start of each blast cleaning shift or change in air system, at least two times per twelve hours
Dust Particle quantity and size	ISO 8502-3	Rating 2 or better	Once on 10% of total no. of components per batch	Area $< 100m^2$: Once
				Area $> 100m^2$: Three checks per Day
Cleanliness	ISO 8501-1	SSPC SP 10	100% of all surfaces	100% for all surfaces
Roughness	ISO 8503	As per clause 5.2.2	Once on each component per batch	Area $< 100m^2$: Once
				Area $> 100m^2$: Three times per Day

Chloride test conductivity	SSPC Guide 15 / ISO 8502-6 / ISO 8502-9	< 50 milligram / m ² for blasted 1 surfaces and < 100 milligram / m ² in maintenance painting	Once on each component per batch	Once for every 300 m ² .
Visual examination of coating	Curing and solvent retention	Full cure, no solvent	100% of all surfaces	100% of all surfaces
	Pinholes, blisters, cracks, etc	No defects		
Holiday detection	ASTM D5162 or NACE SP0188	No holidays	10% of total batch area including welds if size of the components permits	10% of coated area including welds for linings only.
Adhesion	ISO 4624 / ASTM D4541 / ASTMD 3359/ ISO 2409	As per clause 7.10.3	3 determinations per paint batch on test plate	
Curing test (for zinc silicate)	ASTM D 4752	Rating 4 to 5	Once on 10% of total no. of components per batch	Once per 100 m ²
Film Thickness	SSPC PA 2	As per clause 7.10	10% of total batch area	5 spots for every 10 m ² area

ANNAEXURE-II

- Coating System for structural items, handrails, monkey ladders & Chequered plates up to Temperature 120 Degree C.

Coating system – 7:-

STAGE	PAINT REQUIRED	PROFILE / DFT (MICRONS)	REMARKS
SURFACE PREPARATION	-	60-70	SA 2 ½ Grade cleanliness for blasted surface.
PRIMER	INORGANIC ZINC SILICATE : INTERZINC 78I	70	
INTERMEDIATE	HB EPOXY MIO INTERSEAL 547 / INTERSEAL 670 HS / INTERGARD 475HS MIO	150	
FINAL	ACRYLIC ALIPHATIC POLYURETHANE INTERTHANE 990 / INTERTHAN 990SG	60	Final Color code as per the clause no. 10
TOTAL		280 Minimum	

- Coating System for Insulated pipe lines up to Temperature 205 Degree C

Coating system – 2A :- CUI-1

STAGE	PAINT REQUIRED	PROFILE / DFT (MICRONS)	REMARKS
SURFACE PREPARATION	-	60-70	St2/st3 or SA 2 ½ Grade cleanliness for blasted surface.
PRIMER	EPOXY PHENOLIC – NOVOLAC BLEND : INTERBOND 2340 UPC / INTERTHERM 228	100	
TOP COAT	EPOXY PHENOLIC – NOVOLAC BLEND : INTERBOND 2340 UPC / INTERTHERM 228	100	Final Color : As available
TOTAL		200 Minimum	

- Coating System for Insulated pipe lines up to Temperature 205 - 650 Degree C

Coating system – 2B :- CUI-2

STAGE	PAINT REQUIRED	PROFILE / DFT (MICRONS)	REMARKS
SURFACE PREPARATION	-	60-70	St2/st3 or SA 2 ½ Grade cleanliness for blasted surface..
PRIMER	INORGANIC COPOLYMER MATRIX : INTERBOND 1202 UPC	100	
TOP COAT	INORGANIC COPOLYMER MATRIX : INTERBOND 1202 UPC	100	Final Color : As available
TOTAL		200 Minimum	

- Coating System for Uninsulated galvanized pipe lines up to Temperature 120 Degree C

Coating system – 4 :-

STAGE	PAINT REQUIRED	PROFILE / DFT (MICRONS)	REMARKS
SURFACE PREPARATION	-	20 - 30	St2 or SA 1 Grade cleanliness for blasted surface..
PRIMER	LOW VS EPOXY PRIMER SUITABLE FOR GALVANIZED & NON FERROUS SURFACE : INTERSEAL 670 HS	60	
1 st COAT	HB EPOXY MASTIC PRIMER : INTERSEAL 547 / INTERSEAL 670 HS	70	
TOP COAT	ACRYLIC ALIPHATIC POLYURETHANE INTERTHANE 990 / INTERTHAN 990SG	50	Final Color code as per the clause no. 10
TOTAL		180 Minimum	

- Coating System for Uninsulated pipe lines, pipe supports up to Temperature 120 - 600 Degree C

Coating system – 6 :-


STAGE	PAINT REQUIRED	PROFILE / DFT (MICRONS)	REMARKS
SURFACE PREPARATION	-	50-60	SA 2 ½ Grade cleanliness for blasted surface.
PRIMER	INORGANIC ZINC SILICATE: INTERZINC 781 / INTERZINC 2280	75	
1 st COAT	HEAT RESISTANT ALUMINUM PAINT BASED ON SILICON BINDER : INTERTHERM 50	25	
TOP COAT	HEAT RESISTANT ALUMINUM PAINT BASED ON SILICON BINDER : INTERTHERM 50	25	Final Color : As available
TOTAL		125 Minimum	

- Coating System for Uninsulated pipe lines, Pipe supports up to Temperature 120 Degree C

Coating system – 3 :-

STAGE	PAINT REQUIRED	PROFILE / DFT (MICRONS)	REMARKS
SURFACE PREPARATION	-	60 - 70	SA 2 ½ Grade cleanliness for blasted surface.
PRIMER	HB EPOXY MASTIC PRIMER : INTERSEAL 670HS	100	
1 st COAT	EPOXY BLENDED GLASS FLAKE : INTERZONE 954 / INTERZONE 1015	200	
TOP COAT	ACRYLIC ALIPHATIC POLYURETHANE INTERTHANE 990 / INTERTHAN 990SG	50	Final Color code as per the clause no. 10
TOTAL		350 Minimum	

ATTACHMENT – I

 		VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES					
SURFACE PREPARATION & PRIMER PAINT INSPECTION REPORT							
CLIENT		PROJECT		REPORT NO			
WO/PO NO		PROCEDURE NO.		DATE			
WEATHER CONDITION							
ACTIVITY	DATE PERFORMED	START TIME :				FINISH TIME :	
		SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C	SURFACE OR METAL TEMP °C	DEW POINT °C
BLASTING / SURF. PREP.							
PRIMER APPLICATION							
SURFACE CONDITION							
ORIGINAL STATUS		METAL CONDITION		METAL RUST GRADE			
PAINT SYSTEM NO.				BLASTING DATE			
SURFACE PREPARATION							
BLASTING METHOD		PREP. STANDARD		ABRASIVE TYPE			
SURFACE PROFILE REQUIREMENT		ACTUAL SURFACE PROFILE					
DUST LEVEL		SALT TEST REQUIRED		SALT TEST READING			
PRIMER COATING							
PRIMER PAINT/SHADE		APP. METHOD		PRIMER DATE		0:00	
PAINT MANUFACTURER		DFT RANGE		HARD DRY TIME			
PAINT BATCH NO. (BASE)		MANUFACTURE DATE		SHELF LIFE			
PAINT BATCH NO. (HARDNER)							
SR. NO.	DRAWING NO.	REV. NO.	ASSEMBLY NUMBER	GRID NUMBER	GRID QTY	AVERAGE DFT PRIMER	REMARKS
NOTE:							
VISHAL QC				CLIENT / TPIA			
SIGN							
NAME							
DATE							
VE-DOC-24 REV.00							

ATTACHMENT – II



**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED
GROUP OF COMPANIES**

MIO PAINT INSPECTION REPORT

CLIENT		PROJECT		REPORT NO	
WO/PO NO		PROCEDURE NO.		DATE	

WEATHER CONDITION

ACTIVITY	DATE PERFORMED	START TIME :				FINISH TIME :			
		SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C	SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C
MIO COAT									

INTERMEDIATE / MIO COATING



MIO PAINT/SHADE				APP. METHOD				MIO DATE		0:00	
PAINT MANUFACTURER				DFT RANGE				HARD DRY TIME			
PAINT BATCH NO. (BASE)				MANUFACTURE DATE				SHELF LIFE			
PAINT BATCH NO. (HARDNER)											
SR. NO.	DRAWING NO.	REV. NO.	ASSEMBLY NUMBER	GRID NUMBER	QTY{Nos}	Average DFT				ACC / REJ	
						MIO					

NOTE:

	VISHAL QC	CLIENT / TPIA
SIGN		
NAME		
DATE		

VE-DOC-26 REV.00

ATTACHMENT – III

 		VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES								
FINAL / TOP COAT PAINT INSPECTION REPORT										
CLIENT				PROJECT				REPORT NO		
WO/PO NO				PROCEDURE NO.				DATE		
WEATHER CONDITION										
ACTIVITY	DATE PERFORMED	START TIME				FINISH TIME				
		SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C	SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C	
TOP COAT / FINAL										
FINAL / TOP COATING										
FINAL PAINT/SHADE				APP. METHOD				FINAL DATE		
PAINT MANUFACTURER				DFT RANGE				HARD DRY TIME		
PAINT BATCH NO. (BASE)				MANUFACTURE DATE				SHELF LIFE		
PAINT BATCH NO. (HARDNER)										
SR. NO.	DRAWING NO.	REV. NO.	ASSEMBLY NUMBER	GRID NUMBER	GRID QTY(Nos)	Average DFT		ACC / REI		
						FINAL / TOP COAT				
NOTE:										
	VISHAL QC				CLIENT / TPIA					
SIGN										
NAME										
DATE										
VE-DOC-28 REV.00										