

TECHNICAL SPECIFICATIONS
FOR
SSRL SPEAR 3
VACUUM CHAMBER SUPPORT
POWDER COATING OF CARBON STEEL
PS-444-326-11 *RD*

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53 POWDER COATING OF CARBON STEEL

POWDER COATING REQUIREMENTS:

1. SCOPE

- 1.1 THIS SPECIFICATION COVERS THE REQUIREMENTS FOR MATERIALS AND METAL PREPARATION: CLEANING AND POWDER COATING APPLICATION FOR METAL.

2. MATERIALS

- 2.1 PRODUCTS SPECIFIED HEREIN ARE MORTON INTERNATIONAL, UNLESS NOTED OTHERWISE, THIS ESTABLISHES THE QUALITY, UTILITY, AND APPEARANCE OF MATERIALS REQUIRED.
- 2.2 PRODUCTS OF O'BRIEN POWDER PRODUCTS INC. OR EQUAL, MAY BE USED PROVIDING A LIST OF SPECIFIC PRODUCTS IS SUBMITTED TO AND APPROVED BY SLAC PRIOR TO APPLICATION.
- 2.3 MATERIALS SHALL BE APPLIED IN ACCORDANCE WITH THE MANUFACTURER'S DIRECTIONS.

3. PREPARATION/APPLICATION

- 3.1 ALL SURFACES SHALL BE PREPARED TO RECEIVE POWDER COATING.

3.1.1 ALL RUST, SCALE, AND LOOSE PAINT SHALL BE REMOVED.

3.1.2 MECHANICAL DESCALING CAN BE ACCOMPLISHED BY POWER BRUSHING, SANDING, GRINDING, OR CHIPPING WHEN RECOMMENDED BY THE MANUFACTURER, CLEAN FERROUS SURFACES TO WHITE METAL BY SAND-BLASTING.

3.1.3 DEGREASING AND GENERAL CLEANING MAY BE ACCOMPLISHED BY IMMERSION IN, SWABBING WITH, OR SPRAYING WITH ALKALINE EMULSION, SOLVENT, OR DETERGENT CLEANERS.

3.1.4 APPLY MORTON INTERNATIONAL POWDER COATINGS CORVEL 30000 SERIES, TGIC-POLYESTER, LAVA BLACK #20-7042 (COLOR: BLACK, 15-25% GLOSS) OR EQUIVALENT POWDER TO ALL SURFACES AS PER MANUFACTURER'S APPLICATION RECOMMENDATIONS.

3.1.5 CURE SCHEDULE SHALL BE IN ACCORDANCE WITH MANUFACTURER'S RECOMMENDATIONS.

3.1.6 FILM THICKNESS SHALL BE 2-4 MILS.

4. SAMPLES

- 4.1 THE CONTRACTOR SHALL PREPARE SAMPLES (8 1/2" X 11") FOR ACCEPTANCE BY SLAC.

5. ACCEPTANCE TESTING

5.1 ADHESION OF POWDER COATED SURFACES SHALL BE TESTED RANDOMLY AS DETERMINED BY THE REQUESTOR. ADHESION SHALL BE BASED ON RESULTS OF ASTM D-3359-B STANDARD TEST METHODS FOR MEASURING ADHESION BY TAPE TEST, METHOD B, CROSS-CUT TAPE TEST. ADHESION TEST RESULTS GREATER THAN 4B (MORE THAN 5% COATING LOSS IN THE TEST AREA) SHALL BE DEEMED UNACCEPTABLE.

5.2 THE COLOR OF COATED SURFACES SHALL BE CHECKED AGAINST THE STANDARD COLOR CHIP WHICH REPRESENTS THE SPECIFIED COLOR. COLOR CHIP TO BE PROVIDED BY THE REQUESTOR. COATED SURFACE SHALL BE SMOOTH, FREE OF DEFECTS, RUNS OR SAGS.

