

PAINTING INSTRUCTIONS

A. SPECIFICATIONS:

All material and workmanship to be in accordance with the specifications issued for this contract by Mills Engineering Company
Long Lake, Minnesota 55356

B. SHOP:

1. Surface preparation: All surfaces to be Grit Blasted per SSPC #6 (Commercial Blast)
2. Painting: No Paint within 2" of field welded edges or inside tubular columns.

Inside: A Prime coat of Tnemec #272 Topox. Recommended coverage rate 240 sq. ft. per gallon for a dry mil thickness of 3 mils. Thin with TNE MEC 273 Thinner.

Outside: A prime coat of Tnemec 880. Recommended coverage rate 300 sq. ft. per gallon for a dry mil thickness of 2.2 mils. Thin with Tnemec #883 Thinner

Special Note: Do not stack plates wet.

C. FIELD:

1. Surface Preparation: Clean all unpainted and abraded areas by sand blasting per SSPC #6 (Commercial Blast)
2. Spot Painting: All unpainted and abraded areas to ^{be} spot paint ^{ED} with same coating as was used in shop.
3. Whip Blasting: In order for the field coats of inside paint to adhere to the shop primer of Topox, all inside areas should be scarified by whip blasting.

APPROVED AS CORRECTED
SUBJECT TO CONTRACT REQUIREMENTS
BY LS
DATE 2/8/71

MILLS ENGINEERING CO.
LONG LAKE, MINN.

200 N Gal. DEW T & T

For

Orono, Minnesota

PITTSBURGH-DES MOINES STEEL COMPANY
ENGINEERS - MANUFACTURERS - CONTRACTORS

P1 (Sh't 1)

Dwg. _____

Date _____

Contract 20683