

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 <sup>be</sup> spot paint <sup>ED</sup> 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.

**MILLS ENGINEERING CO.  
LONG LAKE, MINN.**

200 M Gal. DEW T & T

For

Orono, Minnesota

**PITTSBURGH-DES MOINES STEEL COMPANY**  
ENGINEERS - MANUFACTURERS - CONTRACTORS

Dwg.

Date

Pl (Sh't 1)

Contract 20683

APPROVED AS CORRECTED  
SUBJECT TO CONTRACT REQUIREMENTS

BY 2.5  
DATE 2/9/71