

MATERIAL AND EQUIPMENT STANDARD

FOR

VINYL PAINT (ALUMINUM) AS INTERMEDIATE

AND

TOP COAT (FINISH)

CONTENTS :	PAGE No.
1. SCOPE	2
2. REFERENCES	2
3. UNITS	3
4. COMPOSITION	3
5. ANALYSIS	4
6. PROPERTIES.....	4
7. STORAGE LIFE AND PACKAGING.....	5
8. INSPECTION.....	6
9. LABELING.....	6

1. SCOPE

This Standard specification which is generated from SSPC-paint 8 covers the minimum requirement for composition, analysis, properties, storage life and packaging, inspection and labeling of a ready to mix vinyl paint (aluminum) to be used as Intermediate and top coat (Finish).

2. REFERENCES

Throughout this Standard the following standards and codes are referred to. The editions of these standards and codes that are in effect at the time of publication of this Standard shall, to the extent specified herein, form a part of this Standard. The applicability of changes in standards and codes that occur after the date of this Standard shall be mutually agreed upon by the Company and the vendor.

SSPC (STEEL STRUCTURES PAINTING COUNCIL) Vol. 2

SSPC-paint No. 8 "Aluminum Vinyl Paint"
 SSPC-PA Guide 3, "A Guide to Safety in Paint Application"

ASTM (AMERICAN SOCIETY FOR TESTING AND MATERIALS)

(Specifications for Ingredients)

D362 "Industrial Grade Toluene"
 D962 "Aluminum Pigments, Powder and Paste, for Paints"
 D1153 "Methyl Isobutyl Ketone"

(Specifications for Packaging)

D3951(88) "Standard Practice for Commercial Packaging"

(Test Methods for Properties)

D185 "Coarse Particles in Pigments, Pastes and Paints"
 D562 "Consistency of Paints Using the Stormer Viscometer"
 D1208 "Common Properties of Certain Pigments"
 D1243 "Dilute Solution Viscosity of Vinyl Chloride Polymers"
 D1296 "Odors of Volatile Solvents and Diluents"
 D1475 "Density of Paint, Varnish, Lacquer and Related Products"
 D1640 "Drying, Curing, or Film Formation of Organic Coatings at Room Temperature"
 D2369 "Volatile Content of Paints"

UFS (US FEDERAL STANDARDS)

(Standard Specifications for Ingredients)

MIL-P-15328 "Primer (Wash) Pretreatment"
 MIL-P-15929 "Primer Coating, Shipboard, Vinyl-Red Lead (for Hot Spray)"

(Federal Test Method Standard No. 141)

Method 3011 "Condition in Container"
 Method 4021 "Pigment Content (Centrifuge)"
 Method 4053 "Nonvolatile Vehicle Content"
 Method 4061 "Drying Time"
 Method 4081 "Water Content (Reflex Method)"

Method 4092	"Coarse Particles and Skins"
Method 4203	"Reducibility and Dilution Stability"
Method 4331	"Spraying Properties"
Method 4541	"Working Properties and Appearance of Dried Film"

ANSI (AMERICAN NATIONAL STANDARDS INSTITUTE)

ANSI Z129.1	"Precautionary Labeling of Hazardous Industrial Chemicals"
-------------	--

IPS (IRANIAN PETROLEUM STANDARDS)

IPS-E-TP-100	"Paints"
--------------	----------

3. UNITS

International System of Units (SI) in accordance with IPS-E-GN-100 shall be used.

4. COMPOSITION

4.1 Ingredients and Proportions

Details of the composition, ingredients and proportions shall be as specified in Table 1.

The paint based on the specified ingredients shall be uniform, stable in storage, and free from grit and coarse particles. Beneficial additives such as anti-skinning agents, suspending agents, or wetting aids may be added.

The aluminum paste shall be packaged separately unless otherwise specified in the procurement documents.

4.2 Percentage

This paint shall contain approximately 14% by volume of nonvolatile film-forming solids (pigment and binder).

TABLE 1 - COMPOSITION

INGREDIENTS	TYPICAL COMPOSITION		INGREDIENT STANDARD
	Wt.%	Vol.%	ASTM
PIGMENT (10 ±1%)			
ALUMINUM PASTE	10.0	6.3	D 962 TYPE 2 CLASS B
VEHICLE (90 ±1%)			
VINYL RESIN A ¹	7.5	5.2	---
VINLY RESIN B ²	7.5	5.1	---
DIOCTYL PHTHALATE ³	1.6	1.2	---
METHYL ISOBUTYL KETONE ⁴	36.7	42.6	D 1153
TOLUENE	36.7	39.6	D 362
TOTAL	100.0	100.0	

1) Vinyl Resin A shall be a hydroxyl containing vinyl chloride acetate copolymer. It shall contain 89.5% to 91.5% vinyl chloride, 5.3% to 7.0% vinyl alcohol, and 2.0% to 5.5% vinyl acetate. The inherent viscosity of the resin (ASTM Standard D 1243, Method A) at 20°C shall not be less than 0.5.

2) Vinyl Resin B shall be a carboxyl containing vinyl chloride acetate copolymer. It shall contain 85% to 87% vinyl chloride, 12% to 14% vinyl acetate, and 0.5% to 1.0% maleic acid. The inherent viscosity of the resin (ASTM Standard D 1243, Method A) at 20°C shall not be less than 0.48.

3) Dioctyl phthalate di-2-ethylhexyl phthalate shall be commercial material which conforms to the following requirements:

Specific gravity at 25°C 0.980-0.9861

Refractive index at 25°C 1.4830-1.6859

4) When specified in the procurement documents, suitable high boiling vinyl solvent may be substituted for a portion of the methyl isobutyl ketone to make the paint more amenable to application in hot weather or by brush.

5. ANALYSIS

The paint shall conform to the composition (analysis) requirements of Table 2.

TABLE 2 - ANALYSIS

CHARACTERISTICS	REQUIREMENTS		ASTM METHOD	US FEDERAL STD. No. 141
	Min. Wt. %	Max. Wt. %		
PIGMENT	6.0	7.5	D 1208	4021*
VOLATILES	75.0	78.5	D 2369	---
NONVOLATILE VEHICLE CALCULATED BY DIFFERENCE	15.5	17.5	---	4053
UNCOMBINED WATER	---	0.5	D 1208	4081
COARSE PARTICLES AND SKINS, AS RETAINED ON SIEVE OPENING STANDARD 0.44 mm (325 MESH SCREEN)	---	0.25	D 185	4092

* Using extraction mixture "C" (1:1 toluene and acetone)

6. PROPERTIES

6.1 The paint shall meet the requirements of Table 3 and sections 6.2 through 6.6.

6.2 Odor

The odor shall be normal for the materials permitted (ASTM Standard D 1296).

6.3 Color

The vehicle before mixing with the aluminum paste shall be clear. The color after mixing shall be typical of aluminum paint (dull aluminum luster).

6.4 Compatibility

There shall be no evidence of incompatibility of any of the ingredients of the paint when two volumes of the paint are slowly mixed with one volume of thinner consisting of 85% toluene and 15% methyl isobutyl ketone by volume (US Federal standard No. 141, Method 4203).

6.5 Adhesion

The paint under test shall show good adhesion when tested as follows: Apply one coat 25 microns dry film thickness of the mixed paint to a clean steel panel free of rust or scale, also, to a similar panel pretreated with Wash Primer US MIL-P-15328, "Primer (Wash) Pretreatment", or SSPC paint 27, "Basic Zinc Chromate-Vinyl Butyral Wash Primer" 12.5 microns (0.5 mil) dry film thickness, and to a panel similar to the preceding one but over which has also been applied one coat of MIL-P-15929, "Primer Coating, Shipboard, Vinyl-Red Lead (for Hot Spray)" (25 microns dry film thickness) After a 24 hour dry, the film under test on each panel shall be subjected to a knife test to determine whether the paint exhibits good adhesion to the undercoats and to the steel.

6.6 Working Properties

The paint shall be easily applied when tested in accordance with US Federal Standard No. 141, Methods 4331 and 4541. The paint shall show no streaking, running, or sagging after drying.

TABLE 3 - PROPERTIES

CHARACTERISTICS	REQUIREMENTS		ASTM METHOD	US FEDERAL STD. No. 141
	Min.	Max.		
PAINT CONSISTENCY				
VISCOSITY* SHEAR RATE				
200 rpm				
KREB UNITS	54	60	D 562	---
GRAMS	75	97	D 562	---
DENSITY Kg/Lit	0.9	0.97	D 1475	---
DRYING TIME MINUTES:				
TACK FREE	---	15	D 1640	4061
DRY HARD	---	60	D 1640	4061

* Viscosity 48 hours or more after manufacture.

7. STORAGE LIFE AND PACKAGING

7.1 Condition in Container

The paint shall show no thickening, curdling, gelling, or hard caking when tested as specified in US Federal Standard No. 141, method 3011, after storage for 24 months from date of delivery (unless otherwise specified by the Company), in a full, tightly covered container.

7.2 Packaging

The packaging shall meet the relevant requirements of ASTM D3951 (88).

8. INSPECTION

8.1 All materials supplied under this specification shall be subject to timely inspection by the purchaser or his authorized representative. The purchaser shall have the right to reject any material(s) supplied which is (are) found to be defective under this specification. In case of dispute the arbitration or settlement procedure, established in the procurement documents shall be followed.

8.2 Samples of any or all ingredients used in the manufacture of this paint may be requested by the purchaser and shall be supplied upon request, along with the supplier’s name and identification for the materials.

8.3 Unless otherwise specified, the methods of sampling and testing should be in accordance with US Federal Test Method Standard No. 141, or applicable methods of the American Society for Testing and Materials (ASTM).

9. LABELING

9.1 Refer to ANSI Standard Z 129.1 "Precautionary Labeling of Hazardous Industrial Chemicals".

9.2 Marking of Containers

Each container shall be legibly marked with the following information:

Name: Vinyl paint (Aluminum) As Intermediate and Top coat (Finish)

Specification: IPS-M-TP-110

Mesc No. :

No of components

Maximum temperature resistance

Type of spray

Kind and size of spray nozzle tip

Cleaning material

Flash point °C.....

Pot life (hours)

Drying time for overcoating

Kind of thinner

Color: Aluminum

Lot Number:

Stock Number:

Date Of Manufacture:

Quantity of Paint in Container:

Information and Warnings, if needed,

Manufacturer’s Name and Address:

Design Guide: For guidance on the usage of this paint for various application/environments and temperature range reference shall be made to IPS-E-TP-100 "Paints"

9.3 Directions for Use

The following directions for use shall be supplied with each container of paint:

Directions for Use of Vinyl paint (Aluminum)

This paint is intended for use over vinyl butyral wash primer or as a finish coat over vinyl chloride-acetate copolymer paint. It is supplied in two components to be mixed just before using.

Gradually add small portions of the liquid to the aluminum paste. Mix the paste thoroughly until it is smooth and free of lumps. Then gradually add the remainder of the liquid, stirring constantly. It is recommended that the paint be mixed by a mechanical mixer.

The paint shall be thinned as necessary with solvent containing not more than 85% toluene and 15% methyl isobutyl ketone or methylethyl ketone. The amount of thinning will depend upon application methods and conditions, and may be as high as 25% to 33% by volume of the paint.

When required, this paint may be tinted to a contrasting color by the addition of a stable tinting pigment dispersed in a vinyl chloride-acetate copolymer resin solution.

Apply by conventional air spray. Brushing may be used in small areas. The surface to be painted shall be dry and above 2°C, not less than 3°C above the dew point. Do not paint outdoors in rainy weather. Apply so as to obtain a minimum dry film thickness of 25 microns.

A wet film of paint shall be deposited on the surface when spraying; the spray gun should be adjusted so that proper atomization is obtained but no dry powder is deposited on the surface. The nozzle should be held about 150 mm from the surface during application.

If application is to be made by brush, apply with a brush heavily loaded with paint; apply quickly and smoothly. Avoid excessive brushing and do not go back over the surface until thoroughly dry.

At temperatures between 16 and 27°C dry at least one hour between coats and 72 hours before immersion. Varying atmospheric conditions and degrees of ventilation in confined spaces may allow shorter or require longer drying times.

Note:

This paint is not to be used as a priming coat next to bare steel.

9.4 Directions for Safety

The following directions for safety shall be supplied with each container of paint:

Paints are hazardous because of their flammability and potential toxicity. Proper safety precautions shall be observed to protect against these recognized hazards. Safe handling practices are required and should include, but not be limited to, the provisions of SSPC-PA Guide 3, "A Guide to Safety in Paint Application" and to the following:

- Keep paints away from heat, sparks, and open flame during storage, mixing, and application. Provide sufficient ventilation to maintain vapor concentration at less than 25% of the lower explosive limit.
- Avoid prolonged or repeated breathing of vapors or spray mists, and prevent contact of the paint with the eyes or skin.
- Clean hands thoroughly after handling paints and before eating or smoking.
- Provide sufficient ventilation to insure that vapor concentrations do not exceed the published permissible exposure limits. When necessary, supply appropriate personal protective equipment and enforce its use.

This paint may not comply with some air pollution regulations because of its hydrocarbon solvent content.

Ingredients in this paint which may pose a hazard include hydrocarbon solvent, Applicable regulations governing safe handling practices shall apply to the use of this paint.