

**MATERIAL AND EQUIPMENT STANDARD**

**FOR**

**WHITE ALKYD PAINT FOR TOP COAT**

**(FINISH)**

<b>CONTENTS :</b>	<b>PAGE No.</b>
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 104 covers the minimum requirements for the composition, analysis, properties, storage life, packaging, inspection and labeling of white alkyd paint for 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)**

SSPC 104 "White or Tinted Alkyd Paint"

**ASTM (AMERICAN SOCIETY FOR TESTING AND MATERIALS)**

**(Specification for Ingredients)**

D212 "Pure Chrome Green"  
 D235 "Petroleum Spirits (Mineral Spirits)"  
 D476 "Titanium Dioxide Pigments"  
 D600 "Liquid Paint Driers"  
 D602 "Barium Sulfate Pigments"  
 D605 "Magnesium Silicate Pigment"

**(Specification for Packaging)**

D3951 "Standard Practice for Commercial Packaging "

**(Test Methods for Properties)**

D185 "Coarse Particles in Pigments, Pastes and Paints"  
 D523 "Specular Gloss"  
 D562 "Consistency of Paints Using the Stormer Viscometer"  
 D1208 "Common Properties of Certain Pigments"  
 D1210 "Fineness of Dispersion of Pigment Vehicle Systems"  
 D1296 "Odors of Volatile Solvents and Diluents"  
 D1475 "Density of Paint, Varnish, Lacquer and Related Products"  
 D1542 "Quantitative Test for Rosin in Varnishes"  
 D2369 "Volatile Content of Paints"  
 D2371 "Pigment Content of Solvent Type Paints"  
 D2801 "Leveling Characteristics of Paints by Draw Down Method"  
 D3278 "Flash Point of Liquids by Setaflash Closed Tester"

**UFS (US FEDERAL STANDARDS)**

**(Standard Specifications for Ingredients)**

TT-E-489 "Enamel, Alkyd, Gloss (for Exterior and Interior Surfaces)"  
 TT-R-266 "Resin, Alkyd Solutions"  
 TT-T-291 "Thinner, Paint, Mineral Spirits, Regular and Odorless"

**US Federal Test Method Standard No. 141**

Method 3011	"Condition in Container"
Method 3021	"Skinning (Partially Filled Container)"
Method 4021	"Pigment Content (Centrifuge)"
Method 4053	"Nonvolatile Vehicle Content"
Method 4061	"Drying Time"
Method 4081	"Water Content (Reflux Method)"
Method 4203	"Reducibility and Dilution Stability"
Method 4321	"Brushing Properties"
Method 4331	"Spraying Properties"
Method 4494	"Sag Test (Multinotch Blade)"
Method 4541	"Working Properties and Appearance of Dried Film"
Method 6221	"Flexibility"

**US Federal Standard No. 595 "Colors"****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**

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 no rosin or rosin derivatives may be used. Beneficial additives such as anti-skinning agents, suspending agents, or wetting aids may be added.

**4.2 Percentage**

This paint shall contain approximately 48% by volume of nonvolatile film forming solids (pigment and binder).

**TABLE 1 - COMPOSITION**

INGREDIENTS	TYPICAL COMPOSITION		INGREDIENT STANDARDS	
	Wt %	ASTM METHOD	US FEDERAL	
Pigment: (47.5 ±2.5 Wt.%)				
Titanium dioxide (Min.)	67.0	D 476	—	
Reinforcing and tinting pigments (Max.)	33.0	D 602		
		D 605		
Totals	100.0			
Vehicle: (52.5 ±2.5 Wt.%)				
Alkyd resin solids	46.8	—	TT-R-266	
Mineral spirit thinner	53.2	D 235	TT-T-291	
			GRADE 1	
Total	100.0			

**5. ANALYSIS**

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

**TABLE 2 - ANALYSIS**

CHARACTERISTICS	REQUIREMENTS		
	Wt %	ASTM METHOD	FEDERAL STD. No. 141
Pigment (Min.)	45.0	D 2371	4021
Volatiles (Max.)	30.0	D 2369	—
Nonvolatile vehicle (Min.) Calculated by difference	23.5	—	4053
Uncombined water (Max.)	1.0	D 1208	4081
Coarse particles and skins as retained on standard 0.04 mm sieve			
(325 mesh screen) (Max.)	1.0	D 185	—
Rosin or rosin derivatives	0	D 1542	—

**6. PROPERTIES**

**6.1 Requirements**

The paint shall meet the requirements of Table 3 and Clauses 6.2 through 6.8.

**6.2 Odor**

The odor shall be normal for the materials permitted (ASTM Standard D1296).

**6.3 Color**

The color shall be white to US Federal Standard 595 No. 17886.

**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 mineral spirits (US Federal Standard No. 141, Method 4203).

**6.5 Skinning**

There shall be no skinning in a three quarters filled closed container after 48 hours when tested in the standard manner specified in US Federal Standard No. 141, Method 3021.

**6.6 Working Properties**

The paint shall be easily applied by all three methods (brush, spray, roller) when tested in accordance with US Federal Standard No. 141, Methods 4321, 4331 and 4541. The paint shall show no streaking, running, or sagging after drying.

**6.7 Flexibility**

The film prepared as described in US Federal Standard No. 141, Method 6221, after baking 24 hours at 93°C shall show no cracking when suddenly chilled to 0°C and quickly bent sharply on itself through 180° degrees over a 3 mm mandrel. The film on the bent part of the panel shall show satisfactory adhesion.

**6.8 Gloss**

The gloss shall be no lower than eggshell (ASTM Standard D523)

**TABLE 3 - PROPERTIES**

CHARACTERISTICS	<u>REQUIREMENTS</u>		
		ASTM METHOD	FEDERAL STD. No. 141
Paint consistency			
Viscosity* shear rate 200 rpm			
Grams	120		
Kreb units Min.	65	D 562	—
Grams	220		
Kreb units Max.	85	D 562	—
Density Kg/l	1.34	D 1475	—
Fineness of grind, microns <sup>+</sup>	25		
Fineness of grind, hegman units	6	D 1210	—
Drying time, hours			
Dry hard (Max.)	18	—	4061
Flash point, °C (Min.)	30.0	D 3278	—
Sag resistance microns (Min.)	152	D 2801	4494
* Viscosity 48 hours or more after manufacture			
rpm = round per minute			
+ Gage depth rounded to nearest 5 µm.			

**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 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 requirement of ASTM D 3951(88).

**8. INSPECTION**

**8.1** All materials supplied under this Standard 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 Standard 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 material.

**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** Labeling shall be in accordance with ANSI Standard Z129.1 "Precautionary Labeling of Hazardous Industrial Chemicals".

**9.2 Marking of Containers**

Each container shall be legibly marked with the following information:

- Name: White Alkyd Paint for Top Coat**
- Specification: IPS-M-TP-125** .....
- 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: White to US Federal Standard 595 No. 17886**
- 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**

### 9.3 Directions for Use

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

#### **Directions for Use of White Alkyd Paint:**

This paint is intended for use as top (finish) coat over rust inhibitive primers on structural steel, over itself, or over other oleoresinous paints. All Oil, grease, dust, and loose or nonadherent paint shall be removed, as residues of oil and grease remaining on the surface will result in decreased paint performance. If the undercoat is damaged, the steel shall be spot cleaned and spot primed with rust inhibitive primer.

Mix paint thoroughly before use. If the pigment has settled, pour off most of the liquid into a clean container. Thoroughly mix the pigment with the remaining liquid, taking care to scrape all the pigment off the bottom of the can. Gradually add the poured off liquid and mix thoroughly. Mixing may be made easier by transferring contents to larger container or by pouring the paint to and from another container. Examine bottom of container for unmixed pigment. Screen Paint before applying.

Thin paint only if necessary, using only mineral spirits. For brush application under normal conditions, no thinning should be necessary. For spray applications, add up to one liter of thinner per eight liters of paint when necessary.

Apply by brush or spray to the specified film thickness or, if none is specified, to at least 38 microns dry or approximately 75 microns wet. The surface to be painted shall be dry; the surface temperature shall be at least 3°C above the dew point and the temperature of the air shall be over 4°C. Do not paint outdoors in rainy weather or if freezing temperatures are expected before the paint dries.

Allow paint at least 18 hours drying time in good weather before recoating.

### 9.4 Direction 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, and lead-drier. Applicable regulations governing safe handling practices shall apply to the use of this paint.



