

Paint Specification – Refrigerated Dryers

Industrial Technologies
West Chester, PA 19380

Date: 1/14/11
Cancels: 3/17/08

1.0 Surface Preparation:

1.1 SSPC-SP8: All sheet metal components shall be submersed in a hot (130°F) bath of iron phosphate pre-coat solution (6 – 10 minutes) to degrease and improve paint adhesion.

1.2 Once degreased and pre-coated, all components shall be thoroughly rinsed with clean water at 120°F to 130°F.

2.0 Surface Coating:

All sheet metal components are to be completely coated with a Hybrid Powder coating to the following Dry Film Thickness':

- Dry Film Thickness (DFT): 2.0 - 3.0 MILS (typical)
- Hardness (pencil) 2H minimum
- Impact (IN-LB) 100 to 160 forward and reverse
- Gloss (60°) 80+
- Crosshatch 5B Minimum
- Salt Spray 1000 HRS
- Humidity 1000 HRS

Once coated with powder, all panels are to be cured in a gas fired infrared oven for a minimum 3.5 minutes/maximum 8 minutes at 400°F.