

Paint Specification – Desiccant Dryers Models HLA, HL, EH, HB & D-EH

Industrial Technologies
West Chester, PA 19380

Date: **01-Sep-17**
Cancels: **All Previous**

1.0 Surface Preparation

Sheet Metal Components (SSPC-SP8):

- 1.1 All sheet metal components shall be submersed in a hot (120 deg 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 sheet metal components should be thoroughly rinsed with clean water.
- 1.3 All sheet metal components will be allowed to thoroughly dry prior to paint application. This shall be accomplished via manual drying with a clean dry cloth, or sending sheet metal components through the gas fired infrared oven to be force dried.

Other Components:

- 1.4 All holes in electrical enclosures are to be taped on the inside with masking tape.
- 1.5 Plug all threaded ports on piping, Aquamatic valves, tank vessels, filter heads, etc. using black iron plugs.
- 1.6 Tape all valve stems and actuators neatly with masking tape.
- 1.7 Cover all sealing surfaces, gasket or O-ring, with masking tape
- 1.8 Remove all excess pipe thread sealant thoroughly.
- 1.9 All structural steel and piping, shall be mechanically de-scaled, de-burred, and degreased to remove all dirt, dust, and cutting/machining fluids.
- 1.10 Dryer vessels, structural steel and piping, shall be thoroughly solvent wiped to remove surface contamination and improve paint adhesion.

2.0 Surface Coating: HEATLESS DESICCANT DRYERS (HLA & HL Series)

- 2.1 All dryer surfaces are to be completely coated with a corrosion-inhibiting alkyd enamel primer, followed by one coat of water-reducible modified alkyd acrylic topcoat. The following wet and dry film thickness' are to be observed:

	<u>Primer Coat</u> <u>Wet Film</u>	<u>Top Coat</u> <u>Wet Film</u>	<u>Total Primer & Topcoat</u> <u>Dry Film</u>
Primer	2.0 - 3.0 Mils	-----	-----
Beige	-----	3.0 - 4.0 Mils	2.5 - 3.5 Mils

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- 2.2 All parts are to dry for a minimum of 1 hour between primer coating and the application of the topcoat. All relevant information is to be recorded on the paint log.
- 2.3 Under normal conditions (temperature and humidity), topcoat should be allowed to dry a minimum of 1 hour before handling.
- 2.4 Completed dryers should be allowed to dry for a minimum of 4 hours prior to shipment.

3.0 Surface Coating: HEAT REACTIVATED DESICCANT DRYERS (EH, HB Series)

- 3.1 All dryer surfaces are to be completely coated with a corrosion-inhibiting hi-temp silicone alkyd primer, followed by 1 – 2 coats of hi-temp silicone alkyd topcoat. The following wet and dry film thickness' are to be observed:

	<u>Primer Coat</u>	<u>Top Coat</u>	<u>Total Primer & Topcoat</u>
	<u>Wet Film</u>	<u>Wet Film</u>	<u>Dry Film</u>
Primer Beige	2.0 - 3.0 Mils	----- 2.0 – 3.0Mils	----- 2.0 – 3.0Mils

- 3.2 All parts are to dry for a minimum of 1/2 hour between primer coating and the application of the topcoat.
- 3.3 Under normal conditions (temperature and humidity), parts should be allowed to dry for at least 1 hour before handling.
- 3.4 After rundown testing has been completed, the dryer shall be allowed to cool down for a minimum of 24 hours prior to packaging.

4.0 Surface Coating: HEAT-OF-COMPRESSION DRYERS (D-EH Series)

- 4.1 All dryer surfaces are to be completely coated with a corrosion-inhibiting hi-temp silicone alkyd primer, followed by 1 – 2 coats of hi-temp silicone alkyd topcoat. The following wet and dry film thickness' are to be observed:

	<u>Primer Coat</u>	<u>Top Coat</u>	<u>Total Primer & Topcoat</u>
	<u>Wet Film</u>	<u>Wet Film</u>	<u>Dry Film</u>
Primer Beige	2.0 - 3.0 Mils	----- 2.0 – 3.0Mils	----- 2.0 – 3.0Mils

- 4.2 All parts are to dry for a minimum of 1/2 hour between primer coating and the application of the topcoat.
- 4.3 Under normal conditions (temperature and humidity), parts should be allowed to dry for at least 1 hour before handling.
- 4.4 After rundown testing has been completed, the dryer shall be allowed to cool down for a minimum of 24 hours prior to packaging.