

250 - Coating Specification for Offshore Applications

1. SCOPE AND PURPOSE

The purpose of OPS 250 is to define the surface preparation, application equipment, application procedure, materials and physical characteristics for a 3 part coating process suitable for offshore applications. This processing specification complies with the requirements of API Spec Q1 (latest edition) and ISO 9001:2008. Through the use of written processing specifications, Omni Valve demonstrates its commitment to quality.

2. RESPONSIBILITY AND AUTHORITY (R&A)

The Engineering Department and designees at Omni are committed to developing, implementing, and maintaining processing specifications that meets or exceeds industry standards

3. RELATED AND SUPPORT DOCUMENTATION

This specification incorporates the latest editions of the following specifications as a reference or constitutes part of this specification.

- Amercoat 68HS Zinc Rich Epoxy Primer Data Sheet by PPG Amercoat
- Amercoat 385 Multi-Purpose Epoxy Data Sheet by PPG Amercoat
- Amercoat 450H Gloss Aliphatic Polyurethane Data Sheet by PPG Amercoat
- ASTM – American Society for Testing and Materials
- SSPC – Society for Protective Coatings

4. PROCEDURE

4.1. Metal Cleaning

4.1.1. All parts to be cleaned by SSPC-SP-5, Surface Preparation Specification No. 1

4.1.2. Areas to be coated may be blasted to SSPC-SP 5, white metal cleaning. Anchor pattern should not exceed 0.001 inch. Recommend 0.0003-0.0007. Use aluminum oxide 100 grit or less. Recommend 180 grit.

4.2. Application

4.2.1. Surfaces to be coated must be clean, and 5°F above dew point. Parts should be coated within 4 hours after blasting.

4.2.2. Coat assemblies per the following.

4.2.3. Amercoat 68HS Zinc Rich Epoxy Primer

- 3 mil dry film thickness not to exceed 5 mils per coat.
- Follow manufacturer's guidelines for mixing and application.

4.2.4. Amercoat 385 Multi-Purpose Epoxy (Intermediate Coat)

- 4-8 mil dry film thickness not to exceed 8 mils per coat.
- Follow manufacturer's guidelines for mixing and application.

4.2.5. Amercoat 450H Gloss Aliphatic Polyurethane Topcoat

- 2-5 mil dry film thickness

- Follow manufacturer's guidelines for mixing and application.
- RAL 9003 White

4.3. Repairs

4.3.1. Prepare damaged areas to original surface preparation specifications, feathering edges of intact coating. Thoroughly remove all contaminants before touchup.

4.4. Inspection and Testing

4.4.1. Visually inspect all parts for defects in coating (bubbles, voids, runs, drips, bare and thin coating). If dust and fine matter are present on the surface of coating, the coating may be sanded lightly with 1000 grit or finer emery paper. Visually inspect after repairs.

4.4.2. Check coating thickness on every assembly.

5. RECORDS

5.1. A Letter of Conformance identifying the purchase order, quantity, part number, date processed, to OPS 250 coating specification

5.2. Test Records shall be recorded in a daily log book.

5.3. Records of test logs and copy of letters of conformance shall be kept by vendor for two years. Records shall be released to customer on demand within 24 hours.

6. SHIPPING AND HANDLING

6.1. Handling and Processing of parts must be in a safe and protective way as not to damage any area of the parts.

6.2. All parts must be shipped back to customer with a protective material so parts will not be damaged in shipping.

6.3. Any parts damaged or received damaged must be reported to customer immediately.

7. REVISION HISTORY

Rev Level	Date	Prepared By	Approved By	Description of Change / Reason
0	08/25/2011	Amanda Tubbs	Johnny Gates	Initial Release

