



Toase-ehe Park Sanati Gohar Ofogh
 Petrochemical Co.
**CONCEPTUAL, BASIC and DETAIL DESIGN
 ENGINEERING OF STYRENE PARK OFFSITE**



Document Title:
 Painting procedure for Ru0001A / B-D-02

Document No.: EI027-ASP-VD-ME-PRO-014

Rev. R0

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STYRENE PARK OFFSITE

Painting procedure for Ru0001A / B-D-02

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ARKAN SANAT PAYDAR
Procurement & Construction

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REVISION RECORD SHEET

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1. Purpose

This work-instruction is applicable whenever epoxy primer and final standard coating is required on bare compressor and compressor packages. It regards carbon steel and cast iron frame, piping and equipment surfaces only.

2. Instructions and criteria's

3.1 Surface preparation:





- 3.1.1 All equipment which needs to be painted will be cleaned as follows:
- 3.1.2 Thoroughly degreasing of all surfaces by use of Benzine D and air pressurized pistol.
- 3.1.3 Removing all discontinuities (e.g. weld spatters) by chipping and by grit blasting.
- 3.1.4 Grit blasting according SA 2 ½ where applicable.
- 3.1.5 Drying all surfaces by blowing air with an air pressurized pistol.
- 3.1.6 All surfaces will be clean and free from any contamination before the painting action will be proceeded.
- 3.1.7 Protect all openings, flange facings, identification plates, stem threads etc... by use of proper protection material.

3.2 Painting:

- 3.2.1 Check thoroughly for cleanliness of all surfaces and protection of all area's which need not to be painted, before proceeding.
- 3.2.2 Painting shall be done after hydro-test.
- 3.2.3 The paint will be applied by means of a manual spray pistol with an opening between 1.2 - 1.5 mm.
- 3.2.4 The spray pressure will be between 3 - 5 barA.
- 3.2.5 The paint action will be performed with a smooth horizontal or vertical movement of the spray pistol.
- 3.2.6 The distance between spray pistol and equipment will be ± 40 cm.
- 3.2.7 Painting shall be done indoors. The air temperature will be 5 – 40deg.C.
- 3.2.8 The relative humidity will be 50 – 80%.
- 3.2.9 All steel temperatures will be at least 3deg.C above dew point of the surrounding air.

Items not to be painted:

1. Stainless steel surfaces
2. Aluminium surfaces (except caps)
3. Name- and tag plates
4. Levers
5. Galvanized surfaces
6. Visual wiring

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7. Coupling covers
8. Insulation
9. Stem threads
10. Flange facings
11. SS Valve body, stem, handle, Actuators

Items painted to Manufacturer Standard:

1. Electric Motors
2. Instruments
3. Heaters
4. PLC panel
5. Compressor and oil pump

Following coats will be applied on all other surfaces:

PAINTING SYSTEM APPLICABLE SHALL BE IN ACCORDANCE WITH BELOW TABLE:								
TAG NO.	EXTERNAL OR INTERNAL SURFACE	BASE MATERIAL	OPERATING TEMPERATURE (°C)	SURFACE PERPARATION	LAYER	DISCRPTION	MIN. DRY FILM THK. (μ)	RAL
Ru0001A & B-D-02	EXTERNAL SURFACE	C.S	UP TO 120	Sa 2 1/2	Primer	2 component zink fosfate HB	75	-
					Intermedite	2 component epoxy primer	75	-
					FINAL	2 component acrylic polyurethane	75	7038
TOTAL DRY FILM THK. (μ)							225 (μ)	

3. Registration

After cleaning following requirements shall be met:

- All surfaces will be visually clean and free from any contamination.






Before painting:

- Ambient conditions (impression).
- Steel condition (impression).

After painting following requirements shall be met:

- Uniform consistency of paint
- No paint gutters allowed
- No blank material visible
- No foreign materials in paint

After painting a visual inspection according the above requirements and a thickness measurement will be performed.

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All results will be recorded on an inspection report and filed within the relevant job order file.

All above mentioned coats (DFT) will be measured by the use of the coating thickness gauge ELCOMETER 345 or other appropriate equipment. Perform a measurement at 20 different spots of the equipment.

All readings must be within the tolerances.

Inspection report: thickness of all layers must be within the tolerances. Registration in report MF/10/Q009.