

Blue (Standard)	4D566 Blue Semi-Gloss Water Reducible Enamel. One coat 1.5 – 2.0 mils thick. Suitable base coat for most over coats. Surface preparation to SSPC-SP10 or phosphate hot water wash.
Asphaltum Varnish	Federal Spec. TT-C-494C solvent based bituminous coating with excellent moisture resistance and suitable for water immersion. Coating thickness 2 mils per coat. Surface preparation to SSPC-SP10 or phosphate hot water wash.
Tnemec Series 39-1261	A high-heat silicone aluminum for protection against weather, moisture, heat and industrial fumes to high temperature applications. Coating thickness 1-2 mils. Surface preparation to SSPC-SP10.
Tnemec Series 141 Pota-Pox 80	Two-part epoxy, conforms to NSF 61, AWWA C-550, AWWA D102 Inside System No. 1 & 2 and AWWA C210. Self-priming system with each coat consisting of 4-8 mils dry film thickness. Surface preparation to SSPC-SP10 or phosphate hot water wash.
Tnemec Series 46H-413	Two-part epoxy, conforms to AWWA C210. Self-priming system. 16 mils dry film thickness recommended or 8 mils for two-coat option. Minimum surface preparation to SSPC-SP10

SURFACE PREPARATION

Specifications of the Steel Structures Painting Council

Solvent Cleaning (SSPC-SP1): Removal of oil, grease, soil and other contaminants by use of solvents, emulsions, cleaning compound, steam cleaning or similar materials and methods which involve a solvent or cleaning action.

Hand Tool Cleaning (SSPC-SP2): Removal of loose rust, loose mill scale and other detrimental foreign matter to degree specified by hand chipping, scraping, sanding and wire brushing.

Power Tool Cleaning (SSPC-SP3): Removal of loose rust, loose mill scale and other detrimental foreign matter to degree specified by wirebrushing, power impact tools or power sanders.

* White Metal Blast Cleaning (SSPC-SP5): Blast cleaning to a gray white uniform metallic color until each element of surface area is free of all visible residues. Suitable surface preparation for Holiday testing.

Commercial Blast Cleaning (SSPC-SP6): Blast cleaning until at least two-thirds of each element of surface area is free of all visible residues.

Brush Blast Cleaning (SSPC-SP7): Blast cleaning to remove loose rust, loose mill scale and other detrimental foreign matter to degree specified.

Near White Blast Cleaning (SSPC-SP10): Blast cleaning to nearly white metal cleanliness until at least 95 percent of each element of surface is free of all visible residues.

* Phosphate Hot Water Wash: Hot water wash in a power washer using the appropriate concentration of chemical, hot water rinse and hot air dry prior to coating. Suitable surface preparation for Holiday testing.

*** NOTE: UNLESS OTHERWISE SPECIFIED, SARTELL VALVES & CONTROLS USES SURFACE PREPARATION AS REQUIRED BY THE PAINT MANUFACTURER.**

FUNCTIONAL SPECIFICATIONS

NSF 61 Requirement	Since April of 1993, many states began phasing in NSF 61 standards for valves in contact with potable water. Tnemec Series 141 Pota-Pox 80 coating presently furnished as standard on Sartell Valves & Controls AWWA butterfly valves meet the requirements of Standard NSF 61.
VOC Limits	EPA regulations requires a limit on the volatile organic compounds (VOC) to 3.5 pounds per gallon. Some States may require lower levels. i.e. California requires 2.8 pounds per gallon.
Paint Compatibility	Some over coats are not compatible with the standard Sartell Valves & Controls base coats. When in doubt, contact factory.
Finish Coat Requirements	Some projects require the valves to be painted after installation. These valves do not need finish coats from the factory. Be sure that the product is not over specified at order entry.
Color Requirements	Projects require special colors. Be sure to include color requirement on the order.
Maximum Coating Thickness	Coating thickness varies with the various paint manufacturers. Coating thickness may be increased by the application of a second or third coat. Typically a 15 mil coating is considered a practical maximum. Some coatings actually lose performance parameters as the thickness is increased beyond the manufacturer's recommendation.
Holiday Testing	Holiday testing is a process using a dielectric device to detect voids in an epoxy coating. NOTE: THIS IS PERFORMED AT AN ADDITIONAL CHARGE TO THE COATING PRICE.

OTHER PAINTING SYSTEMS

Fusion Coatings	Fusion bonded Epoxy is a one-part heat curable semi-rigid thermosetting powdered coating. It is available on a special basis.
Two Part Epoxies	A two part system consists of a base material and a catalyzing or hardening agent to cure the coating. Coating cure may take place in air or accelerated by oven heating.
Three Part Zinc Primer	An inorganic coating consisting of three elements: base, filler powder and catalyst. This system is very difficult to work with, requires long cure times, and is very sensitive to surface prep and recoating.

APPLICATION

Sartell Valves & Controls Blue	Stainless steel, bronze, aluminum or nickel alloy valves are not painted. Stainless steel or plated components will not be painted. Purchased accessories will not be painted. Purchased pneumatic, hydraulic and electric actuators will only have the manufacturer's coating. All Sartell Valves & Controls actuators will be painted. Tubing and fittings will not be painted. Pinned extension pipes will not be painted that have galvanized, black oxide or varnish coatings.
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