

MARC CLIMATIC CONTROLS CORROSION PROTECTION SPECIFICATION

1.1 General

Coatings shall be applied in accordance with Marc Climatic Controls, Inc. Coating Procedures For Air Cooling Equipment no. 1290-HU-U, Rev. 4. The color shall be gray. The paint manufacturer's recommended drying times between coats shall be used as a minimum

1.2 Cabinet and component surfaces

The unit shall be completely disassembled prior to coating. Surfaces shall be cleaned, primed, and coated in accordance with the procedures above. Coatings shall include all uninsulated cabinet surfaces, the evaporator and condenser coils, motors, blower wheels and scrolls, fan blades, brackets, etc. The unit shall be reassembled and given a final coating. All fasteners shall be stainless steel.

1.3 Coils

Coils shall be washed with a mild acid solution, rinsed with water, and allowed to dry prior to coating. Coils shall be flow-coated to ensure full coverage. Coating shall include compressor(s) and all refrigerant tubing.

MARC CLIMATIC CONTROLS, INC.
COATING PROCEDURES FOR AIR COOLING EQUIPMENT
NO. 1290-IIU-U, REV. 5

I. SURFACE PREPARATION

- A. CARBON STEEL STRUCTURAL SURFACES SHALL BE SAND BLASTED OR POWER TOOL CLEANED TO REMOVE DIRT, RUST, AND SCALE. SURFACES SHALL THEN BE CLEANED WITH THINNER IN A MANNER TO RINSE AWAY ANY REMAINING OIL OR DUST.
- B. ALL PAINTED SURFACES TO RECEIVE PROTECTIVE COATINGS SHALL BE LIGHTLY SANDED TO "ROUGH-UP" THE SURFACE AND THEN THOROUGHLY CLEANED WITH MINERAL SPIRITS.
- C. GALVANIZED SURFACES SHALL BE WASHED WITH A MILD ACID SOLUTION, RINSED WITH WATER, AND ALLOWED TO DRY.
- D. COILS SHALL BE WASHED WITH A MILD ACID SOLUTION, RINSED WITH WATER, AND ALLOWED TO DRY.

II. COIL SURFACES

A. **PRIME COAT**

- 1. FINNED SURFACES SHALL BE FLOW-COATED WITH VINYL WASH PRIMER # WP9520A TO ENSURE FULL COVERAGE. TOTAL DRY FILM THICKNESS SHALL BE 0.5 MILS (PROX.).
- 2. THE WASH PRIMER SHALL BE ALLOWED TO DRY THOROUGHLY BEFORE TOP COATING.

B. **TOP COAT**

- 1. SURFACES SHALL BE TOP COATED WITH GRAY URETHANE # SU11467.
- 2. FINNED SURFACES SHALL BE FLOW-COATED WITH URETHANE TO ENSURE FULL COVERAGE.
- 3. BEFORE DRY, THE COIL SHALL BE SPRAYED WITH URETHANE FROM BOTH SIDES, SO AS TO BUILD UP A FINE BEAD ON FIN EDGES TO PREVENT SPLITTING.
- 4. THE COATING SHALL BE APPLIED IN SUCH A MANNER THAT ALL SURFACES WILL RECEIVE A CONTINUOUS DRY FILM THICKNESS OF 1.0 MIL (PROX.). TOTAL DRY FILM THICKNESS SHALL BE APPROXIMATELY 1.5 MILS.

III. FLAT SURFACES

A. **PRIME COAT**

1. **CLEANED CARBON STEEL STRUCTURAL SURFACES**

SURFACES SHALL BE COATED WITH PRIMER # SU11468 WHITE. THE AVERAGE DRY MIL THICKNESS SHALL BE APPROXIMATELY 2 TO 4 MILS. PRIMED SURFACES SHALL BE ALLOWED TO DRY THOROUGHLY BEFORE TOP-COATING.

2. **PAINTED SURFACES**

PAINTED SURFACES HAVING BEEN PREPARED IN ACCORDANCE WITH I.A. ABOVE WILL BE READY FOR THE TOP COAT.

3. **GALVANIZED SURFACES**

FLAT EXPOSED SURFACES (HOUSINGS) SHALL RECEIVE ONE COAT OF VINYL WASH PRIMER APPLIED TO A THICKNESS OF 0.2 TO 0.4 MILS DRY FILM. IT SHOULD BE NOTED THAT A PROPERLY PRIMED SURFACE WILL PRESENT A MOTTLED TRANSLUCENT APPEARANCE.

B. **TOP COAT**

- 1. PRIMED FLAT SURFACES SHALL BE TOP COATED WITH GRAY URETHANE # SU11467.
- 2. THE TOP COAT SHALL BE APPLIED IN SUCH A MANNER AS TO ASSURE THE ABSENCE OF VOIDS OR HOLIDAYS IN THE COATING FILM.
- 3. DRY FILM THICKNESS
 - a) TOTAL DRY FILM THICKNESS FOR CABINET AND GALVANIZED SURFACES SHALL BE 1.5 TO 2.0 MILS MINIMUM AND WILL EQUAL THE SUM OF THE VINYL WASH PRIMER (OR ORIGINAL PAINT) PLUS THE URETHANE FINISH.
 - b) TOTAL DRY FILM THICKNESS OF PRIMED STRUCTURAL SURFACES SHALL BE 5 TO 6 MILS MINIMUM AND WILL EQUAL THE SUM OF THE PRIMER PLUS THE URETHANE FINISH.
- 4. DRYING TIMES BETWEEN SUCCESSIVE COATS OF THE TOP COAT SHALL BE AT LEAST TWO HOURS.

END OF PROCEDURES