

PPI IDLER - SURFACE PROTECTION SYSTEMS

PAINT

Most non-machined surfaces shall be painted unless otherwise protected by such means as rubber, plastic, plating, etc. Vendor supplied components are not re-coated unless used in fabrications, i.e. welded, bolted, etc. Gray color supplied as standard unless otherwise specified in writing prior to ordering and on Purchase Order. PPI standard color is RAL 7024 Graphite Gray.

Option 1: Standard Alkyd Enamel Paint (Supplied unless otherwise specified)

Pretreatment: surfaces reasonably free of grease, dirt, loose scale, and slag.
High solids alkyd enamel, approximate dry film thickness 1 mil.

Option 2: Alkyd Enamel, Two Coats

Pretreatment: surfaces reasonably free of grease, dirt, loose scale, and slag.
Primer: High solids alkyd enamel, approximate dry film thickness 1 mil.
Top Layer: High solids alkyd enamel, approximate dry film thickness 1 mil.
Final approximate dry film thickness 2 mil.

Option 3: Urethane Primer, Alkyd Enamel Top Layer

Provides moderate surface protection.
Pretreatment: phosphate wash
Primer: 2 part urethane primer, approximate dry film thickness of 1-1.5 mil. Minimum thickness 1 mil.
Top Layer: Alkyd enamel, approximate dry film thickness 0.7 mil.
Final approximate dry film thickness 1.7 mil.

Option 4: High Performance 2 Component Urethane.

Provides excellent gloss, weathering resistance and film flexibility
Pretreatment: commercial blast clean and phosphate wash, wash only for idler rolls
Primer: 2 part urethane primer, approximate dry film thickness of 1-1.5 mil. Minimum thickness 1 mil.
Top Layer: high performance, high solids, 2 component urethane
approximate dry film thickness up to 1 mil. Minimum thickness 0.7 mil.
Final approximate dry film thickness of 1.7 - 2.5 mils.

Option 5: Urethane Primer, Epoxy Mastic Top Layer

Provides exceptional corrosion protection
Pretreatment: commercial blast clean and phosphate wash
Primer: 2 part urethane primer, approximate dry film thickness of 1.5-2 mil.
Top Layer: 2 part polyamide epoxy mastic, approximate dry film thickness 2 mil.
Final approximate dry film thickness of 3.5-4 mil.
Note: Epoxy paint can discolor and chalk with extended exposure to sunlight.

Option 6: Other clearly specified by customer.

Frame options:

Option 7: Hot Dip Galvanize: Frames, brackets, etc. can be hot dip galvanized. Rolls are excluded.

Galvanizing forms a metallurgical bond between the zinc and the underlying steel, creating a barrier that is part of the metal itself. During galvanizing, the liquid zinc reacts with the surface of the steel article to form a series of zinc-iron alloy layers.

Rev:	Revised Date:
8	10/08/18
ECO18-556	By: TVZ

Drawn Date:
02/17/03
By: EJA

Dwg: ISM-120