

Haygor Instrument & Company, Inc.

Serving The Petrochemical Industry For Over 25 Years

PAINTING PROCEDURE

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| Prepared By: Allen Bishop | Document #: HIE PAINT 01.A |
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1. Scope

The purpose of this document is to outline and describe the general requirements and procedures used at Haygor Instrument & Company, Inc. for preparation and painting of industrial equipment and components.

2. Qualified Personnel

Technicians are trained on site at our facility and undergo supervision during this procedure. Training includes the proper handling of equipment, safety regulations, and use of personal protective equipment.

3. Work Area

This procedure is performed in a designated work area free of debris and clutter to reduce the risk of slips, trips, or falls. Spray paint is extremely flammable and is contained in a designated area in a controlled environment maintained between temperatures of 65 and 85 Degrees F. Spray paint should not be stored near sources of heat, flames, or sparks. The designated paint area and environment is well ventilated ensuring fumes are not exposed to the operator. All paint manufacturer product instructions and guidelines are referred to and followed. Lights, electrical appliances, and other equipment are kept away from the paint area. Empty cans are disposed of following hazardous waste guidelines.

4. Material Receiving

A Shop Order is created at the time of receipt and will accompany the material. The Shop Order includes work instructions for the painting personnel.

5. Acceptable Paints

The following paints are acceptable unless customer requirements define different:

Krylon ® Industrial Enamel Spray Paint
Rust-Oleum ® Industrial Enamel Spray Paint
Sherwin Williams ® Enamel Industrial Paints
PPG ® Industrial Coatings Enamel Paint
Custom Aerosol Products, Inc. ® Acrylic Lacquer (For custom colors)

Note: Customer defined paints will be used upon customer request.

6. Surface Preparation

Inspect surface to be painted for any oils, loose paint, rust, or dirt. Remove any oils using Ensolve degreaser or soap and water. Remove loose paint, rust, or dirt by sandblasting, sanding, or wire brushing. Smooth surfaces are sanded. Surfaces not to be painted are covered with bag material, plastic caps, and tape to prevent any overspray.

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7. Spray Painting Procedure

- 7.1. All surfaces to be painted are inspected for cleanliness. Surfaces should be free of oil, loose paint, rust, and dirt. All areas not to be painted are verified for proper covering and protected from overspray. Prepared surfaces are not handled with bare hands. Oils, dirt, and grease prevent paint from adhering to the surface.
- 7.2. Spray cans should be shaken for minimum of 1 minute after mixing ball is heard.
- 7.3. Hold can 10-14" away from surface. Several light coats are applied within a few minutes apart to avoid drips and runs. Spray applications are applied in a horizontal movement. Surfaces are recoated within 1 hour and let final coat dry for 24 hours.
- 7.4. Gray primer is to be spray applied on bare surfaces prior to the final color.

8. Inspection

Remove any protected surfaces and inspect all surfaces for proper paint coverage and reveal no overspray.

9. Final Packaging and QC Inspection

Final Quality Control inspection is performed by the Quality Control personnel who will inspect and verify all surfaces, labeling, paperwork, and packaging of the completed job before shipping. Equipment is to be packaged in a foam filled box to protect painted surfaces from being damaged in storage and shipment.

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