

1. APPLICATION

This painting procedure applied for painting work for all equipments and parts which are manufactured by **TORISHIMA PUMP MFG. CO., LTD.**

2. EXCEPTION

The following surface shall not be painted.

- (1) Applied surface of rust preventive agent
- (2) Stainless steel parts
- (3) non-ferrous metal parts
- (4) Plated surface
- (5) Glass
- (6) Plastic

3. Caution of painting work

3-1. Before surface preparation

All rust, oil, dirt and any element which might affect the correct adherence of the painting shall be cleaned by solvent.

3-2. After surface preparation

After surface preparation, iron powder and dust shall be cleaned according to following steps.

Step-1

Painted parts and floor shall be cleaned with a broom and/or dustpan.

Step-2

Painted parts and floor shall be cleaned with a duster brush.

Step-3

After cleaned with compressed air, dust shall be cleaned with a vacuum cleaner.

3-3. Inspection and confirmation of the paint

Following items shall be checked.

- (1) Presence of the container damage
- (2) Quantity of the container
- (3) Checking of the description on the container
 - a. Trademark
 - b. Brand name
 - c. Capacity or mass
 - d. Indication of dangerous article type
 - e. Product number
 - f. Indication according to Industrial Safety and Health Law
 - g. Name of the company
 - h. Indication according to Poisonous and Deleterious Substances Control Law
- (4) Inspection of color

Open the container, and paint stir precipitated pigments with a stir stick that reaches the bottom of the container, and even up the entire paint.

Paint should be applied on a small area of the glass or tinned plate, and compared to the color chart.

- (5) Confirmation of the prescribed thinner

It is confirmed whether the prescribed thinner is prepared.

3-4. Paint handling

Pigments that have precipitated are untied, it often stirs with the paint mixing machine, and the entire paints are evened up.

The pigment should be stirred until the precipitation does not attach previously.

The prescribed thinner is used without fail before the dilution.

3-5. Painting environment

Painting work shall be avoided following condition.

- (1) Temperature be below 5 °C or relative humidity exceeds 85 %.
- (2) rainy or snowy day (Indoor work may be excepted).
- (3) Painted surface is wet with dew or frost.
- (4) Gale or many dust exists.

4. Painting specification

Painted surface		Painting specification No.	Part to be painted	Final color
External surface	Ambient temperature parts	S1	UPPER PARTS FROM THE SOLE PLATE	RAL5002
	Wetted surface	S2	LOWER PARTS FROM THE SOLE PLATE	-
Coupling guard		S1		RAL5002

5. Painting process

5-1. Painting specification No. : S1

Surface Preparation : Sa 2.1/2

Coating Step	Paint		DFT (μm)	Color
	General name	Product name		
First	Zinc rich epoxy	INTER ZINC 52	75	
Second	Epoxy combination paint	INTERGARD 251	50	
Third	Epoxy combination paint	INTERGARD 251	50	
Forth	Epoxy combination paint	INTERGARD 740	50	Ultramarine Blue RAL 5002
Total			225	

Note

- 1) "DFT" shows minimum Dry Film Thickness.
- 2) The paint manufacturer

Coating step	Paint Manufacturer
First	INTERNATIONAL
Second	INTERNATIONAL
Third	INTERNATIONAL
Forth	INTERNATIONAL

5-2. Painting specification No. : S2

Surface Preparation : Sa 2.1/2

Coating Step	Paint		DFT (μm)	Color
	General name	Product name		
First	Epoxy combination paint	INTERSEAL 670HS	125	
Second	Epoxy combination paint	INTERSEAL 670HS	125	
Third	Epoxy combination paint	INTERSEAL 670HS	125	
Total			375	

Note

- 1) "DFT" shows minimum Dry Film Thickness.
- 2) The paint manufacturer

Coating step	Paint Manufacturer
First	INTERNATIONAL
Second	INTERNATIONAL
Third	INTERNATIONAL