909-M-063 PAINTS FOR METAL SURFACES

(Adopted 10-21-21)

The Standard Specifications are revised as follows:

SECTION 909, BEGIN LINE 143, INSERT AS FOLLOWS:

(c) Polyurethane Finish Coat

Polyurethane finish coat shall be a two-component polyester or acrylic aliphatic polyurethane suitable for use as a finish coat over epoxy intermediate paint.

The mixed paint shall be in accordance with the following requirements.

Volatile organic compounds, ASTM D3960, max. .....336 g/L
Volume solids, ASTM D2697, min. 60%
Set-to-touch, ASTM D1640, 5 mils wet film thickness, min. .....30 minutes
Total solids ASTM D2369, min. 70%
Specular gloss, 60°*, 10 ±0.5 mils wet film thickness*
on a tin coated steel panel, dried 48 h, ASTM D523, min. 75
Viscosity, ASTM D562, Krebs Units, max. 100
Contrast ratio, ASTM D2805, 5 ±0.5 mils wet film thickness,
dried 24 h on opacity chart 2A or 2C, min. 0.95
Dry hard, ASTM D1640, 5 mils wet film thickness, max. .....24 h

SECTION 909, BEGIN LINE 223, DELETE AND INSERT AS FOLLOWS:

(e) Finish Coat for Weathering Steel

The finish coat shall be an aliphatic polyurethane or a waterborne acrylic paint, and the dried paint film shall match color No. 20045 of SAE-AMS-STD-595. It shall be suitable for use as a finish coat over epoxy intermediate paint. The mixed paint shall be in accordance with the following requirements.

For aliphatic polyurethane paint:

Weight/volume, ASTM D1475, 25°C, min. .....1.200 kg/L
Total solids, % by weight, ASTM D2369, min. 60
Volatile Organic Compounds, ASTM D3960, max. .....336 g/L
Specular gloss, 60°, *10 ±0.5 mils wet film thickness*
on a tin coated steel panel, dried 48 h, ASTM D523, max. .....~~25~~*30*

For waterborne acrylic paint:

Weight/volume, ASTM D1475, 25°C, min. .....1.200 kg/L
Total solids, % by weight, ASTM D2369, min. 48
Volatile Organic Compounds, ASTM D3960, max. .....180 g/L
Specular gloss, 60°, *10 ±0.5 mils wet film thickness*
on a tin coated steel panel, dried 48 h, ASTM D523, max. .....~~25~~*30*