1. PROTECTIVE PAINT SYSTEM ON M.S RAILING WORKS-

STEP-01 –Surface Preparation – ABRASIVE BLASTING IS MOST RECOMMENDED.
However in cases where it is not possible manual cleaning to be done as stated below.

a) Emery Paper (no 80/60) + Wire Brush + power tool (as required) cleaning quality to SSPC standards ST2 & ST3 standards.
b) Wash off the Residue to get a clean surface
i) Mop with wet cloth.
ii) Clean the cloth & again mop it with the wet cloth.
iii) Allow it to dry naturally.
iv) Check with moisture meter (should be less than 8 %).

STEP-02 – After drying apply 1ST coat of epoxy primer @ 95 microns (Brush + Roller application), immediately (within 2 hours) after surface preparation at vendor's workshop/ site.

Check point A :- Lodha CM team to check coating thickness with an Elcometer for DFT (Dry Film Thickness) & in process also check WFT (Wet film thickness). DFT should be 95 microns & WFT should be @ 115 microns.

STEP 03 – Wrap it after drying (drying time -min 12 – 16 hrs @ 25 – 45 c).

STEP 04 - Post completion of all surrounding wet works (within 3 months of applying **Epoxy Primer**),

i) Light sanding and wash clean with water.
ii) Touch up with **Epoxy Primer** (wherever required) to bring it back to original DFT of 95 microns.

STEP 05– On dry surface apply final coat of **PU Paint** (brush + roller application) @ 50 microns to approved color shade.

NOTE: For enhanced finish, spray application can be done, but it will be costlier by @35% due to excess wastage during spray application.

Check point B :- Vendor to submit DFT checklist to ensure min 50 microns is applied & the same needs to be verified by lodha CM team. Coating thickness can be checked with an Elcometer for DFT (Dry Film Thickness) & in process also check WFT (Wet flim thickness). DFT should be 50 microns & WFT should be 65 microns.

APPROVED PROTECTIVE PAINT SYSTEMS ON MS RAILING AND FENCING WORKS (145 microns DFT)	
Option -01 (Berger System)	**EPOXY PRIMER :-** Berger PROTECTOMASTIC BPL coating @ 95 Microns.
	PU PAINT - BR PU high gloss enamel @ 50 MICRONS.
Option -02 (Akzonobel System)	**EPOXY PRIMER** - INTERSEAL 547 @ 95 MICRONS.
	PU PAINT - INTERTHANE 990 @ 50 MICRONS.
Option -03 (Asian Paints System)	**EPOXY PRIMER :-** Sigmacover 620 @ 95 MICRONS.
	PU PAINT - SIGMADUR 520 @ 50 MICRONS.

2. PROTECTIVE PAINT SYSTEM ON M.S STRUCTURAL WORKS

STEP-01 –Surface Preparation – ABRASIVE BLASTING IS RECOMMENDED FOR ALL STRUCUTRAL STEEL WORKS.

Clean the blasted surface with wire brush/blow dryer to remove any loose material clinging onto the blasted steel surface.

STEP-02 –After cleaning apply 1st coat of **Epoxy Primer@ 100 microns** (Brush + Roller application) immediately (within 2 hours) after surface preparation at vendor's workshop.

STEP-03 --After drying (min 12 – 16 hrs @ 25 – 45 c) apply 2nd coat of **Epoxy Primer@ 75 microns** (Brush + Roller application).

Check point A:- Lodha CM team to check coating thickness with an Elcometer for DFT (Dry Film Thickness) & in process also check WFT (Wet film thickness). DFT should be 100/ 75 microns & WFT should be @ 120/ 95 microns respectively.

STEP 04 - Wrap it after drying (min 12 – 16 hrs @ 25 – 45 c).

STEP 05 - Post completion of all surrounding wet works (within 3 months of applying **Epoxy primer**) i) Light sanding and wash clean with water.
ii) Touch up **Epoxy primer** (wherever required) to bring it back to original DFT of 175 microns.

STEP 06 – On dry surface apply final coat of **PU Paint** @ 75 microns in approved color shade (2 coats of 37.5 microns by Spray Application).
Check point B :- Lodha CM team to check coating thickness with an Elcometer for DFT (Dry Film Thickness) & in process also check WFT (Wet film thickness). DFT should be 75 microns & WFT should be @ 95 microns.

APPROVED PROTECTIVE PAINT SYSTEMS ON MS STRUCTURAL WORKS (250 microns DFT).	
Option -01 (Berger Paint System)	**Epoxy Primer :-** Protectomastic BPL @ 100 Microns
	Intermediate Coat :- Epilux 4 High build Mio @ 75 Microns.
	Pu Paint - Bergerthane Finish @ 75 Microns.
Option -02 (Akzonobel Paint System)	**Epoxy primer -** Interplus 256 @ 175 Microns.
	Pu Paint - Interthane 990 @ 75 Microns.
Option -03 (Asian Paints System)	**Epoxy Primer :-** Sigmacover 620 @ 175 Microns.
	PU Paint - Sigmadur 550 @ 75 Microns.