PRESERVATION PROCESS INSTRUCTION (PPI) for
BILGES
to be used in conjunction with
CORE PPI 63101-000 with a
Surface Preparation Method of Abrasive Blasting with Sponge Jet Media

Test and Evaluation Only

<table>
<thead>
<tr>
<th>AGENCY</th>
<th>Approved by</th>
<th>DATE</th>
</tr>
</thead>
<tbody>
<tr>
<td>NAVSEA 05M1</td>
<td></td>
<td>10 JUNE 05</td>
</tr>
<tr>
<td>TYCOM (if required)</td>
<td></td>
<td></td>
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<tr>
<td>TYCOM (if required)</td>
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</table>
1. **SCOPE:**

1.1 Cleaning, Surface Preparation and Painting Requirements for Bilges.

2. **REFERENCES:**

   (IN ADDITION TO THE ELEMENTS CONTAINED IN THE CORE PPI, ADD THE FOLLOWING SUPPLEMENTAL ELEMENTS)

2.c. MSDS and manufacturer’s ASTM F 718 sheets, Shipbuilders and Marine Paints and Coating Product / Procedure Data Sheet for coating systems being applied for specified area.

   Bilge Surfaces prepared to SSPC-SP-11--------------------- MIL-PRF-24441, Euronavy ES 301 K/L/S, Interbond 998, Alocit 28.15.

   Bilge Surfaces prepared equivalent to SSPC-SP-10 ------ Euronavy ES 301 K/L/S, Interbond 998, Alocit 28.15.

3. **APPENDICES:**

   (REFER TO CORE PPI EXCEPT FOR APPENDIX 10)

4. **REQUIREMENTS:**

   (REFER TO CORE)

5. **PRE-SURFACE PREPARATION:**

   (REFER TO CORE)

6. **SURFACE PREPARATION:**

   (REFER TO CORE PPI AND AUGMENT IT WITH THE FOLLOWING CORRELATE/SUPPLEMENTAL ELEMENTS)

6.2 METHOD 1: Accomplish the overhaul surface preparation requirements equivalent to a minimum of SSPC-SP-10 using abrasive blast with sponge jet media IAW Table 631-11-1 (Surface Preparation), for the locations/area being prepared.

   **NOTE:** SPONGE JET MEDIA DOES NOT RICOCHET AND DAMAGE OR CONTAMINATE ADJACENT AREAS AS OTHER BLAST MEDIA, HOWEVER CARE SHOULD BE TAKEN TO CONTAIN, CONTROL AND COLLECT SPONGE MEDIA.

6.3 Not Applicable to this PPI

6.4 POWER TOOL CLEANING ON SURFACES INACCESSIBLE TO METHOD 1:

   **NOTES:** SURFACE PREPARATION METHOD OF SSPC-SP-15 MAY BE USED INSTEAD OF SSPC-SP-11 WHEN THE FOLLOWING COATING SYSTEMS ARE USED: EURONAVY ES-301 K/L/S, INTERBOND 998, ALOCIT 28.15.

   IMPLEMENTING AUTHORITY WILL DESIGNATE SURFACE PREPARATION METHOD TO USE, SSPC-SP-11 OR SSPC-SP-15.

   APPLICATION OF MIL-PRF-24441 COATING APPLIES ONLY TO AREAS PREPARED TO SSPC-SP-11.

   6.4.1 Power Tool Cleaning to Bare Metal:

   6.4.1.1 Accomplish the overhaul surface preparation requirements of SSPC-SP-11 and Table 631-11-1, (Surface Preparation), for the location/area being prepared. Minimum requirement is SSPC-SP-11.

   6.4.1.2 Accomplish the overhaul surface preparation requirements of SSPC-SP-15 and Table 631-11-1, (Surface Preparation), for the location/area being prepared. Minimum requirement is SSPC-SP-15.

   6.4.2 Surface preparation accomplished using a surface preparation device such as a disk sander or power wire wheel that burnishes, polishes or smoothes the surface is not authorized. Accomplish a surface profile of 1 mil minimum.

   6.4.3 Feather edges of well-adhered adherent paint in adjacent areas remaining after cleaning.
6.4.4 The Responsible Implementing Authority shall have the authority to reject this method in any area if the surface can be shown to have adequate accessibility for Abrasive Blasting using abrasive blast with sponge jet media.

6.5.2.3 If conductivity measurements for surfaces prepared to an SSPC-SP-11 or SSPC-SP-15 in an isolated area exceed the respective values, circle area and perform spot solvent cleaning (Super High Flash Naphtha) followed by retest.

7. **PAINTING REQUIREMENTS:**

7.14 **REPAIRS:**

**NOTES:** SURFACE PREPARATION METHOD OF SSPC-SP-15 MAY BE USED INSTEAD OF SSPC-SP-11 WHEN THE FOLLOWING COATINGS ARE USED FOR REPAIRS: EURONAVY ES 301 K/L, INTERBOND 998, ALOCIT 28.15.

IMPLEMENTING AUTHORITY WILL DESIGNATE SURFACE PREPARATION METHOD FOR REPAIRS.

APPLICATION OF MIL-PRF-24441 COATING APPLIES ONLY TO AREAS PREPARED TO SSPC-SP-11.

8. **PRIMER COAT APPLICATION:**

9. **STRIPE COAT APPLICATION:**

10. **INTERMEDIATE COAT APPLICATION:**

11. **STRIPE COAT APPLICATION:**

12. **TOPCOAT APPLICATION:**

13. **FINAL INSPECTION:**

APPENDIX 1: QA INSPECTION FORM – ENVIRONMENTAL READING

APPENDIX 2: QA INSPECTION FORM – SURFACE SOLUBLE SALT CONDUCTIVITY LOG

APPENDIX 3: QA INSPECTION FORM – SURFACE PROFILE LOG

APPENDIX 4: QA INSPECTION FORM – DRY FILM THICKNESS MEASUREMENTS

APPENDIX 5: CHECKPOINTS & MILESTONES COMPLETION LOG

APPENDIX 6: CERTIFIED COATING INSPECTOR’S CHECKPOINT SIGN OFF LOG

APPENDIX 7: PAINT APPLICATION EQUIPMENT & PAINT CONSUMPTION LOG

APPENDIX 8: SURFACE CONDUCTIVITY TESTING PROCEDURE

APPENDIX 9: (NOT APPLICABLE TO THIS PPI)

APPENDIX 10: COATING SYSTEM (S)
## COATING SYSTEMS

<table>
<thead>
<tr>
<th>Coating</th>
<th>EuroNavy ES 301 K, L and S</th>
<th>F150/156 Type IV</th>
<th>F150/151/152 Type III</th>
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<tbody>
<tr>
<td>Prime</td>
<td>4 – 6 mils DFT (ES-301 K/L)</td>
<td>4 – 6 mils DFT (150)</td>
<td>3 – 4 mils DFT (150)</td>
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<tr>
<td>Stripe</td>
<td>4 – 6 mils DFT (ES-301 S)</td>
<td>2 – 4 mils DFT</td>
<td>2 – 4 mils DFT</td>
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<tr>
<td>Intermediate</td>
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<td>N/A</td>
<td>3 – 4 mils DFT</td>
</tr>
<tr>
<td>Coat</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Stripe</td>
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<td>N/A</td>
<td>2 – 4 mils DFT</td>
</tr>
<tr>
<td>Top</td>
<td>4 – 6 mils DFT (ES-301S)</td>
<td>4 – 6 mils DFT (156)</td>
<td>3 – 4 mils DFT (152)</td>
</tr>
<tr>
<td>System DFT</td>
<td>8 – 12 mils DFT</td>
<td>8 – 12 mils DFT</td>
<td>9 – 12 mils DFT</td>
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<tr>
<td></td>
<td>12 – 18 mils DFT with stripe coat</td>
<td>10 – 16 mils DFT with stripe coat</td>
<td>13 – 20 mils DFT with stripe coat</td>
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<table>
<thead>
<tr>
<th>Coating</th>
<th>Interbond 998</th>
<th>Alocit 28.15</th>
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<tbody>
<tr>
<td>Prime</td>
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<td>5 – 7 mils DFT</td>
</tr>
<tr>
<td>Stripe</td>
<td>6 – 7 mils DFT</td>
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<td>Top</td>
<td>6 – 7 mils DFT</td>
<td>5 – 7 mils DFT</td>
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<tr>
<td>System DFT</td>
<td>12 – 14 mils DFT</td>
<td>10 – 14 mils DFT</td>
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<tr>
<td></td>
<td>18 – 21 mils DFT with stripe coat</td>
<td>15 – 21 mils DFT with stripe coat</td>
</tr>
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