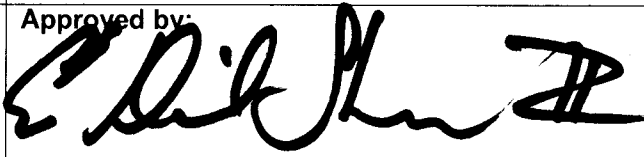


**PRESERVATION PROCESS INSTRUCTION (PPI) for
REPAIR TO BALLAST TANKS
to be used in conjunction with
CORE PPI 63101- 000 with a
Surface Preparation Method of Abrasive Blasting with Sponge Jet Media**

Test and Evaluation Only

| AGENCY | | DTE |
|---------------------|--|---------|
| NAVSEA 05M1 | Approved by:  | 10SEP03 |
| TYCOM (if required) | Approved by: | |
| TYCOM (if required) | Approved by: | |

- 1. **SCOPE:**
- 1.1 Cleaning, Surface Preparation and Painting Requirements for Repairs to Ballast Tanks.
- 2. **REFERENCES:** (REFER TO CORE PPI)
- 3. **APPENDICES:** (REFER TO CORE PPI EXCEPT FOR APPENDIX 10)
- 4. **REQUIREMENTS:** (REFER TO CORE PPI)
- 5. **PRE-SURFACE PREPARATION:** (REFER TO CORE PPI AND AUGMENT IT WITH THE FOLLOWING CORRELATE / SUPPLEMENTAL ELEMENTS)

5.3 **DEGREASE / FRESH WATER WASH DOWN:** Prior to surface preparation, remove all surface contaminants such as marine growth, mud, grease and oil (hydrocarbons), salts, loose paint and loose rust; with 5,000-PSI minimum fresh water wash down. Use vacuum to remove standing water followed by an adequate time to allow the surface to dry prior to surface preparation. SSPC-SP-1 requirements shall be met.

5.3.1 Mark areas to be repaired with white, black or red board marker.

- 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

- 7. **PAINTING REQUIREMENTS:** (REFER TO CORE PPI AND THE FOLLOWING SUPPLEMENTAL ELEMENT TO IT)

7.9.1 Reactivated adjacent surfaces to be painted IAW Ref. 2.c.

- 8. **PRIMER COAT APPLICATION:** (REFER TO CORE PPI)
- 9. **STRIPE COAT APPLICATION:** (REFER TO CORE PPI)
- 10. **Not Applicable to this PPI:**
- 11. **Not Applicable to this PPI.**
- 12. **TOPCOAT APPLICATION:** (REFER TO CORE PPI)
- 13. **FINAL INSPECTION:** (REFER TO CORE PPI)

NOTE: ALLOW COATING TO DRY FOR 7 DAYS PRIOR TO TANK CLOSEOUT.

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| <u>APPENDIX 1: QA INSPECTION FORM – ENVIRONMENTAL READING</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 2: QA INSPECTION FORM – SURFACE SOLUBLE SALT CONDUCTIVITY LOG</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 3: QA INSPECTION FORM – SURFACE PROFILE LOG</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 4: QA INSPECTION FORM – DRY FILM THICKNESS MEASUREMENTS</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 5: CHECKPOINTS & MILESTONES COMPLETION LOG</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 6: CERTIFIED COATING INSPECTOR’S CHECKPOINT SIGN OFF LOG</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 7: PAINT APPLICATION EQUIPMENT & PAINT CONSUMPTION LOG</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 8: SURFACE CONDUCTIVITY TESTING PROCEDURE</u> | (REFER TO CORE PPI) |
| <u>APPENDIX 9:</u> | (NOT APPLICABLE TO THIS PPI) |
| <u>APPENDIX 10: COATING SYSTEM</u> | (REFER TO THIS PPI) |

APPENDIX 10

COATING SYSTEMS

| Coating | EuroNavy ES 301 K, L and S |
|-------------------|--------------------------------------|
| Prime | 4-6 mils DFT (ES 301 K or L) |
| Stripe | 6-8 mils DFT (ES 301 S) |
| Top | 6-8 mils DFT (ES 301 S) |
| System DFT | 10-14 mils DFT |
| | 16-22 mils DFT for Stripe Coat Areas |