


**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

AGENCY		DATE
NAVSEA 05M1	Approved by: 	10 SEP 03
TYCOM (if required)	Approved by:	
TYCOM (if required)	Approved by:	

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:** (REFER TO CORE PPI AND THE FOLLOWING CORRELATE/SUPPLEMENTAL ELEMENTS TO IT)

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:** (REFER TO CORE PPI)
- 9. **STRIPE COAT APPLICATION:** (REFER TO CORE PPI)
- 10. **INTERMEDIATE COAT APPLICATION:** (REFER TO CORE PPI) (24441 Type III system)
- 11. **STRIPE COAT APPLICATION:** (REFER TO CORE PPI) (24441 Type III system)
- 12. **TOPCOAT APPLICATION:** (REFER TO CORE PPI)
- 13. **FINAL INSPECTION:** (REFER TO CORE PPI)

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

APPENDIX 10

COATING SYSTEMS

Coating	EuroNavy ES 301 K, L and S	F150/156 Type IV	F150/151/152 Type III
Prime	4 – 6 mils DFT (ES-301 K/L)	4 – 6 mils DFT (150)	3 – 4 mils DFT (150)
Stripe	4 – 6 mils DFT (ES-301 S)	2 – 4 mils DFT	2 – 4 mils DFT
Intermediate Coat	N/A	N/A	3 – 4 mils DFT
Stripe	N/A	N/A	2 – 4 mils DFT
Top	4 – 6 mils DFT (ES-301S)	4 – 6 mils DFT (156)	3 – 4 mils DFT (152)
System DFT	8 – 12 mils DFT	8 – 12 mils DFT	9 – 12 mils DFT
	12 – 18 mils DFT with stripe coat	10 – 16 mils DFT with stripe coat	13 – 20 mils DFT with stripe coat

Coating	Interbond 998	Alocit 28.15
Prime	6 – 7 mils DFT	5 – 7 mils DFT
Stripe	6 – 7 mils DFT	5 – 7 mils DFT
Top	6 – 7 mils DFT	5 – 7 mils DFT
System DFT	12 – 14 mils DFT	10 – 14 mils DFT
	18 – 21 mils DFT with stripe coat	15 – 21 mils DFT with stripe coat