

PENBERTHY

application report

Section 2000
Application Report 2600.1
Issued 05/05
Replaces 05/04

For: **FLAT GLASS GAGE OFFSHORE PREPARATION AND SPECIFICATION**

I. Materials of Construction

Covers and chambers shall be prepared and coated as stated in (II.) below. All fastener hardware, U-bolts, etc. shall be 316 stainless steel that is shot blasted prior to assembly to accomplish a 1 to 2 mil anchor profile for subsequent coatings. Flat 18-8 (302-304) stainless steel washers are required under nuts to distribute bolt loads. Glass shall be tempered borosilicate and completely protected on both edges to prevent casual damage from nearby installation or maintenance operation such as snag grinding or sandblasting. In addition, 1/4" minimum thickness glass protectors shall be affixed to vision slot(s), using silicone rubber sealant to prevent surface damage.

II. Surface Preparation and Coating

Chambers and covers shall be finish machined, sandblasted to white metal producing a 1 to 2 mil anchor profile and prime coated with 0.5 to 1.0 mils dry film thickness of inorganic zinc (priming operation must occur the same day as the sandblasting). After drying, surface variations shall be removed prior to assembly. The assembled gage shall be coated with inorganic zinc on all external surfaces except glass to a 2.5 to 3.0 mil thickness. The assembled gage shall be coated with epoxy tie coat on all external surfaces except glass to a 4.0 to 8.0 mil dry film thickness. The final coat shall be polyurethane to a 2.0 to 3.0 mil dry film thickness.

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application report

For: GAGECOCK OFFSHORE PREPARATION AND SPECIFICATION

I. Surface Preparation and Coating

Assembled gagecocks are sandblasted to white metal producing a 1 to 2 mil anchor profile and prime coated with inorganic zinc to 2.5 to 3.0 mils dry film thickness (priming operation must occur the same day as the sandblasting). After drying, surface variations shall be removed.

The gagecocks are coated with epoxy tie coat on all external surfaces except stem, to a 4.0 to 8.0 mil dry film thickness. The final coat shall be polyurethane to a 2.0 to 3.0 mil dry film thickness.