

CPS Definition

Standard:

ISO 12944-5; C4.10; H

COATING	INNER 80 µm	OUTER 200 µm		
	PRIMARY	PRIMARY	INTERMEDIATE	TOP (2)*
Coating designation	EP – Primer EMC 182 white K-DB	EP-zinc rich primer EMD 156-HS	EP-micaceous iron intermediate coat EMD 30	PUR top coat ADD 47 or PUR-Mica top coat ADD 43
Coating kind	Epoxy primer	Zinc-Rich Epoxy Primer	Epoxy intermediate coat	Acrylate polyurethane
Shade	White, mat	Grey, mat	Red brown, mat	Glossy or mat, RAL XXXX
Manufacturer	CHING	CHING	CHING	CHING
Surface state prior sand blasting ISO 8501-1:2007	A or B	A or B	/	/
ISO 8501-3:2006	P2	P2		
Surface state prior coating ISO 8501-1:2007	Abrasive blasting Sa 2 ½	Abrasive blasting Sa 2 ½	dry, dedusted, degreased	dry, dedusted, degreased
Number and thickness of layers	1 x 80 µm	1 x 60 µm	1 x 80 µm	1 x 60 µm
Recommended layer thickness	60÷120 µm	60÷100 µm	80÷120 µm	60÷100 µm
Total allowed deviation	(1)*	Total thickness (1)*		
Coating application	Airless Conventional spray Brush Roller	Airless Conventional spray Brush Roller	Airless Conventional spray Brush Roller	Airless Conventional spray Brush Roller
Cross-cut test (3)* ISO 2409:2020	1	1	1	2
Spreading rate (approximate)	4,6 m ² /kg	2,9 m ² /kg	5,1 m ² /kg	5,4 m ² /kg or 5,0 m ² /kg

REMARKS:

- The final control of adhesion and thickness of coatings is carried out in a well dry coating.
- Surface state prior to coating application shall be determined by ISO 8501-1:2007, on the basis of image samples.
- (1)* Dry film thickness (DFT) acceptance criteria: ISO 12944-5:2019, chapter 7.3 and ISO 19840:2012, chapter 9.
- (2)* Top coat, RAL and finish are defined in the order document.
- (3)* The test requirement is defined in the order document.
- For applications is required to use the technical instructions of the manufacturer of paints and standard ISO 12944-5:2019.
- When working with the selected coatings type, the minimum or maximum time that must or may elapse before the application of the previous coat must be taken into account.
- The use of a brush and roller is only permitted for painting hard to reach areas.
- For any deviations from the requirements above, the contractor must obtain the consent of the contracting authority and shall inform the person which has met document.



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