

# BOLTED COATING PROCESS



**1. Chemical Wash** .....  
Chemical wash, rinse and oven dry steel.



**2. Mechanical Blast**  
Controlled blast with a shot & grit mix providing a minimum of SSPC-SP10 (SA 2.5) near-white blast with 2.0-3.0 mil profile.



**3. Powder Coating**  
Application of Trico-Bond EP; interior coated at 5.0 mils average DFT for liquid storage and 3.0 mils minimum DFT for dry bulk tanks. Exterior coated to 3.0 mils minimum DFT. Higher build rates are available.



**4. Initial Cure**  
Partial cure of coatings at 330°F (165°C).



**5. Top Coat**  
Application of aliphatic polyurethane at 1.5 mils average DFT to the exterior of the staves.



**6. Final Cure**  
Final cure of coating system at 400°F (204°C).

