

**SECTION 09 91 00
PAINTING**

PART 1-GENERAL

1.01 DESCRIPTION

- A. Section specifies field painting.
- B. Section specifies prime coats which may be applied in shop under other sections.
- C. Painting includes shellacs, stains, varnishes, and coatings specified.

1.02 RELATED WORK

- A. Shop prime painting of steel and ferrous metals: Division 05 - METALS, Division 10 - SPECIALTIES, Division 12 – FURNISHINGS.
- B. Type of Finish, Color, and Gloss Level of Finish Coat: Section 09 06 00, SCHEDULE FOR FINISHES.

1.03 SUBMITTALS

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Manufacturer's Literature and Data:
 - 1. Before work is started, or sample panels are prepared, submit manufacturer's literature, the current Master Painters Institute (MPI) "Approved Product List" indicating brand label, product name and product code as of the date of contract award, will be used to determine compliance with the submittal requirements of this specification. The Contractor may choose to use subsequent MPI "Approved Product List", however, only one list may be used for the entire contract and each coating system is to be from a single manufacturer. All coats on a particular substrate must be from a single manufacturer. No variation from the MPI "Approved Product List" where applicable is acceptable.
- C. Sample Panels:
 - 1. After painters' materials have been approved and before work is started submit sample panels showing each type of finish and color specified.
 - 2. Panels to show color: metal, wood, glass or as appropriate to final product and finish, 100 by 250 by 3 mm (4 inch by 10 inch by 1/8 inch).
 - 3. Panel to show transparent finishes: Wood of same species and grain pattern as wood approved for use, 100 by 250 by 3 mm (4 inch by 10 inch face by 1/4 inch) thick minimum, and where both flat and edge grain will be exposed, 250 mm (10 inches) long by sufficient size, 50 by 50 mm (2 by 2 inch) minimum or actual wood member to show complete finish.
 - 4. Attach labels to panel stating the following:
 - a. Federal Specification Number or manufacturers name and product number of paints used.
 - b. Specification code number specified in Section 09 06 00, SCHEDULE FOR FINISHES.
 - c. Product type and color.
 - d. Name of project.

5. Strips showing not less than 50 mm (2 inch) wide strips of undercoats and 100 mm (4 inch) wide strip of finish coat.
- D. Sample of identity markers if used.
- E. Manufacturers' Certificates indicating compliance with specified requirements:
 1. Manufacturer's paint substituted for Federal Specification paints meets or exceeds performance of paint specified.
 2. High temperature aluminum paint.
 3. Epoxy coating.

1.04 DELIVERY AND STORAGE

- A. Deliver materials to site in manufacturer's sealed container marked to show following:
 1. Name of manufacturer.
 2. Product type.
 3. Batch number.
 4. Instructions for use.
 5. Safety precautions.
- B. In addition to manufacturer's label, provide a label legibly printed as following:
 1. Federal Specification Number, where applicable, and name of material.
 2. Surface upon which material is to be applied.
 3. If paint or other coating, state coat types; prime, body or finish.
- C. Maintain space for storage, and handling of painting materials and equipment in a neat and orderly condition to prevent spontaneous combustion from occurring or igniting adjacent items.
- D. Store materials at site at least 24 hours before using, at a temperature between 18 and 30 degrees C (65 and 85 degrees F).

1.05 APPLICABLE PUBLICATIONS

- A. Publications listed below form a part of this specification to the extent referenced. Publications are referenced in the text by basic designation only.
- B. American Conference of Governmental Industrial Hygienists (ACGIH):
ACGIH TLV-BKLT-2012 Threshold Limit Values (TLV) for Chemical Substances and Physical Agents and Biological Exposure Indices (BEIs)
ACGIH TLV-DOC-2012. Documentation of Threshold Limit Values and Biological Exposure Indices, (Seventh Edition)
- C. American National Standards Institute (ANSI):
A13.1-07..... Scheme for the Identification of Piping Systems
- D. American Society for Testing and Materials (ASTM):
D260-86.....Boiled Linseed Oil
- E. Commercial Item Description (CID):
A-A-1555 Water Paint, Powder (Cementitious, White and Colors) (WPC)
(cancelled)
- F. Federal Specifications (Fed Spec):
TT-P-1411A..... Paint, Copolymer-Resin, Cementitious (For Waterproofing Concrete and Masonry Walls) (CEP)
- G. Master Painters Institute (MPI):
No. 1-12Aluminum Paint (AP)
No. 4-12 Interior/ Exterior Latex Block Filler

No. 5-12	Exterior Alkyd Wood Primer
No. 7-12	Exterior Oil Wood Primer
No. 8-12	Exterior Alkyd, Flat MPI Gloss Level 1 (EO)
No. 9-12	Exterior Alkyd Enamel MPI Gloss Level 6 (EO)
No. 10-12	Exterior Latex, Flat (AE)
No. 11-12	Exterior Latex, Semi-Gloss (AE)
No. 18-12	Organic Zinc Rich Primer
No. 22-12	Aluminum Paint, High Heat (up to 590° - 1100°F) (HR)
No. 26-12	Cementitious Galvanized Metal Primer
No. 31-12	Polyurethane, Moisture Cured, Clear Gloss (PV)
No. 36-12	Knot Sealer
No. 71-12	Polyurethane, Moisture Cured, Clear, Flat (PV)
No. 77-12	Epoxy Cold Cured, Gloss (EC)
No. 79-12	Marine Alkyd Metal Primer
No. 91-12	Wood Filler Paste
No. 94-12	Exterior Alkyd, Semi-Gloss (EO)
No. 95-12	Fast Drying Metal Primer
No. 98-12	High Build Epoxy Coating
No. 101-12	Epoxy Anti-Corrosive Metal Primer
No. 108-12	High Build Epoxy Coating, Low Gloss (EC)
No. 119-12	Exterior Latex, High Gloss (acrylic) (AE)
No. 135-12	Non-Cementitious Galvanized Primer

- H. Steel Structures Painting Council (SSPC):
SSPC SP 1-04 (R2004) Solvent Cleaning
SSPC SP 2-04 (R2004) Hand Tool Cleaning
SSPC SP 3-04 (R2004) Power Tool Cleaning

PART 2 - PRODUCTS

2.01 MATERIALS

- A. Aluminum Paint (AP): MPI 1.
- B. Exterior Oil Wood Primer: MPI 7.
- C. Exterior Alkyd, Flat (EO): MPI 8.
- D. Exterior Alkyd Enamel (EO): MPI 9.
- E. Exterior Latex, Flat (AE): MPI 10.
- F. Exterior Latex, Semi-Gloss (AE): MPI 11.
- G. Organic Zinc rich Coating (HR): MPI 22.
- H. High Heat Resistant Coating (HR): MPI 22.
- I. Cementitious Galvanized Metal Primer: MPI 26.

- J. Epoxy Cold Cured, Gloss (EC): MPI 77.
- K. Marine Alkyd Metal primer: MPI 79.
- L. Exterior Alkyd, Semi-Gloss (EO): MPI 94.
- M. Fast Drying Metal Primer: MPI 95.
- N. High Build Epoxy Coating: MPI 98.
- O. Epoxy Anti-Corrosive Metal Primer: MPI 101.
- P. High Build Epoxy Marine Coating (EC): MPI 108.
- Q. Exterior Latex, High Gloss (acrylic) (AE): MPI 119.
- R. Waterborne Galvanized Primer: MPI 134.
- S. Non-Cementitious Galvanized Primer: MPI 135.

2.02 PAINT PROPERTIES

- A. Use ready-mixed (including colors), except two component epoxies, polyurethanes, polyesters, paints having metallic powders packaged separately and paints requiring specified additives.
- B. Where no requirements are given in the referenced specifications for primers, use primers with pigment and vehicle, compatible with substrate and finish coats specified.

2.03 REGULATORY REQUIREMENTS/QUALITY ASSURANCE

- A. Paint materials shall conform to the restrictions of the local Environmental and Toxic Control jurisdiction.
 - 1. Volatile Organic Compounds (VOC): VOC content of paint materials shall not exceed 10g/l for interior latex paints/primers and 50g/l for exterior latex paints and primers.
 - 2. Lead-Base Paint:
 - a. Comply with Section 410 of the Lead-Based Paint Poisoning Prevention Act, as amended, and with implementing regulations promulgated by Secretary of Housing and Urban Development.
 - b. Regulations concerning prohibition against use of lead-based paint in federal and federally assisted construction, or rehabilitation of residential structures are set forth in Subpart F, Title 24, Code of Federal Regulations, Department of Housing and Urban Development.
 - 3. Asbestos: Materials shall not contain asbestos.
 - 4. Chromate, Cadmium, Mercury, and Silica: Materials shall not contain zinc-chromate, strontium-chromate, Cadmium, mercury or mercury compounds or free crystalline silica.
 - 5. Human Carcinogens: Materials shall not contain any of the ACGIH-BKLT and ACGHI-DOC confirmed or suspected human carcinogens.
 - 6. Use high performance acrylic paints in place of alkyd paints, where possible.
 - 7. VOC content for solvent-based paints shall not exceed 250g/l and shall not be formulated with more than one percent aromatic hydro carbons by weight.

PART 3 – EXECUTION

3.01 JOB CONDITIONS

- A. Safety: Observe required safety regulations and manufacturer's warning and instructions for storage, handling and application of painting materials.
 - 1. Take necessary precautions to protect personnel and property from hazards due to falls, injuries, toxic fumes, fire, explosion, or other harm.
 - 2. Deposit soiled cleaning rags and waste materials in metal containers approved for that purpose. Dispose of such items off the site at end of each day's work.
- B. Atmospheric and Surface Conditions:
 - 1. Do not apply coating when air or substrate conditions are:
 - a. Less than 3 degrees C (5 degrees F) above dew point.
 - b. Below 10 degrees C (50 degrees F) or over 35 degrees C (95 degrees F), unless specifically pre-approved by the Contracting Officer and the product manufacturer. Under no circumstances shall application conditions exceed manufacturer recommendations.
 - 2. Do no exterior painting when it is windy and dusty.
 - 3. Do not paint in direct sunlight or on surfaces that the sun will soon warm.
 - 4. Apply only on clean, dry and frost free surfaces except as follows:
 - a. Apply water thinned acrylic and cementitious paints to damp (not wet) surfaces where allowed by manufacturer's printed instructions.
 - b. Dampened with a fine mist of water on hot dry days concrete and masonry surfaces to which water thinned acrylic and cementitious paints are applied to prevent excessive suction and to cool surface.
 - 5. Varnishing:
 - a. Apply in clean areas and in still air.
 - b. Before varnishing vacuum and dust area.
 - c. Immediately before varnishing wipe down surfaces with a tack rag.

3.02 SURFACE PREPARATION

- A. Method of surface preparation is optional, provided results of finish painting produce solid even color and texture specified with no overlays.
- B. General:
 - 1. Remove prefinished items not to be painted such as lighting fixtures, escutcheon plates, hardware, trim, and similar items for reinstallation after paint is dried.
 - 2. Remove items for reinstallation and complete painting of such items and adjacent areas when item or adjacent surface is not accessible or finish is different.
 - 3. See other sections of specifications for specified surface conditions and prime coat.
 - 4. Clean surfaces for painting with materials and methods compatible with substrate and specified finish. Remove any residue remaining from cleaning agents used. Do not use solvents, acid, or steam on concrete and masonry.
- C. Wood:
 - 1. Sand to a smooth even surface and then dust off.
 - 2. Sand surfaces showing raised grain smooth between each coat.
 - 3. Wipe surface with a tack rag prior to applying finish.
 - 4. Surface painted with an opaque finish:
 - a. Coat knots, sap and pitch streaks with MPI 36 (Knot Sealer) before applying paint.
 - b. Apply two coats of MPI 36 (Knot Sealer) over large knots.

5. After application of prime or first coat of stain, fill cracks, nail and screw holes, depressions and similar defects with wood filler paste. Sand the surface to make smooth and finish flush with adjacent surface.
 6. Before applying finish coat, reapply wood filler paste if required, and sand surface to remove surface blemishes. Finish flush with adjacent surfaces.
- D. Ferrous Metals:
1. Remove oil, grease, soil, drawing and cutting compounds, flux and other detrimental foreign matter in accordance with SSPC-SP 1 (Solvent Cleaning).
 2. Remove loose mill scale, rust, and paint, by hand or power tool cleaning, as defined in SSPC-SP 2 (Hand Tool Cleaning) and SSPC-SP 3 (Power Tool Cleaning). Exception: where high temperature aluminum paint is used, prepare surface in accordance with paint manufacturer's instructions.
 3. Fill dents, holes and similar voids and depressions in flat exposed surfaces of hollow steel doors and frames, access panels, roll-up steel doors and similar items specified to have semi-gloss or gloss finish with TT-F-322D (Filler, Two-Component Type, For Dents, Small Holes and Blow-Holes). Finish flush with adjacent surfaces.
 - a. This includes flat head countersunk screws used for permanent anchors.
 - b. Do not fill screws of item intended for removal such as glazing beads.
 4. Spot prime abraded and damaged areas in shop prime coat which expose bare metal with same type of paint used for prime coat. Feather edge of spot prime to produce smooth finish coat.
 5. Spot prime abraded and damaged areas which expose bare metal of factory finished items with paint as recommended by manufacturer of item.
- E. Zinc-Coated (Galvanized) Metal, Surfaces Specified Painted:
1. Clean surfaces to remove grease, oil and other deterrents to paint adhesion in accordance with SSPC-SP 1 (Solvent Cleaning).
 2. Spot coat abraded and damaged areas of zinc-coating which expose base metal on hot-dip zinc-coated items with MPI 18 (Organic Zinc Rich Coating). Prime or spot prime with MPI 134 (Waterborne Galvanized Primer) or MPI 135 (Non-Cementitious Galvanized Primer) depending on finish coat compatibility.

3.03 PAINT PREPARATION

- A. Thoroughly mix painting materials to ensure uniformity of color, complete dispersion of pigment and uniform composition.
- B. Do not thin unless necessary for application and when finish paint is used for body and prime coats. Use materials and quantities for thinning as specified in manufacturer's printed instructions.
- C. Remove paint skins, then strain paint through commercial paint strainer to remove lumps and other particles.
- D. Mix two component and two part paint and those requiring additives in such a manner as to uniformly blend as specified in manufacturer's printed instructions unless specified otherwise.
- E. For tinting required to produce exact shades specified, use color pigment recommended by the paint manufacturer.

3.04 APPLICATION

- A. Start of surface preparation or painting will be construed as acceptance of the surface as satisfactory for the application of materials.
- B. Unless otherwise specified, apply paint in three coats; prime, body, and finish. When two coats applied to prime coat are the same, first coat applied over primer is body coat and second coat is finish coat.
- C. Apply each coat evenly and cover substrate completely.
- D. Allow not less than 48 hours between application of succeeding coats, except as allowed by manufacturer's printed instructions, and approved by Resident Engineer.
- E. Finish surfaces to show solid even color, free from runs, lumps, brush marks, laps, holidays, or other defects.
- F. Apply by brush, roller or spray, except as otherwise specified.
- G. Do not paint in closed position operable items such as access doors and panels, doors, and similar items..

3.05 PRIME PAINTING

- A. After surface preparation prime surfaces before application of body and finish coats, except as otherwise specified.
- B. Spot prime and apply body coat to damaged and abraded painted surfaces before applying succeeding coats.
- C. Additional field applied prime coats over shop or factory applied prime coats are not required except for exterior exposed steel apply an additional prime coat.
- D. Metals except boilers, incinerator stacks, and engine exhaust pipes:
 - 1. Zinc-coated steel and iron: MPI 134 (Waterborne Galvanized Primer) Aluminum scheduled to be painted: MPI 95 (Fast Drying Metal Primer).

3.06 EXTERIOR FINISHES

- A. Apply following finish coats where specified in Section 09 06 00, SCHEDULE FOR FINISHES.
- B. Steel and Ferrous Metal :
 - 1. Two coats of MPI 94 (Exterior Alkyd, Semi-Gloss (EO)) on exposed surfaces, except on surfaces over 94 degrees C (200 degrees F).

3.07 REFINISHING EXISTING PAINTED SURFACES

- A. Clean, patch and repair existing surfaces as specified under surface preparation.
- B. Remove and reinstall items as specified under surface preparation.
- C. Remove existing finishes or apply separation coats to prevent non compatible coatings from having contact.
- D. Patched or Replaced Areas in Surfaces and Components: Apply spot prime and body coats as specified for new work to repaired areas or replaced components.

- E. Except where scheduled for complete painting apply finish coat over plane surface to nearest break in plane, such as corner, reveal, or frame.
- F. Refinish areas as specified for new work to match adjoining work unless specified or scheduled otherwise.

- G. Sand or dull glossy surfaces prior to painting.
- H. Sand existing coatings to a feather edge so that transition between new and existing finish will not show in finished work.

3.08 PAINT COLOR

- A. Color and gloss of finish coats is specified in Drawings.
- B. Coat Colors:
 - 1. Color of priming coat: Lighter than body coat.
 - 2. Color of body coat: Lighter than finish coat.
 - 3. Color prime and body coats to not show through the finish coat and to mask surface imperfections or contrasts.

3.09 MECHANICAL AND ELECTRICAL WORK FIELD PAINTING SCHEDULE

- A. Field painting of mechanical and electrical consists of cleaning, touching-up abraded shop prime coats, and applying prime, body and finish coats to materials and equipment if not factory finished in space scheduled to be finished.
- B. In spaces not scheduled to be finish painted, paint as specified under paragraph H, colors.
- C. Paint after tests have been completed.
- D. Omit prime coat from factory prime-coated items.
- E. Finish painting of mechanical and electrical equipment is not required when located in interstitial spaces, above suspended ceilings, in concealed areas such as pipe and electric closets, pipe basements, pipe tunnels, trenches, attics, roof spaces, shafts and furred spaces except on electrical conduit containing feeders 600 volts or more.
- F. Omit field painting of items specified in paragraph, Building and Structural WORK NOT PAINTED.
- G. Color:
 - 1. Paint items having no color specified in to match surrounding surfaces.
 - 2. Paint colors as specified in drawings except for following:
 - a. Federal Safety Red: Exposed fire protection piping hydrants, post indicators, electrical conducts containing fire alarm control wiring, and fire alarm equipment.
 - b. Federal Safety Orange: .Entire lengths of electrical conduits containing feeders 600 volts or more.
- H. Apply paint systems on properly prepared and primed surface as follows:
 - 1. Exterior Locations:
 - a. Apply two coats of MPI 94 (Exterior Alkyd, Semi-gloss (EO))to the following ferrous metal items:
 - b. Fire hydrants, post indicators, yard hydrants, exposed piping and similar items.
 - c. Apply two coats of MPI 11 (Exterior Latex, Semi Gloss (AE)) to the following metal items:
 - i. Galvanized and zinc-copper alloy metal.

3.10 BUILDING AND STRUCTURAL WORK FIELD PAINTING

- A. Painting and finishing of interior and exterior work except as specified under paragraph 3.11
- B.
 1. Painting and finishing of new and existing work including colors and gloss of finish selected is specified in Finish Schedule, Section 09 06 00, SCHEDULE FOR FINISHES.
 2. Painting of disturbed, damaged and repaired or patched surfaces when entire space is not scheduled for complete repainting or refinishing.
 3. Painting of ferrous metal and galvanized metal.
 4. Identity painting and safety painting.
- B. Building and Structural Work not Painted:
 1. Prefinished items: Finished surfaces:
 - a. Hardware except ferrous metal.
 - b. Anodized aluminum, stainless steel, chromium plating, as otherwise specified.
 - c. Signs, fixtures, and other similar items integrally finished.
 2. Labels:
 - a. Code required label, such as Underwriters Laboratories Inc., Inchcape Testing Services, Inc., or Factory Mutual Research Corporation.
 - b. Identification plates, instruction plates, performance rating, and nomenclature.
 3. Galvanized metal:
 - a. Exterior chain link fence and gates, and gratings.
 - b. Except where specifically specified to be painted.
 4. Metal safety treads and nosings.
 5. Gaskets.
 6. Concrete curbs, gutters, pavements, retaining walls, exterior exposed foundations walls and interior walls in pipe basements.
 7. Face brick.
 8. Structural steel encased in concrete, masonry, or other enclosure.
 9. Structural steel to receive sprayed-on fire proofing.
 10. .
 11. .

3.11 IDENTITY PAINTING SCHEDULE

1. :

PIPING	COLOR OF EXPOSED PIPING	COLOR OF BACKGROUND	COLOR OF LETTERS	LEGEND BBREVIATIONS
Drain Line		Green Brown	White	Drain

2. Electrical Conduits containing feeders over 600 volts, paint legends using 50 mm (2 inch) high black numbers and letters, showing the voltage class rating. Provide legends where conduits pass through walls and floors and at maximum 6100 mm (20 foot) intervals in between. Use labels with yellow background with black border and words Danger High Voltage Class, // 5000 // 15000 // 25000 //.

3. See Sections for methods of identification, legends, and abbreviations of the following:
 - a. Conduits containing high voltage feeders over 600 volts: Section 26 05 33, RACEWAY AND BOXES FOR ELECTRICAL SYSTEMS / Section 27 05 33, RACEWAYS AND BOXES FOR COMMUNICATIONS SYSTEMS / Section 28 05 33, RACEWAYS AND BOXES FOR ELECTRONIC SAFETY AND SECURITY.

3.12 PROTECTION CLEAN UP, AND TOUCH-UP

- A. Protect work from paint droppings and spattering by use of masking, drop cloths, removal of items or by other approved methods.
- B. Upon completion, clean paint from hardware, glass and other surfaces and items not required to be painted of paint drops or smears.
- C. Before final inspection, touch-up or refinished in a manner to produce solid even color and finish texture, free from defects in work which was damaged or discolored.

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APPENDIX

Coordinate the following abbreviations used in Section 09 91 00, PAINTING, with other Sections, especially Section 09 06 00, SCHEDULE FOR FINISHES and other COATING SECTIONS listed. Use the same abbreviation and terms consistently.

Paint or coating	Abbreviation
Acrylic Emulsion	AE (MPI 10 – flat/MPI 11 – semigloss/MPI 119 - gloss)
Alkyd Flat	Ak (MPI 49)
Alkyd Gloss Enamel	G (MPI 48)
Alkyd Semigloss Enamel	SG (MPI 47)
Aluminum Paint AP (MPI 1)	
Cementitious Paint	CEP (TT-P-1411)
Exterior Latex	EL??(MPI 10 / 11 / 119)??
Exterior Oil	EO (MPI 9 – gloss/MPI 8 – flat/MPI 94 – semigloss)
Epoxy Coating	EC (MPI 77 – walls, floors/MPI 108 – CMU, concrete)
Fire Retardant Paint	FR (MPI 67)
Fire Retardant Coating (Clear)	FC (MPI 66, intumescent type)
Floor Enamel	FE (MPI 27 – gloss/MPI 59 – eggshell)
Heat Resistant Paint	HR (MPI 22)
Latex Emulsion	LE (MPI 53, flat/MPI 52, eggshell/MPI 54, semigloss/MPI 114, gloss Level 6)
Latex Flat	LF (MPI 138)
Latex Gloss	LG (MPI 114)
Latex Semigloss	SG (MPI 141)
Latex Low Luster	LL (MPI 139)
Plastic Floor Coating	PL
Polyurethane Varnish	PV (MPI 31 – gloss/MPI 71 - flat)
Rubber Paint	RF (CID-A-A-3120 - Paint for Swimming Pools (RF)).
Water Paint, Cement	WPC (CID-A-A-1555 - Water Paint, Powder).
Wood Stain	WS (MPI 90)

Verify abbreviations used in the following coating sections:

Section 09 96 59, HIGH-BUILD GLAZED COATINGS	GC	
Section 09 94 19, MULTICOLOR INTERIOR FINISHING		MC

--- E N D ---

I. SPECIFICATION FOR POWDER COATING OVER HOT DIP GALVANIZING

The following specification is recommended:

1. Hot dip galvanize and do not water or chromate quench
2. Remove all drainage spikes and surface defects
3. Powdercoat within 12 hours of galvanizing. Do not get surfaces wet. Do not leave outside
4. Keep the surface clean. Do not transport uncovered loads. Diesel fumes will contaminate surface
5. If surface contamination has occurred or is suspected, clean surface with proprietary solvent/detergent designed for pre-cleaning prior to powdercoating
6. Use zinc phosphate pretreatment if highest adhesion is required. Surface must be perfectly clean. Zinc phosphate has no detergent action and will not remove oil or soil.
7. Use iron phosphate if standard performance is required. Iron phosphate has a slight detergent action and will remove small amounts of surface contamination. Best used for pre-galvanized products
8. Pre-heat work prior to powder application
9. Use 'degassing' grade polyester powder only

Check for correct curing by solvent testing. Adjust pre-heat and line speed to ensure full cure.

[ASTM D7803](#)