

Marine New Construction Systems Guide

The following system recommendation are based upon all steel plate being blasted in accordance with Steel Structures Painting Council standard SSPS-SP-10 "Near White Metal" to remove all mill scale, corrosion and other contamination. When pre-construction primers are not used, a surface profile of 2-2½ mils shall be obtained.

When pre-construction primers are used, secondary surface preparation prior to the application of the coating systems shall be based upon the type of pre-construction utilized, area of the vessel, desired service performance, compatibility with coating systems and other factors. Consult Carboline for exact recommendations.

The products listed within the following systems are those what would be considered as Carboline's standard recommendations, however, many alternate products are also available to better suit conditions during construction and other factors. Consult Carboline for alternate recommendations.

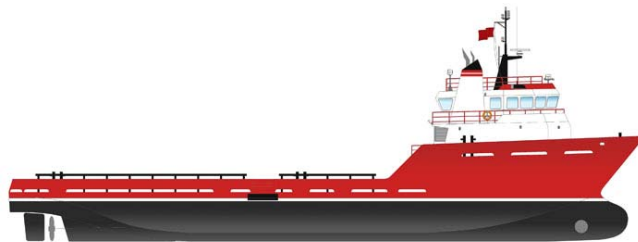
Area	Coating/System	DFT per coat	Remarks	
A. Underwater Hull	Carboguard 885	5-6 Mils	Extended maximum recoat interval (12 mths)	
	Carboguard 885	5-6 Mils	Apply 1 st coat of antifouling while "tacky"	
	C-Flex 123	3-4 Mils	Long life, ablativ antifouling	
	C-Flex 123	3-4 Mils	Flexible dry to launch schedules	
B. Hull above Waterline (Freeboard)	Carbozinc 859 Series	2-3 Mils	High zinc loading anticorrosive primer	
	Carboguard 885	4-6 Mils	See Product Data Sheet for recoat intervals	
	Carbothane 134 Series	2-3 Mils	High Gloss, chemical resistant recoatable polyurethane	
	Alternate 2 coat system	Carbozinc 859 Series	2-3 Mils	High zinc loading anticorrosive primer
		Carboxane 2000	5-6 Mils	Long Life, polysiloxane/epoxy topcoat
C. Exterior Decks	Carbozinc 859 Series	2-3 Mils	High zinc loading anticorrosive primer	
	Carboguard 885	4-6 Mils	See Product Data Sheet for recoat intervals	
	Carboguard 885	4-6 Mils	Mix with #36 or #47 aggregate for nonskid finish	
	Carbothane 134 Series	2-3 Mils	Optional polyurethane topcoat	
	High Abrasion Option	Carboguard 1209	10-12 Mils	Glass Flake Filler epoxy
		Carboguard 1209	10-12 Mils	Mix with # 36 or #47 aggregate for nonskid finish
	Carbothane 134 Series	2-3 Mils	Optional polyurethane topcoat	
D. Superstructure	Carbozinc 859 Series	2-3 Mils	High zinc loading anticorrosive primer	
	Carboguard 885	4-6 Mils	See Product Data Sheet for recoat intervals	
	Carbothane 134 Series	2-3 Mils	High Gloss, chemical resistant recoatable polyurethane	
	Alternate 2 coat system	Carbozinc 859 Series	2-3 Mils	High zinc loading anticorrosive primer
		Carboxane 2000	5-6 Mils	Long Life, polysiloxane/epoxy topcoat

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E. Interiors			
Accommodation Spaces, bulkheads and overheads not covered by paneling or insulation	Carbocoat 150	2-3 Mils	Universal primer
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	Carbocoat 45	2-3 Mils	Gloss alkyd finish (omit topcoat for areas covered)
All decks. Storage, work, Machinery spaces and Engine room except for bilges	Carboguard 885	4-6 Mils	Epoxy anticorrosive
	Sanitile 655	4-6 Mils	High gloss epoxy finish
Bilges and tank tops	Carboguard 885	4-6 Mils	Epoxy anticorrosive
	Carboguard 885	4-6 Mils	Epoxy anticorrosive

F. High Heat Areas			
F.1 Epoxy – 450°F	Thermaline 450	8-10 Mils	Topcoat with epoxies and polyurethanes
F.2 Zinc – 800°F	Thermaline 2977	2.5	
F.3 Silicone Alkyd – 1000°F	Thermaline 4700 Series	2.0	Limited color availability
F.4 Zinc/Silicone – 1200°F	Thermaline 4765	2.0	
F.5 Silicone Alkyd – 450°F	Thermaline 4900 Series	2.0	Available in colors

G. Tanks			
F.1 Ballast Tanks and double bottoms	Carboguard 885	4-6 Mils	Epoxy anticorrosive
	Carboguard 885	4-6 Mils	Epoxy anticorrosive
F.2 Potable Water Tanks	Carboguard 561	5-6 Mils	NSF Approved Epoxy
	Carboguard 561	5-6 Mils	NSF Approved Epoxy
F.3 Fuel Tanks	Phenoline 187 Primer	5-6 Mils	Epoxy Phenolic
	Phenoline 187 Topcoat	5-6 Mils	Epoxy Phenolic
F.4 Dry Cargo Tanks/Holds	Carboguard 885	4-6 Mils	Epoxy anticorrosive
	Carboguard 885	4-6 Mils	Epoxy anticorrosive
F.5 Chemical Cargo Tanks	** Consult Carboline **		Phenoline and Plasite tank linings are selected based upon actual cargos



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