

1.0 Scope

1.1 This procedure defines the methods for cleaning and coating Amarillo Gear Drives with a marine paint finish for a minimum dry film thickness of 0.020 inches.

2.0 Surface Preparation

- 2.1 Mask all surfaces that are to remain unpainted. These include input and output shafts, oil sight glass, mounting feet, vents and other optional accessories.
- 2.2 Sandblast the entire unit down to white metal per ANSI A159.1 1972 and remove all dust particles with Carboline Thinner #2.

3.0 Application (Follow manufacturer's application procedures as specified on the product data sheet)

3.1 Primary Coat

- 3.1.1 Spray one coat on all exposed surfaces to achieve a dry film thickness of .002 to .003 inches.
- 3.1.2 Air dry for 24 hours before applying the topcoat.

3.2 Top Coats

- 3.2.1 Mix parts A and B separately. Mix together in equal proportions and thin up to 10%, by volume, with thinner.
- 3.2.2 Spray two coats on all exposed surfaces to achieve a minimum dry film thickness of 0.009 inches per coat.
- 3.2.3 Air dry for 24 hours between each coat.
- 3.2.4 Final cure time is 3 days.

4.0 Product Selection

- 4.1 Primary Coat: Carboline – Carbo-Zinc 11; Color: Green
- 4.2 Top Coat: Carboline 890; Color: RAL 9005 Black
- 4.3 Thinner: Carboline Thinner #2
- 4.4 Clean up : Carboline Thinner #2

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CLEANING AND COATING PROCEDURE
 MARINE FINISH – 3 COATS
 20 MILS DFT

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