

## 1.0 Scope

- 1.1 This procedure defines the methods for cleaning and coating all Amarillo Gear Drives with a marine paint finish.

## 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

### 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 Coat

- 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 one coat on all exposed surfaces to achieve a minimum dry film thickness of .006 inches. A wet film thickness of 8 mils (no thinner) or 9 mils (10% thinner) is required to achieve the recommended dry film thickness.
- 3.2.3 Air dry for 24 hours.
- 3.2.4 Final cure time is 3 days.

## 4.0 Product Selection

- 4.1 Primary Coat: Carboline Carbo-Zinc 11 (Green).
- 4.2 Top Coat: Carboguard 890. Gray #703 (Pump Drives), RAL 9005 Black (Fan Drives). Other colors are available.
- 4.3 Thinner: Carboline Thinner #2
- 4.4 Clean up : Carboline Thinner #2

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### CLEANING AND COATING PROCEDURE MARINE FINISH

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