

# JOHN RUCK CONSTRUCTION LTD

FPC Procedure No.

**JRC P:18 v5**

FPC Procedure Title **Production - Painting**

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Approved and/or reviewed by K Clegg  
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Reviewed by:	Name: K Clegg	Date: 17/04/17	Name: K Clegg	Date: May 2018	Name: K Clegg	Date: April 2019
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## **Corrosion protection by protective paint systems to JRC default procedure.**

- P18.1 The shot blasted component is transferred to the paint trestles by overhead crane
- P18.2 Our default paint specification "Red Primathon Sheen" will be applied as per the suppliers paint technical data sheet supplied. If no other paint specification is indicated on the "Contract Review Sheet" (JRC R28) this will be the protective coating to be applied. Alternative paint specifications when indicated will be applied in accordance with the data sheets supplied by the paint manufacturer
- P18.3 If the contract states that steelwork is Galvanised, this will be carried out to BS EN 1461
- P18.4 Spray paint equipment will only be used by trained operators.
- P18.5 Each operator will be responsible for ensuring that maintenance checks P18.6 are undertaken before use. If faults are found and not readily resolved then the equipment must be isolated and the fault referred to the Workshop Foreman for resolution.
- P18.6 Before use: Visual inspection – check airflow extractors and spray guns.  
Check safety stickers and instruction sheet are in place.  
Check spray gun trigger safety latch.  
Check spray gun needle for wear.  
Check extractor filter medium.  
Check that extractor noise / vibration levels  
Check extractor fan units – especially for damage to impellor blades
- P18.7 Monthly: Check condition of extractor fan filters and replace if required
- P18.8 All operators must wear appropriate air fed spray mask and respirator when spraying. The mask must be correctly fitted according to manufacturer's instructions. Before use, each sprayer is responsible for checking their mask and respirator, as follows:  
Visual inspection – check there is no obvious damage and visor is clear.  
Check air flow  
Check face seal and forehead seal  
Check head harness, comfort pads and peel off covers  
Check that the 9100 Filter is clean and replace if required  
Visually inspect the air respirator, filter and breathing tube

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P18.9 Extraction unit and compressor are turned on & paint supply established with suction tube

P18.10 Exposed surfaces are sprayed and work rotated until all surfaces have 1 complete coat

P18.11 Deleted.

P18.12 Paint thickness is confirmed on every component. The paint will be at least 150 microns and tested using a wet thickness gauge. Dry thickness will consequently be at least 75 microns – see P18.8. Temperature and humidity of the area and the steel section temperature will be taken 4 times a day. Results will be recorded on JRC R:22

P18.13 The thickness gauge measuring equipment is self-calibrating and should be checked periodically with calibrated slip of known thickness.

P18.14 When all the steel has been painted, the record sheets will be filed in section 11 of the contract job file in the main office

P18.16 Painted items are moved to a designated dry storage area; where they are left until the next working day for the paint to fully dry.

P18.17 Painted/ fabricated steel is transferred to the Contract designated external storage area by the Yard Operative during the next working day and the dry thickness tested with a newly zeroed digital gauge and the reading recorded on JRC R:22. Minimum thickness must be 75 microns.