10-0072-1
EMORANDUM

	SUBJECT
Phillip Grossweiler	EXXON GALVESTON Newport News Shipbuilding - Proposed Paint Schedule-NNS Letter 10/26/77 - Attached.
OM	DATE / FILE NO.
G. R. Sturges	12/21/77

1. Total amount quoted by shipyard per attached letter and summary for external and internal areas totals $237,025.00. This figure to the writer's belief is excessively out of proportion in relation to the overall project. Material costs as indicated total $20,711.00, the balance of $216,314.00, labor cost. Total estimated man hours for this item total 15,448 man hours.

   It is necessary for EXXON Company U.S.A. to coat this vessel while in construction period, but suggest time and material contract be negotiated.

2. Surface preparation, which has loosely been defined in referenced correspondence under the term "clean" must be re-defined as follows; specification to read -

   a. All surfaces to be coated will be approved by owner's representative prior to application of coating sequence, 3 hour call out required (minimum).

   b. On interior areas, normal working lighting will be left and additional lighting provided at shipyard expense where owner's representative deems necessary. All lighting to be explosion proof during coating.

   c. Shipyard to provide adequate disposal bins on deck for removal of empty paint cans, rags and other used paint materials.

   d. On external areas, scaffolding must not be removed until coating has cured (12 hrs. @ 77°-50% RH) and been inspected and approved by owner's representative.

   e. On external areas, where by necessity scaffolding has been erected with the aid of welding lugs, all lugs, slag etc. are to be ground clean and I/O zinc applied prior to application of coating sequence of the surrounding area. (Minimum recoat internal 16 hours)

   f. All areas coated with I/O zinc will be allowed to cure 16 hrs. prior to overcoat sequence.

   g. All surfaces, external or internal, will be cleaned by water wash and degreased where necessary, degreaser to be thoroughly removed by wash down when required. Surface allowed to dry thoroughly and be free from crayon or chalk marks prior to application of coating sequence.

   h. On weather exposed areas, particularly, main weather deck, foscle deck, navigation deck, flying bridge deck, careful attention must be given to areas which have been damaged during construction period. In these areas, the possibility of the substrate coated with Inorganic zincs, may have been removed by traffic, damaged by oils, grease etc. These areas must be re-blasted and recoated. Careful attention given to all welds in these aforementioned areas.

i. Care must be taken to prevent damage by overspray to installed equipment, this is shipyard responsibility and all equipment of owner to be covered with adequate protective materials.

j. No exterior coating be applied during rain or upon steel which is condensating.

k. No material be applied when steel or atmospheric temperature is 32°F or below. No material be applied when RH is 85% or above.

l. Material (owner supplied) will not be thinned. If thinning should be required TH6860 be used.

m. Material to be applied in 3 coats allowing proper interval between coats. Inorganic zinc - 3.0 - 4.0 MDFT, - primer 1.0 - 2.0 MDFT, topcoat 1.5 - 2.0 MDFT. Minimum total 5.5 - maximum 8.0 MDFT.

n. Paint in containers should be kept from possible freezing temperatures in Newport News area.

o. Yard quality control inspector should be available for inspection with owner's representative.

p. No overtime without owner's approval and authorization allowed.

q. Labor force to be counted and total manpower figures per shift given to owner's representative by shift supervisor.

r. All finished and approved areas upon coating completion will be closed to traffic and minimal trafficking allowed.

s. All finished areas, subjected to construction damage, e.g. weld burns, fingerprints, markings, etc. to be repaired to owner's satisfaction at yard expense.

GRS/bt
Attachment

c: Mr. H. J. Borgen
Mr. T. J. Donovan
Mr. W. N. Ekstrand
Mr. H. P. Leyendecker
Mr. G. Libero
Files