PROCESS SPECIFICATION

APPLICATION OF ASBESTOS COMPOUND BY SPRAYING | 60-01-11

ISSUED 7/28/58 BY J.W. Dean

CHANGED 0/1/58 Sub 2

General

This specification covers the application of sprayed insulation on the inside surfaces of steam turbine laggings for the purpose of insulation and sound deadening.

Material

The material used for this process is as listed below:-

W.E. Material #4057-3.

Equipment

The equipment to be used is as listed below or its equivalent:-

Eclipse Air Brush Co. "46" Spray Gun with Cone Nozzle and 1/4" fluid tip Eclipse #7835 Pump, 4 to 1 ratio suitable hoses for carrying 60 psi atomizing pressure and 60 psi fluid pressure.

Operations

(1) Cleaning lagging
(2) Application of Primer Coat
(3) Application of Anchor Coating
(4) Application of Second Coating
(5) Application of Final Coating

It is recommended that the above operations be performed to the lagging while in the assembled condition.

(1) Cleaning Lagging

Remove all dirt, oil, grease, rust and other foreign matter from the metal surfaces to be coated. This operation to be accomplished by using mineral spirits or 6305-1, followed by wiping with a clean cloth.

Caution: Ventilation must be provided to avoid accumulation of vapors. Refer to Safe Practice Data Sheet T-4.

(2) Application of Primer Coat

Apply one (1) coat of primer 6449 -1 to all surfaces that will be sprayed with insulation #4057-3.

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(3) Application of Anchor Coat

Apply one coat of the compound by spraying to cover approximately 80% of the surface, i.e., 20% of the base metal will show through the insulating compound. The compound is applied by holding the spray gun approximately three feet from the lagging.

The surface will appear mottled. Air dry this coating for a minimum of one (1) hour.

Note;- The anchor coat should always be insulated with compound from a barrel that has not been previously opened. A previously opened and resealed drum may be used for later coats.

(4) Application of Second Coat

Spray on a heavy coating to a wet film thickness of 3/16 of an inch. This is to be applied by spraying with sufficient number of passes to build up to 3/16 of an inch and prevent any running or sagging of the compound.

Before the applied insulation has time to set up, separate the joints where the turbine lagging is to be disassembled using a parting tool. Air dry this coat for a minimum of two (2) hours.

(5) Application of Final Coat

Spray on a final coat to increase the final film thickness to 1/4 of an inch minimum. Separate the joints with the use of a parting tool before the insulation has time to set up. Air dry for a minimum of 24 hours.

Caution

The operator should wear an air-supply type respirator. Keep flames and sparks away from the insulation material. Refer to Safe Practice Data Sheet E-1.

The material is supplied in 30 gallon drums with clamped sealed tops. Always keep material sealed when not in use.

Order insulating compound for coverage of 4.5 square feet per gallon.

J. W. Desmond

J. W. Desmond, Mfg. Engineer
L.&M.T. Erection and Test

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