



ASPC Project




END CUSTOMER	: Arya Sasol Polymer Company
CONTRACTOR	: DYPNF Co., Ltd.
VENDOR NAME	: Airpack Netherlands BV
EQUIPMENT DESCRIPTION	: Screw Compressor & Roots Blower : Package
PURCHASE ORDER NUMBER	: PO-PC2312-08

Customer Document : 3944-VD-0171-DYP-RE-400-PRC-0128
Number

Airpack Document Number : 23383-18

Document Title : Painting Procedure

Review Code and Status		Contractor Initials/Signature	Date signed
<input type="checkbox"/>	Code 1 REJECTED - Vendor to revise and Resubmit. Work cannot proceed		
<input type="checkbox"/>	Code 2 Comments As Noted - Work May proceed, subject to compliance with and incorporation of comments		
<input checked="" type="checkbox"/>	Code 3 No Comments - Work may proceed.		27 May 2025
<input type="checkbox"/>	Code 4 Information only - Review not required.		

Rev. No.	Description	Date	Prepared by	Checked by	Approved by
00	Issued for Approval	07-03-2025	SC	KP	JJ

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1. References

Reference is made to the following documents.

Offer 23383-COM

2. General

Our paint system is based on brush/roller application. Painting will be done by Airpack painting specialists. As offered, Airpack equipment will be painted according to the paint schedule below.

3. Surface preparation

- All structures and equipment are designed and built-in accordance with ISO standards for high durability of the paint systems.
- All oil or grease shall be removed by washing the item to be painted with appropriate solvents or any other suitable means before beginning blast cleaning operations. This includes bolt holes in piping assemblies.
- Weld spatter and remains of temporary welds, deposits or surface defects shall be eliminated appropriately.
- Airpack shall protect all equipment that is not to be painted or liable to be affected by the presence of abrasives or paint. Special attention will be paid to avoid splashes of zinc paint on equipment made of austenitic steels.
- Surface preparation shall be inspected by Airpack Quality Control prior to application of paint.

4. Blast cleaning of carbon steel

All surfaces to be coated, will be blast-cleaned according to:

- the grade of cleanliness, SA 2.5
- the surface profile, to be evaluated using ISO 8503-2
- as painting is Airpack standard, no blast clean record is available.

After blast-cleaning, all dust must be removed using a vacuum cleaner before applying the paint. All blast-cleaned surfaces shall be coated before the deterioration of the "grade of cleanliness". In any case, any surface that has been blast-cleaned shall be coated on the same day.

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5. Paint Application

Coating system will be from paint manufacturer Jotun.

The products shall be delivered in their original sealed packaging and stored in such conditions as to avoid their degradation. The packaging shall be clearly marked with the product description, the batch number, the fabrication date and the expiration date. Paint shall always be applied to surfaces that are dry, clean and degreased, for both coating on substrate and previous coat.

Painting work shall not proceed if:

- Temperature of the substrate is less than 3°C above the dew point;
- The relative humidity is more than 85% RH (90% RH for inorganic zinc silicates);
- The weather is rainy or foggy, except under shelter, and subject to verification of the atmospheric conditions;
- The minimum or maximum temperature of the ambient atmosphere and the substrate are outside the limits given in the product data sheets.

Application shall be by brush/roller. Stripe coats shall be applied by brush to all angles, corners, and all the welds with the same product than this to be applied on the surface to be painted. Different colours shall be used for all successive coats of the paint system. The finishing coat of the required colour shall be opaque to cover the shade of the undercoat. The thickness of each coat, including frequency shall be checked by Airpack. The values will be recorded and made available.

6. Painting report

A paint report as attached (see attachment 1) will be provided with a final coating check during FAT. Dry film thickness will be checked using a calibrated Quanix Automation 1311669. Calibration certificate will be made available during FAT.

7. Paint systems

For a detailed overview of each item please refer to below paint schedule.

8. Repair procedure

In case a deviation or non-conformity has been found, this will be repaired as per below procedure. Where the coating has been scratched off, flaked, or in any other way damaged as to hamper its protective function, the coating will be grinded off 5 cm around the defect and paint will be re-applied to conform with the painting system defined in this painting procedure. In case more than 5% of the equipment surface is not conform specifications, the entire part will be blasted and re-coated. Where blasting is not feasible, paint will be grinded off until the bare metal, after which it is re-coated.

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Paint schedule

	MATERIAL	DESCRIPTION	SYSTEM	TDFT [μm]	FINAL COLOR
C1	Carbon Steel	STRUCTURAL STEEL	1	320	RAL-7000
C2	Carbon Steel	PRESSURE SAFETY VALVE	Mfr. std.	Mfr. std.	RAL-1016
C3	Stainless steel	LPS / JUNCTION BOX	Mfr. std.	Mfr. std.	RAL-7035
C4	Cast iron	ELECTRIC MOTOR	Mfr. std.	Mfr. std.	RAL-5010
C5	Galvanised steel	COMPRESSOR/BLOWER ENCLOSURE	Mfr. std.	Mfr. std.	RAL-5001/7047

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Paint system 1 (acc. ISO 12944-2 C5M-H table S7.04, & Jotun)

- Structural steel
- Surface preparation Sa 2½
- Temperatures up to 120°C

Layer	Type of paint	Make	DFT
1	epoxy mastic	Jotamastic Smart Pack	90 µm
2	epoxy mastic	Jotamastic Smart Pack	90 µm
3	epoxy mastic	Jotamastic Smart Pack	90 µm
4	Polyurethane	Hardtop XP	50 µm
		Total DFT	320 µm

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PAINT REPORT

Customer : ...
 Purchase order number : ...
 Equipment : ...
 Equipment item no. : ...
 Airpack ref. no. : 23383-COM
 Serial no. : ...
 Test location : Zierikzee
 Test date : ...

 Item : SKID
 Paint system : 1

MEASUREMENTS According to Attachment #1

EXAMPLE