



Casco Bay Steel Structures, Inc.
 One Wallace Avenue
 South Portland, Maine 04106
 Phone: 207.780.6722 Fax: 207.780.6726

Qualifications

1. Blast and paint operations shall be overseen and monitored by Casco Bay Steel Structures QC Manager in conjunction with Thomas Payeur (NACE Certified Coating Inspector Level 3) of New England Inspection, Inc.
2. Blasting Operators and Supervisors shall have a minimum of 1 year bridge experience
3. Coating Operators and Supervisors shall have a minimum of 1 year bridge experience
4. All equipment and operators shall be tested prior to the start of production

Steel Surface Requirements

1. Solvent cleaning shall be performed on bare steel in accordance with SSPC-SP1 using either M.E.K or water.
2. Steel shall be blast cleaned to near white metal grade per SSPC-SP10
3. All flame cut edges shall be ground with a disk wheel or similar to remove the hardened flame cut edge. Corners shall be rounded to a 1/16" radius
4. Blast profile shall be 1.5-3.5 mils minimum in accordance with the Project Special Provisions

3.0 max per manufacturer recommendations.

Paint Coating Application

1. Paint shall be applied per the coating manufacturer's recommendations
2. Prime coat shall be applied within 8 hours of completion of blasting
3. Paint system shall be as follows:
 - a. Prime Coat shall be Carboline Carbozinc 859 Organic Zinc (3.5-5 Mils Min DFT)
 - b. Intermediate Coat shall be Carboline Carboguard 893 Epoxy Red (3-6 Mils DFT)
 - c. Top Coat shall be Carboline Carbothane 133 VOC Aliphatic Polyurethane (3-4 Mils DFT)
 Exterior surfaces to be light dull gray, Federal Color No: 16440
 Interior surfaces to be insignia white, Federal Color No: 17925
4. Special Paint Areas:
 - a. Mist Coat only on the top of the top flange
 - b. Prime Paint only all faying surfaces

Inspection Hold Points

1. All work shall be inspected by QC and QA for conformance to project specifications
2. QA will be provided with adequate notice in advance of the hold points
3. Minimum production hold points shall be as follows:
 - a. Solvent cleaning
 - b. Surface Preparation
 - c. Surface Profile
 - d. Immediately following prime coat
 - e. Immediately following intermediate coat
 - f. Immediately following top coat
 - g. After completion of all coating applications (Final Inspection)

Vermont Agency of Transportation
RECEIVED
 CK'D BY TYLin OK'D BY TYLin
 March 24, 2017
 RESUBMIT No Approved AsNoted
 BY Kristin Higgins DATE 3/27/2017

T.Y. LIN INTERNATIONAL
 THE STAMPED DOCUMENTS ARE HEREBY:
 APPROVED
 APPROVED AS NOTED
 REVISE AND RESUBMIT
 SEE TRANSMITTAL FOR ADDITIONAL INFORMATION AS APPLICABLE.
 THIS REVIEW IS FOR GENERAL CONFORMANCE WITH DESIGN CONCEPT ONLY. ANY DEVIATION FROM THE PLANS OR SPECIFICATIONS NOT CLEARLY NOTED BY THE CONTRACTOR HAS NOT BEEN REVIEWED. REVIEW BY THE ENGINEER SHALL NOT RELIEVE THE CONTRACTOR OF THE CONTRACTUAL RESPONSIBILITY FOR ANY ERRORS OR DEVIATION FROM THE CONTRACT REQUIREMENTS.
 JOSH OLUND March 24, 2017
 REVIEWER DATE