

Designer Note: Insert into all projects requiring a moisture cured urethane paint system. Consult District Paint Inspector.

MOISTURE CURED URETHANE PAINT SYSTEM (BDE)

Effective: November 1, 2006

Revised: January 1, 2010

Add the following to Section 1008 of the Standard Specifications:

“1008.06 Moisture Cured Urethane Paint System. The moisture cured urethane paint system shall consist of an aromatic moisture cured urethane primer, an aromatic moisture cured urethane intermediate coat, and aliphatic moisture cured urethane finish coats. It is intended for field painting blast-cleaned existing structures.

(a) General Requirements.

- (1) Compatibility. Each coating in the system shall be supplied by the same paint manufacturer.
- (2) Toxicity. Each coating shall contain less than 0.01 percent lead in the dry film and no more than trace amounts of hexavalent chromium, cadmium, mercury or other toxic heavy metals.
- (3) Volatile Organics. The volatile organic compounds of each coating shall not exceed 2.8 lb/gal (340 g/L) as applied.

(b) Test Panel Preparation.

- (1) Substrate and Surface Preparation. Test panels shall be ASTM A 36, hot-rolled steel measuring 4 x 6 in. (100 x 150 mm). Panels shall be blast-cleaned per SSPC–SP5 white metal condition using recyclable metallic abrasive according to SSPC AB-3. The abrasive shall be a 60/40 mix of shot and grit. The shot shall be an SAE shot number S230 and the grit an SAE number G40. Hardness of the shot and grit shall be Rockwell C45. The anchor profile shall be 1.5-2.5 mils (40-65 microns) measured according to ASTM D 4417, Method C.
- (2) Application and Curing. All coatings shall be spray applied at the manufacturer's recommended film thickness. The coated panels shall be cured at least 30 days and not more than 45 days at 77 °F ± 2 °F (25 °C ± 2 °C) and 65 ± 5 percent relative humidity.
- (3) Scribing. The test panels shall be scribed according to ASTM D 1654 with a single “X” mark centered on the panel. The rectangular dimensions of the scribe shall have a top width of 2 in. (50 mm) and a height of 4 in. (100 mm). The scribe cut shall expose the steel substrate as verified with a microscope.

(4) Number of Panels. All testing shall be performed on triplicate panels.

(c) Zinc-Rich Primer Requirements.

(1) Generic Type. This material shall be a single component zinc-rich aromatic moisture cured urethane primer. It shall be suitable for topcoating with urethanes.

(2) Zinc Dust. The zinc dust pigment shall be according to ASTM D 520, Type II.

(3) Slip Coefficient. The organic zinc coating shall meet a Class B AASHTO slip coefficient (0.50 or greater) for structural steel joints using ASTM A 325 (A 325M) or A 490 (A 490M) bolts.

(4) Adhesion. The adhesion to an abrasively blasted steel substrate shall not be less than 900 psi (6.2 MPa) when tested according to ASTM D 4541 Annex A4.

(d) Intermediate Coat Requirements.

(1) Generic Type. This material shall be a single component aromatic moisture cured urethane. It shall be suitable as an intermediate coat over the primer and compatible with the finish coat.

(2) Color. The color of the intermediate coat shall provide a distinct contrast between the primer and the finish coat.

(e) Urethane Finish Coat Requirements.

(1) Generic Type. This material shall be a single component aliphatic moisture cured urethane. It shall be suitable as a topcoat over the intermediate coat.

(2) Color and Hiding Power. The finish coat shall match Munsell Glossy Color 7.5G 4/8 Interstate Green, 2.5YR 3/4 Reddish Brown, 10B 3/6 Blue, or 5B 7/1 Gray. The color difference shall not exceed 3.0 Hunter Delta E Units. Color difference shall be measured by instrumental comparison of the designated Munsell standard to a minimum dry film thickness of 3 mils (75 microns) of sample coating produced on a test panel according to ASTM D 823, Practice E, Hand-Held, Blade Film Application. Color measurements shall be determined on a spectrophotometer with 45 degrees circumferential/zero degrees geometry, illuminant C, and two degrees observer angle. The spectrophotometer shall measure the visible spectrum from 380-720 nanometers with a wavelength interval and spectral bandpass of 10 nanometers.

The contrast ratio of the finish coat at 3 mils (75 microns) dry film thickness shall not be less than 0.99 when tested according to ASTM D 2805.

(3) Accelerated Weathering Resistance. Test panels shall be aluminum alloy measuring 12 x 4 in. (300 x 100 mm) prepared according to ASTM D 1730 Type A, Method 1 Solvent Cleaning. A minimum dry film thickness of 3 mils (75 microns) of finish coat shall be applied to three test panels according to ASTM D 823, Practice E, Hand Held Blade Film Application. The coated panels shall be cured at

least 30 days and not more than 45 days at 77 °F ± 2 °F (25 °C ± 2 °C) and 65 ± 5 percent relative humidity. The panels shall be subjected to 300 hours of accelerated weathering using the light and water exposure apparatus (fluorescent UV - condensation type) as specified in ASTM G 53-96 and ASTM G 154 (equipped with UVB-313 lamps). The cycle shall consist of eight hours UV exposure at 140 °F (60 °C) followed by four hours of condensation at 104 °F (40 °C). After exposure, the panel shall be rinsed with clean water and allowed to dry at room temperature for one hour. The exposed panels shall not show a color change of more than 3 Hunter Delta E Units.

(f) Three Coat System Requirements.

- (1) Finish Coat Color. For testing purposes, the color of the finish coat shall match Federal Standard No 595, color chip 14062 (green).
- (2) Salt Fog. When tested according to ASTM B 117 and evaluated according to AASHTO R 31, the paint system shall exhibit no spontaneous delamination and not exceed the following acceptance levels after 5,000 hours of salt fog exposure.

Salt Fog Acceptance Criteria (max.)		
Blister Conversion Value	Rust Criteria	
After 4000 Hours	Maximum Creep	Average Creep
10	6 mm	2 mm

- (3) Cyclic Exposure. When tested according to ASTM D 5894 and evaluated according to AASHTO R 31, the paint system shall exhibit no spontaneous delamination and not exceed the following acceptance levels after 5,040 hours of cyclic exposure.

Cyclic Exposure Acceptance Criteria (max.)		
Blister Conversion Value	Rust Criteria	
	Maximum Creep	Average Creep
10	13 mm	7 mm

- (4) Adhesion. The adhesion to an abrasively blasted steel substrate shall not be less than 900 psi (6.2 MPa) when tested according to ASTM D 4541 Annex A4.
 - (5) Freeze Thaw Stability. There shall be no reduction of adhesion, which exceeds the test precision, after 30 days of freeze/thaw/immersion testing. One 24 hour cycle shall consist of 16 hours of approximately -22 °F (-30 °C) followed by four hours of thawing at 122 °F (50 °C) and four hours tap water immersion at 77 °F (25 °C). The test panels shall remain in the freezer mode on weekends and holidays.
- (g) Qualification Samples and Tests. The manufacturer shall supply, to an independent test laboratory and to the Department, samples of the moisture cured zinc-rich urethane primer, moisture cured urethane intermediate coat, and moisture cured aliphatic urethane finish coats for evaluation. Prior to approval and use, the manufacturer shall submit a notarized certification of the independent laboratory, together with results of all tests, stating that these materials meet the requirements as set forth herein. The certified test report shall state lots tested, manufacturer's name, product names, and dates of manufacture. New certified test results and samples for testing by the

Department shall be submitted any time the manufacturing process or paint formulation is changed. All costs of testing, other than tests conducted by the Department, shall be borne by the manufacturer.

- (h) Acceptance Samples and Certification. A 1 qt (1 L) sample of each lot of paint produced for use on state or local agency projects shall be submitted to the Department for testing, together with a manufacturer's certification. The certification shall state that the formulation for the lot represented is essentially identical to that used for qualification testing. All acceptance samples shall be witnessed by a representative of the Illinois Department of Transportation. The moisture cured zinc-rich primer, moisture cured urethane intermediate coat, and moisture cured aliphatic urethane finish coat shall not be used until tests are completed and they have met the requirements as set forth herein."