


	20000m3 FUEL OIL STEEL STORAGE TANK			Vendor:  MACHINE SAZI PARS CO. (MSP)
	Painting Procedure			
	Vendor Doc No: VD-ST-PR-005		Rev.: 01	
	Client Doc No. :- -----			

ITEM NO. : **Painting Procedure**

TOTAL Sheets : **6** (Excluding Attachments)

<input type="checkbox"/>	NO COMMENT: Documents/ Drawings Were Checked By Purchaser And Further Steps Can Be Followed.									
<input type="checkbox"/>	COMMENTS AS MARKED: Documents/Drawings Were Checked By Purchaser And Marked Comments Must Be Considered By Vendor. Vendor Shall Revise Documents/ Drawings As Per Comments And The New Revision Of Documents/ Drawings Must Be Reissued Prior To Fabrication.									
<input type="checkbox"/>	REJECTED: Documents/ Drawings Were Checked And It Is Not Comply With Purchase Order Requirements At All.									
<input type="checkbox"/>	ACCEPTABLE WITH COMMENTS: Documents/Drawings Were Checked By Purchaser And Comments Must Be Considered By Vendor. Fabrication Can Proceed Accordingly. Revised Document To Be Issued Either For Review Or As Final Certified. However Purchaser Will Check The Revised Document For Proper Incorporation Of Comments.									
<input type="checkbox"/>	NOT RETURNED: Document Was Received For Information And Not Returned To The Vendor.									
<table border="1" style="width: 100%;"> <tr> <td style="width: 33%;">Name :</td> <td style="width: 33%;">Req. No.:</td> <td style="width: 33%;">Seq. No.:</td> </tr> <tr> <td>Signature :</td> <td></td> <td></td> </tr> <tr> <td>Date:</td> <td></td> <td></td> </tr> </table>		Name :	Req. No.:	Seq. No.:	Signature :			Date:		
Name :	Req. No.:	Seq. No.:								
Signature :										
Date:										
Purchaser review & comments does not absolve the vendor of the responsibility for the correct design, manufacturing and operation of the equipment										

D01	Issue for Approval	M.B	E.SHAKOURI	M.TAVSOLI FAR	M.Ghaleie	06.Jan.2026
D00	Issue for Comment	M.B	M.GH	M.A.SH	M.Ghaleie	02.Nov.2025
Rev.	DESCRIPTION	Pre.	Checked	Approved	AUTHD	Date

			20000m3 FUEL OIL STEEL STORAGE TANK		Vendor:  MACHINE SAZI PARS CO. (MSP)
			Painting Procedure		
			Vendor Doc No: VD-ST-PR-003	Rev.: 01	
			Client Doc No. :-----		

Revision Index													
Sheet	Revision						Sheet	Revision					
	D00	D01	D02	D03	D04	D05		D00	D01	D02	D03	D04	D05
1	X						31						
2	X	X					32						
3	X	X					33						
4	X	X					34						
5	X	X					35						
6	X	X					36						
7	X	X					37						
8							38						
9							39						
10							40						
11							41						
12							42						
13							43						
14							44						
15							45						
16							46						
17							47						
18							48						
19							49						
20							50						
21							51						
22							52						
23							53						
24							54						
25							55						
26							56						
27							57						
28							58						
29							59						
30							60						





	20000m3 FUEL OIL STEEL STORAGE TANK		Vendor:  MACHINE SAZI PARS CO. (MSP)
	Painting Procedure		
	Vendor Doc No: VD-ST-PR-003	Rev.: 01	
	Client Doc No. :-		

Table of Contents

1.	SCOPE	4
2.	INTERNATIONAL STANDARD, CODE AND GUIDLINE	4
3.	EXECUTION OF WORK	4
4.	HANDLING OF COATED ITMES	6
5.	EQUIPMENT	6
6.	ENVIRONMENTAL CONDITION	6
7.	INSPECTION	6
8.	REMEDIAL WORK.....	7
9.	PAINTING SCHEDULE	7

	20000m3 FUEL OIL STEEL STORAGE TANK		Vendor:  MACHINE SAZI PARS CO. (MSP)
	Painting Procedure		
	Vendor Doc No: VD-ST-PR-003	Rev.: 01	
	Client Doc No. :- -----		

1. Scope

This procedure covers the surface preparation, methods of application and painting material to be used for 20-Tk-02.

2. International Standard, Code and Guidelines



- API 650 - 14th. Ed. AUG.2025
- SSPC-SP1-Solvent Cleaning
- SSPC-SP-COM-Surface Preparation Commentary for Steel and Concrete Substrates
- SSPC SP-11-Surface Preparation Standard No. 11
- ISO 8502-3 Assessment of dust on steel surfaces prepared for painting (pressure sensitive tape method)
- DIN 55928, Part 7 -Corrosion protection of steel structures by organic and metallic coatings; test areas
- ASTM E 337-Standard Test Method for Measuring Humidity with a Psychrometer (the Measurement of Wet- and Dry-Bulb Temperatures)
- SSPC-Vis 1-89 Surface comparison images according to SSPC-VIS 1-89 Blast cleaning
- ASTM D 4417 Standard Test Methods for Field Measurement of Surface Profile of Blast Cleaned Steel

3. Execution of Work

3.1 With reference to 20-Tk-02, the following surfaces and materials shall not be painted:

- Galvanized surfaces except where safety or color marking is required.
- The following parts of carbon steel and low-alloy steel surfaces:
 - Surfaces which should obviously not be painted (e.g., nameplates, mechanically finished surfaces, etc.).
 - Bolt/Nuts for location to be frequently removed, such as manholes, inspection holes etc.

3.2 Shop painting

- All flange faces and other machined surfaces shall be kept free of paint.

3.3 Surface preparation



- Mill scale, rust-scale and foreign material shall be removed by commercial blast cleaning or tool cleaning.

	20000m3 FUEL OIL STEEL STORAGE TANK		Vendor:
	Painting Procedure		
	Vendor Doc No: VD-ST-PR-003	Rev.: 01	
	Client Doc No. :-----		

- Surface preparation shall be thoroughly cleaned prior to painting in accordance with applicable SSPC or SIS Manual.
- Prior to the start of work, the vendor/painting contractor shall examine all surfaces to be coated to determine their acceptability for the specified work. If the surfaces are found to be unacceptable, the vendor/ painting contractor shall either return the surface to an acceptable condition or immediately notify the contractor in writing if the repairs are outside the scope of work. Work shall not commence until corrective action has been taken. Commencement of work prior to the taking of corrective action shall preclude any subsequent claim by the vendor. The Contractor may require corrective action at the vendor/painting Contractor's expense.
- Selection of abrasive for blast cleaning shall be in accordance with the recommendations given in SSPC-SP-COM and the recommendations agreed with the individual paint manufacturer for each type of paint used. Generally, this shall give a surface profile within the range mentioned in article 6.3.2 SSPC-SP-COM with maximum peak amplitude of 100 microns. Spent abrasives shall be completely removed from the prepared surface by either vacuum cleaning, air spray or stiff brushing. For inorganic zinc primed surfaces, the abrasive shall be hard sharp and angular and for this reason, shot shall not be acceptable. The surface profile shall be checked in conjunction with an approved roughness comparator.

3.4 General requirements

- Painting shall be applied by the spray method except for special cases such as repair and touch-up.
- Prior to application, paints shall be well agitated to give uniform mixing.
- Where thinner is used to thinning the paints, its volume shall be limited to the extent specified by paint manufacture's standards.
- The primer coat of paint shall be applied immediately after visual inspection of surface preparation.
- Subsequent coating of paint shall be made after checking against the dryness of previous paint films. Any defects, uncoated portion, deposits, etc., shall also be pre-checked and completely repaired.
- In the following cases, repair painting shall be done.
 - a. When there are development of any detrimental film irregularity, such as lifting or loose of adhesion of the coat due to change of weather before dried.
 - b. When there are development of any detrimental film irregularity, such as loose, cracked, brittle or non-adherent paint or dis-coloration during 2 or 3 days after completion of painting.

	20000m3 FUEL OIL STEEL STORAGE TANK		Vendor:  MACHINE SAZI PARS CO. (MSP)
	Painting Procedure		
	Vendor Doc No: VD-ST-PR-003	Rev.: 01	
	Client Doc No. :- -----		

c. Other unacceptable cases

All repair and touch up activities shall be performed according to the approved paint manufacturer's instruction.

4. Handling of coated items



Coated items shall be protected on non-abrasive supports during storage and shipment. Coated surfaces shall be protected from damage during lifting, handling, and shipment.

5. Equipment



The vendor /painting contractor shall provide equipment capable of regulating and controlling the specified environmental conditions within the work area to perform the work according to the production schedule.

Application equipment shall be equivalent to the equipment recommended by the coating's manufacturer and shall be suitable to apply the coating as specified.

Equipment air supply lines shall be equipped with fillers/traps to remove moisture and oil as close to the point of use as possible.

6. Environmental Condition

No painting operation shall be done in the following weather conditions on the work area:

- Rain, snow, fog or when such conditions are likely to occur before the paint has become dry.
- Dust effects adversely due to high wind.
- Ambient temperature is below 5°C.
- Relative humidity is greater than 85%.
- When the metal surface temperature is less than 3°C above the ambient dew point or above the manufacturer's limit.
- Painting shall not be carried out outside daylight hours on exterior locations. Painting may also be suspended due to dusty conditions.

7. Inspection


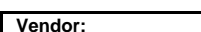


7.1 The dry film thickness shall be verified in accordance with SSPC-PA 2.

7.2 The coating shall be visually inspected for defects such as overspray, runs, sags, voids, blistering, peeling, rusting, mud cracking, inadequate cure, and lack of adhesion. Mud cracking must be removed by reblasting. Areas where defective coatings have been repaired or replaced shall be reinspected to the original requirements.

7.3 After completion of finish coat, thickness of dry film shall be checked by thickness gauge.

7.4 After completion of finish coat, appearance of painting shall be visually checked.

	20000m3 FUEL OIL STEEL STORAGE TANK		Vendor:  MACHINE SAZI PARS CO. (MSP)
	Painting Procedure		
	Vendor Doc No: VD-ST-PR-003	Rev.: 01	
	Client Doc No. : -----		

7.5 All required inspections shall be performed as per Paint Specification.

8. Remedial Work



Coated surfaces that are damaged during assembly, handling, or shipment shall be repaired in accordance with procedures accepted by the contractor

The surface profile shall be restored to meet the specified surface preparation requirements for cleanliness and profile. The periphery of a damaged area shall be feathered prior to coating application.

Precautions shall be taken to protect adjacent coated areas from damage caused by local abrasive blasting. The use of vacuum blast type equipment will be permitted for abrasive blast cleaning.

Power tool cleaning shall be done per the requirements of SSPC-SP 11.

9. Painting Schedule



Exterior Surfaces : Shell & Roof Plate

System	Min. Surface preparation	Primer Coat	DFT (Min)	Intermediate Coat	DFT (Min)	Finish Coat	DFT (Min)	Required Total DFT(Min)	Finish Color
A	Sa 2 1/2	Inorganic Zinc Primer	25µm	Surface Tolerant Epoxy	250µm	-	-	275 µm	RAL 9010

Note: Insulation will be applied on the specified coats according to the insulation drawing.

Exterior Surfaces : Bottom Plate (Soil Side)

System	Min. Surface preparation	Primer Coat	DFT (Min)	Intermediate Coat	DFT (Min)	Finish Coat	DFT (Min)	Required Total DFT(Min)	Finish Color
B	Sa 2 1/2	Coal tar epoxy OR bituminous epoxy	400-500 µm	-	-	-	-	400-500 µm	-

Exterior Surfaces : Stairway & Handrail

System	Min. Surface preparation	Primer Coat	DFT (Min)	Intermediate Coat	DFT (Min)	Finish Coat	DFT (Min)	Required Total DFT(Min)	Finish Color
C	Sa 2 1/2	Inorganic Zinc Primer	75µm	High Build Epoxy Polyamide	75µm	Aliphatic Polyurethane	50µm	200 µm	RAL 9005

Interior Surfaces

System	Min. Surface preparation	Primer Coat	DFT (Min)	Intermediate Coat	DFT (Min)	Finish Coat	DFT (Min)	Required Total DFT(Min)	Finish Color
--------	--------------------------	-------------	-----------	-------------------	-----------	-------------	-----------	-------------------------	--------------

Not Applicable