

WILKO PAINT, Inc.

WICHITA, KANSAS 67204-0089

MANUFACTURERS OF THE FINEST INDUSTRIAL FINISHES

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SUMMARY OF SURFACE PREPARATION SPECIFICATIONS

SSPC	NACE	Description	Summary
SP 1		Solvent Cleaning	Removal of oil, grease, dirt, soil, salts, and contaminants by cleaning with solvent, vapor, alkali, emulsion, or steam.
SP 2		Hand Tool Cleaning	Removal of loose rust, loose mill scale, and loose paint to degree specified, by hand chipping, scraping, sanding, and wire brushing.
SP 3	#3	Power Tool Cleaning	Removal of loose rust, loose mill scale, and loose paint to degree specified, by power tool chipping, descaling, sanding, wire brushing, and grinding.
SP 5	#1	White Metal Blast Cleaning	Removal of all visible rust, mill scale, paint, and foreign matter by blast cleaning by wheel or nozzle (dry or wet) using sand, grit, or shot. (For very corrosive atmospheres where high cost of cleaning is warranted.)
SP 6		Commercial Blast Cleaning	Blast cleaning until at least two-thirds of the surface area is free' of all visible residues. (For rather severe conditions of exposure.)
SP 7	#4	Brush-Off Blast Cleaning	Blast cleaning of all except tightly adhering residues of mill scale, rust, and coatings, exposing numerous evenly distributed flecks of underlying metal.
SP 8		Pickling	Complete removal of rust and mill scale by acid pickling, duplex pickling, or electrolytic pickling.
SP 10	#2	Near-White Blast Cleaning	Blast cleaning nearly to White Metal cleanliness, until at least 95% of the surface area is free of all visible residues. (For high humidity, chemical atmosphere, marine, or other corrosive environments.)
SP-11-87T		Power Tool Cleaning to Bare Metal	Complete removal of all rust, scale, and paint by power tools, with resultant surface profile.
Vis 1-89		Visual Standard for Abrasive Blast Cleaned Steel	Standard reference photographs; optional supplement to SSPC Surface Preparation Specification SSPC-SP 5, 6, 7, and 10
Vis 2		Standard Method of Evaluating Degree of Rusting on Painted Steel Surfaces	A geometric numerical scale for evaluating degree of rusting of painted steel. Illustrated by color photographs and black and white dot diagrams.

More information on these specs can be found at the following websites:

SSPC: <http://www.sspc.org/>

NACE: <http://www.nace.org/>