



TECHNICAL SERVICE REPORT

OWNER: Equipment Test **INTERNATIONAL REP:** P. Bock;
Attn: Mr. Kristian Dalseide **DATE:** 10/07/2003
APPLICATOR: International Paint Company Houston TX test lab
EQUIPT. DESCR: Carbon Steel Piping, previously coated with Epoxy
LOC: International Paint Company Houston TX spray test lab
SURFACE PREP: "Rustibus" surface preparation machine for straight-run piping
COATING SYSTEM: Interseal 670HS Surface Tolerant Epoxy

OBSERVATIONS: On April 1, 2003 Mr. Kristian Dalseide of Dalseide Shipping, manufacturers of the "Rustibus" surface preparation machine for straight-run piping, did a demonstration of the machine's capabilities at International Paint Company's Houston TX test lab. During the demonstration, the machine effectively removed old coating from straight line pipe as claimed by the manufacturer.

After completion of the demonstration, portions of the pipe prepared using the "Rustibus" surface preparation machine were coated with International Interseal 670HS Surface Tolerant Epoxy. Preparation of the areas to be coated did not reach SSPC SP11, in that old coating was removed and the prepared surfaces were bright steel, but instead of a sharp, angular profile, there was an undulating striation profile with the maximum profile height running about 0.5 mil. International Paint Technical Service Manager Mr. Joe Miller commented that Interseal 670HS was applied over poorer surface preparation every day, so the test application was definitely valid.

Interseal 670HS was spray applied to the prepared pipe, and the pipe was left outside the south side of the manufacturing facility. After six months weathering, International spray test lab technician Bob Bryant attached "patty" type adhesion test dollies with curved machined faces to the Interseal 670HS coated sections of the test pipe. The adhesive was allowed to dry, and adhesion pull tests were done. Attached photos show the results. Note that the adhesive used is dark gray in color.

Dolly 1:	1871 lbs	Part Glue Failure, part midcoat cohesion failure
Dolly 2:	2359 lbs	Glue Failure
Dolly 3:	2196 lbs	Part Glue Failure, part midcoat cohesion failure
Dolly 4:	Mis-pull,	no reading registered

Photos "Rustibus" B, C and D show the pipe area tested and the pulled dollies. For comparison, Photo A shows an uncoated area of pipe, which had been partly prepared with the "Rustibus" machine. The surface preparation texture and striation are clearly visible. On areas coated for the test, all old (light gray) epoxy was removed to bare steel before application of the buff Interseal 670HS.

Based on this test, International Paint Company recommends use of the "Rustibus" surface preparation machine for straight-run piping where the resulting level of surface preparation is acceptable to the owner or specification writer, and where the prepared surface is to be overcoated with Interseal 670HS or a similar surface tolerant epoxy. The "Rustibus" surface preparation machine performs as advertised by its manufacturer.

Peter P. Bock
International Paint Company
attn.: Photos
Headquarters Technical Support
Rustibus A, B, C, D
Protective Coatings
Houston, TX USA
Cel phone: 713-542-3968

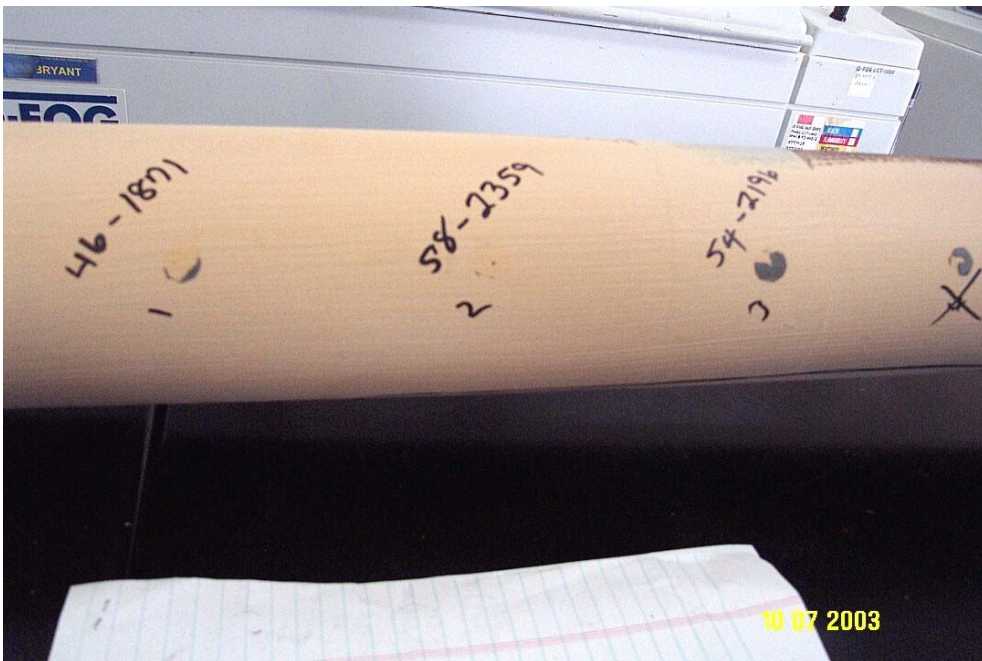
 **International**

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A



B



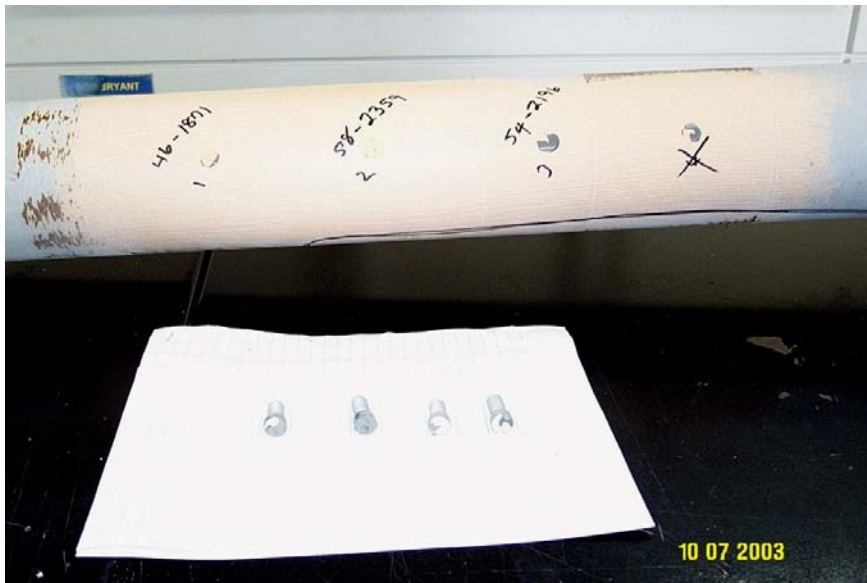
X International

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C



D



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