



CLOCK SPRING®

Application Note NACE #3 Finish

To ensure a good bond, Clock Spring Company L.P. recommends a NACE #3, or equivalent finish on the pipe surface being repaired with Clock Spring®.

NACE #3 is defined as follows:

Commercial Blast Cleaning - Removal of mill scale, rust, rust scale, paint or foreign matter by the use of abrasives propelled through nozzles or by centrifugal wheels, to the degree specified. A Commercial Blast Cleaned Surface Finish is defined as one from which all oil, grease, dirt, rust scale and foreign matter have been completely removed from the surface and all rust, mill scale and old paint have been completely removed except for slight shadows, streaks, or discolorations caused by rust stain, mill scale oxides or slight, tight residues of paint or coating that may remain; if the surface is pitted, slight residues of rust or paint may be found in the bottom of pits; at least two-thirds of each square inch of surface area shall be free of all visible residues and the remainder shall be limited to the light discoloration, slight staining or tight residues mentioned above.

Equivalent Power Tool Cleaning:

SSPC-SP-3 (Steel Structures Painting Council) - St 3 (Swedish Standards)

Power Tool Cleaning - Removal of all rust scale, mill scale, loose paint, and loose rust to the degree specified by power wire brushes, power impact tools, power grinders, power sanders or by a combination of these methods. The substrate should have a pronounced metallic sheen and be free of oil, grease, dirt, soil, salts and other contaminants. Surface should not be buffed or polished smooth.

Simply the smartest pipeline repair decision you can make!

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