East Coast Refinishing & Surface Stripping, Inc. Quality Manual – Industrial Blasting & Coating Operations

1. Quality Policy

East Coast Refinishing is committed to providing high-quality abrasive blasting and industrial coating services that meet customer specifications and industry standards. Our objective is to ensure that all work performed in our facility meets or exceeds the requirements of project specifications, coating manufacturer recommendations, and applicable surface preparation standards. Quality is achieved through trained personnel, documented procedures, controlled surface preparation, coating inspection and verification, and continuous improvement of shop processes.

2. Scope

This quality manual applies to abrasive blasting, surface preparation, industrial coating application, handling and storage of coated steel, and inspection and verification of coating systems performed at the East Coast Refinishing facility.

3. Facility & Controlled Work Environment

All blasting and coating operations are performed indoors in a controlled shop environment to ensure consistent quality and environmental control. East Coast Refinishing operates enclosed blasting and painting areas that allow proper containment of blasting media, controlled coating application, and proper curing of coatings in accordance with manufacturer recommendations.

4. Facility Equipment

- Two enclosed abrasive blast booths used for controlled surface preparation
- One 40 foot industrial paint booth
- One 30 foot industrial paint booth with baking capabilities

5. Equipment & Capabilities

- Rotary screw compressors with conditioned air supply
- Abrasive blasting equipment and media recovery systems
- Airless spray equipment for industrial coatings
- Dry film thickness gauges for coating inspection
- Rigging and material handling equipment for fabricated steel and assemblies

6. Applicable Standards

- AMPP / SSPC Surface Preparation Standards
- SSPC-SP6 Commercial Blast Cleaning
- SSPC-SP10 Near White Blast Cleaning
- SSPC-SP16 Sweep Blasting of Galvanized Steel
- Manufacturer coating specifications
- Project-specific coating requirements when provided by the client

7. Organization & Responsibilities

Operations Manager – Responsible for scheduling, production oversight, and quality compliance. Coating Supervisor – Responsible for surface preparation verification, coating application procedures, and environmental monitoring. Technicians – Responsible for performing blasting and coating operations, following established procedures, and reporting issues or deviations.

8. Surface Preparation Methods

- Abrasive blasting
- Sweep blasting of galvanized surfaces
- Mechanical cleaning when specified

9. Surface Preparation Inspection

Inspection includes visual verification of cleanliness, surface profile verification, and removal of contaminants prior to coating. Surfaces are inspected to ensure compliance with the specified surface preparation standard before coating application begins.

10. Coating Application

Coatings are applied according to manufacturer technical data sheets, project specifications, and recommended film thickness requirements. Typical coating systems include epoxy primers, zinc-rich primers, alkyd shop primers, polyurethane topcoats, and high-build epoxy systems.

11. Environmental Monitoring

- Surface temperature
- Ambient temperature
- Relative humidity
- Dew point

12. Inspection Procedures

Inspection is performed throughout the process including verification of surface cleanliness, coating coverage, and dry film thickness measurements when required. Inspection information may be recorded using internal inspection forms.

13. Inspection Tool Verification

Inspection tools such as dry film thickness gauges are checked against reference shims prior to use to ensure accurate readings when measuring coating thickness.

14. Documentation & SDS Information

Project documentation may include job travelers, inspection forms, coating batch information, environmental conditions, and film thickness records. Safety Data Sheets (SDS) for coating materials and related products are maintained by East Coast Refinishing and can be provided to customers upon request.

15. Handling & Storage

After coating application materials are allowed to cure properly and are handled carefully to prevent coating damage. Materials are staged within the facility and inspected prior to shipment. Any damaged areas are repaired before delivery.

16. Continuous Improvement

East Coast Refinishing periodically reviews work procedures, production processes, and customer feedback to improve quality, efficiency, and customer satisfaction.