

[CompanyName]

Painting and Coatings Contractor

Supplemental Procedures, Inspection & Test Plan,
and Inspection Checklists

[ProjectName]

[ProjectNumber]

Management acceptance

These Project-specific Procedures, Inspection & Test Plan, and Inspection Checklists have been reviewed and accepted.

Endorsed By: (Name / Title)	[QualityManagerName], Quality Manager		
Signature:	<i>[QualityManagerName]</i>	Date:	[Date]
Version	1.0	Notes	Initial Issue

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QC ITP, Procedures, and Inspection Checklists

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Inspection and Test Plan and Log		
Project Number	Project Name	
[ProjectNumber]	[ProjectName]	

Item	Specification Section	Applicable Standard	Inspection & Test Description	Test and Inspection Method	Frequency	Acceptance Criteria	Inspection/Test By	Unique QC Notes
1	Surface Preparation	AMPP SP 1	Surface cleanliness verification	Visual inspection	Prior to coating application	No visible contamination	QC Inspector	Record visual conditions
2	Surface Preparation	AMPP SP 10	Near-White Metal Blast Cleaning	Visual inspection with comparator (AMPP VIS 1)	Each prepared area	Per AMPP SP 10	QC Inspector	Reference visual standards
3	Surface Preparation	ASTM D4417	Surface profile measurement	Replica tape or profile gauge	Each prepared area	2-4 mils	QC Inspector	Record measurements

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7	Coating Application	AMPP Guide 11	Stripe coating verification	Visual inspection	Each applicable location	Complete coverage on edges, welds, bolts	QC Inspector	Record locations inspected
8	Coating Application	AMPP PA 2	Dry film thickness measurement	Magnetic DFT gauge	Specified intervals	Meets specified DFT range	QC Inspector	Record DFT readings
9	Coating Application	ASTM D4541	Pull-off adhesion test	Portable adhesion tester	As specified in ITP	Minimum adhesion per project specifications	QC Inspector	Record adhesion values

Item	Specification Section	Applicable Standard	Inspection & Test Description	Test and Inspection Method	Frequency	Acceptance Criteria	Inspection/Test By	Unique QC Notes
10	Coating Application	ASTM D5162	Holiday testing (continuity testing)	Low voltage wet sponge/high voltage spark testing	As specified in ITP	No holidays detected	QC Inspector	Document findings and repairs
11	Environmental Conditions	Project Spec.	Ambient temperature verification	Digital thermometer	Every 4 hours during coating	Within project specification limits	QC Inspector	Record temperature readings

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14	Equipment Calibration	Project Spec.	Inspection equipment calibration verification	Calibration records check	Monthly	Calibration current and equipment functional	QC Supervisor	Document calibration status
15	Final Inspection	AMPP VIS 1	Final coating visual inspection	Visual inspection	Project completion	Free from defects (runs, sags, pinholes, holidays)	QC Supervisor	Final visual verification

Verification of Work Task Completion (sign and date)

QC Supervisor Signature:	Date:
Quality Manager Signature:	Date:
Project Manager Signature:	Date:
* On behalf of the contractor, I certify that this enhanced Inspection and Test Plan is complete, aligned with the latest AMPP standards, and suitable for use in monitoring and verifying compliance with project specifications.	

SURFACE PREPARATION PROCEDURE

Procedure Number: CP-QC-302

Revision Number: 1.0

Effective Date: [Insert Date]

Approved by: [QualityManagerName], Quality Manager

Purpose

To define and standardize surface preparation procedures to ensure proper adhesion and performance of coating systems, aligning with customer specifications, AMPP standards, and industry best practices..

Scope

This procedure covers surface preparation methods, inspections, and acceptance criteria for field- and shop-applied above-ground coatings and below-ground coatings. It applies to abrasive blasting, power tool cleaning, hand tool cleaning, waterjetting, and surface cleanliness evaluations.

Referenced Standards

- AMPP SP 1 – Solvent Cleaning
- AMPP SP 2 – Hand Tool Cleaning
- AMPP SP 3 – Power Tool Cleaning
- AMPP SP 10 – Near-White Metal Blast Cleaning (formerly SSPC-SP 10/NACE No.2)
- AMPP SP 6 – Commercial Blast Cleaning (formerly SSPC-SP 6/NACE No.3)
- AMPP SP 7 – Brush-Off Blast Cleaning (formerly SSPC-SP 7/NACE No.4)
- ASTM D4417 – Field Measurement of Surface Profile of Blast Cleaned Steel
- ISO 8502-3 – Assessment of Dust on Steel Surfaces Prepared for Painting (Pressure-Sensitive Tape Method)
- ASTM D4285 – Test Method for Indicating Oil or Water in Compressed Air
- Manufacturer's Data Sheets (MDS).

Definitions

- Surface Profile: Measurement of surface roughness after surface preparation.
- Near-White Metal Blast Cleaning (AMPP SP 10): A very thorough cleaning by abrasive blasting, removing all contaminants except for minimal, tightly adherent residues.
- Commercial Blast Cleaning (AMPP SP 6): Thorough abrasive cleaning removing all contaminants, visible rust, and mill scale, except minor staining.
- Flash Rust: Rapid corrosion occurring after blasting and prior to coating.

Responsibilities

- Quality Manager: Ensures procedure compliance, reviews inspection reports, and manages nonconformances.
- Quality Control Supervisor (QCS): Oversees day-to-day inspections, verifies inspection accuracy, and manages corrective actions.
- Inspectors: Conduct detailed inspections, document findings, and report nonconformances.

- Superintendent: Manages site activities, coordinates inspections, and ensures adherence to procedures.

Equipment and Materials

- Abrasive blasting equipment
- Power tools (grinders, needle guns, pneumatic tools)
- Profile measurement instruments (replica tape, stylus gauges)
- Compressed air quality testing equipment (blotter test materials)
- Personal protective equipment (PPE)]
- Verify ambient and surface temperature (>5°F above dew point).
- Confirm adequate environmental conditions (temperature, humidity, wind).
- Ensure surface is free from visible contaminants (oils, grease, dirt).

7.2 Abrasive Blast Cleaning

- Select abrasive media per contract specifications and MDS.
- Perform abrasive blasting according to AMPP SP 10 (Near White) or AMPP SP 6 (Commercial) standards.

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- Record results and immediately rectify any contaminants.

7.5 Post-Surface Preparation Inspection

- Inspect surfaces immediately after preparation to prevent flash rust.
- Document any deviations from specifications.
- If flash rust is observed, re-clean the area immediately.

8. Acceptance Criteria

- Surface cleanliness as per AMPP SP 10 or AMPP SP 6.
- Surface profile range as specified (typically 2-4 mils).
- No visible contaminants or moisture on surfaces prior to coating.
- Compressed air cleanliness compliant with ASTM D4285.
- Dust level rating Quantity Rating 2 or better (ISO 8502-3).

9. Nonconformance Management

- Document all nonconformances immediately.
- Tag and isolate nonconforming surfaces.
- Implement corrective actions, re-inspect, and document resolution.

10. Training and Qualifications

- Inspectors require AMPP PCI Level 1 or NACE CIP Level 1 certification.
- Abrasive blasting personnel must be trained per AMPP standards.
- All personnel receive annual training refreshers on surface preparation methods and inspection procedures.

11. Documentation and Recordkeeping

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- regulatory changes.
- Regularly communicate procedure updates to all project personnel.

Quality Controlled Work Task List			
Project ID	Project Name	Preparer	Date
[ProjectNumber]	[ProjectName]		

Project Work Tasks / Contract Section	Quality Controlled work task	Method for identification of Approved Inspection Status
	Surface Preparation	Surface Preparation Checklist
	Coating Application	Coating Application Checklist
	Holiday Testing	Holiday Testing Checklist
	Environmental Conditions Monitoring	Environmental Conditions Monitoring Checklist

Coating Application Inspection Checklist

Project: Id#	Project Name:	Coating Application Method:			
[ProjectNumber]	[ProjectName]	<input type="checkbox"/> Spray Application <input type="checkbox"/> Brush Application		<input type="checkbox"/> Roller Application <input type="checkbox"/> Stripe Coating Application	
Checkpoints/Inspection Items	Acceptance Criteria	Standards	Measurements	Pass	Fail
Coating materials verified (batch number, expiry)	Materials match approved submittals	Project Specifications			
Equipment inspection and cleanliness verification	Equipment clean and operational	Project Specifications			
Environmental conditions within specified limits	Temperature, humidity, and wind meet MDS requirements	Manufacturer's Data Sheets			
Proper mixing and thinning of coating materials	Per manufacturer's instructions	Manufacturer's Data Sheets			
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Stripe coating applied as required (edges, welds, bolts)	Stripe coating fully covers specified areas	AMPP Guide 11			
Coating curing and drying verified	Meets curing times and conditions specified	Manufacturer's Data Sheets			
Post-coating visual inspection (defect-free)	No visible defects (pinholes, sags, runs)	AMPP VIS 1			

Production Notes:

Reported Nonconformances:

Verification of Work Task Completion (sign and date)

Inspector Name	Date of Inspection:
Signature	Time:

* On behalf of the contractor, I certify that this report is complete and correct, and the equipment and material used, and work performed during this reporting period is in compliance with the contract drawings and specifications to the best of my knowledge except as noted in this report.