

## SPECIFICATIONS

**Surface Preparation:** The exterior steel surface is blast cleaned to Steel Structures Painting Council Surface Preparation Specification No. 6 (SSPC-SP6) requirements utilizing cast steel abrasives conforming to the Society of Automotive Engineers (SAE) Recommended Practice J827. The blast method used is a recirculating, closed cycle centrifugal wheel system with abrasive conforming to SAE Shot Number S280.

**Interior Coating:** All accessible interior surfaces are coated with a lead and chromate free red oxide rust inhibitive alkyd primer to a minimum dry film thickness of 1.0 mils.

**Exterior Coating:** All exterior surfaces are prime coated with a Zinc Rich Epoxy Powder to a minimum dry film thickness of 2.0 mils. The coating is electrostatically applied and partially cured in a gas fired convection oven by heating the substrate to a minimum of 250° F.

The powder primed surface is coated with a High-Build Acrylic Polyurethane Enamel to a minimum dry film thickness of 2.0 mils (.002"). The coating is electrostatically applied and cured in a gas-fired convection oven by heating the steel substrate to a minimum of 225° F for a minimum of 1/2 hour.

**Quality:** Thermosetting powder resin provides both intracoat as well as substrate fusing adhesion that meets 5A or 5B classifications (most stringent) of ASTM D3359.

**Packaging:** Prior to shipment, small poles are wrapped in 0.125" thick ultraviolet-inhibiting, plastic-backed foam. Larger poles are cradled in a 1.0" rubberized foam base.