

## **SPECIFICATIONS**

**General:** The standard powder coat finish consists of either a Polyester Urethane, TGIC (Triglycidyl Isocyanurate) Polyester or a Super Durable Powder<sup>1</sup>.

**Surface Preparation:** Prior to being incorporated into an assembled product, steel plates 0.75" or more in thickness are blast cleaned when required to remove rolled-in mill scale, impurities and non-metallic foreign materials. After assembly, all weld flux is mechanically removed. 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:** Interior surfaces (pole shafts only) at the base end for a length of approximately 2.0' are mechanically cleaned and coated with a zinc rich epoxy powder. The coating is electrostatically applied and cured in a gas fired convection oven by heating the steel substrate to a minimum of 350° F and a maximum of 400° F.

**Exterior Coating:** All exterior surfaces are coated with either a Polyester Urethane, TGIC (Triglycidyl Isocyanurate) Polyester or a Super Durable Powder to an average dry film thickness (DFT) of 3.0 mils (0.003"). The coating is electrostatically applied and cured in a gas fired convection oven by heating the steel substrate to a minimum of 350° F and a maximum of 400° F. The thermosetting powder resin provides both intercoat as well as substrate fusion adhesion that meets 5A or 5B classifications of ASTM D3359.

**Quality Control:** The powder coating facilities are owned and operated by the pole manufacturer to ensure a quality coating system.

**Packaging:** Prior to shipment, small poles are wrapped in an ultraviolet inhibiting plastic backed foam. Larger poles are cradled in a rubberized foam base.

<sup>1</sup> A Super Durable Powder provides a minimum of three times the gloss retention, color retention and ultraviolet light (UV) resistance compared to the standard powder coatings. The Super Durable Powder is only stocked in Valmont standard colors. Other Super Durable colors may be made available upon factory request.