



Tesco Controls Inc.

Paint Process Specification

Enclosures Metal Preparation and Painting

General:

Enclosures and fittings shall be prepared for finishing, utilizing a five stage dip process and the coating shall be electrostatically applied powder in accordance with the following specifications.



Factory Painted Finish:

The paint coating shall be dry powder, electrostatically applied to produce a finish of 3 to 5 mils thickness.

The coated metal shall then be baked. The coating shall be commercially smooth, substantially free of flow lines, paint washout, streaks, blisters and other defects that would impair serviceability or detract from general appearance.

Tests and Certification:

The finish shall be in accordance with following:

Salt Spray Resistance The undercutting of the film of the coating shall not exceed 1/8" average, from lines scored diagonally and deep enough to expose the base metal, after 2500 hours exposure in a salt spray cabinet in accordance with ASTM Designation: B 117.

Adherence - There shall be no coating loss when tested by California Test 645. Compliance of the coating system to the above requirements may be determined by the application of the coating, to 4" X 8" X 0.024" test specimens of the same material as the cabinets, in the same manner as applied to the cabinet. Testing shall include tape pull and mandrel bend testing in compliance with California Test Method 645.

A fade and chalk test which shall result in a maximum of 10% deviation from an original finish measurement when checked by weatherometer and fadeometer.

Note:

Standard enclosures are fabricated from hot-dipped galvanized sheet steel, cleaned and painted in accordance with the preceding specifications. Optional enclosure materials include aluminum, clear anodized or painted in accordance with these specifications. Stainless Steel enclosures are available either painted in accordance with these specifications or left un-coated with a natural finish.

TESCO Control Cabinet Standard Colors:

ANSI 61 Gray, ANSI 49 Gray, Camel Tan, Ranch Green, Mint Green, Gloss Black, Dark Olive Green, Autumn White, Hospital White,
(Custom colors upon request)

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