

# Specifications:

**MAIN FRAME:** Welded assembly fabricated from 13 & 14 gauge galvanized steel tubing and hot rolled flat steel. Frame is coated with custom formula of TGIC polyester powder coating in conformance with the specifications outlined herein, after fabrication.

**END CAPS:** 4.5" OD and larger shall be cast aluminum, powder coated to match frame. Smaller end caps shall be injection molded high density polyethylene. All end caps are factory installed.

**Bolt Caps, Bolt Guards, and Foot Shrouds:** Injection molded high density polyethylene.

**FOOT PADS:** (where applicable) shall be cast aluminum.

**HARDWARE:** All nuts, bolts, screws, and lock washers used in the assembly shall be stainless steel, yellow dichromate plated steel, blue-coat plated steel, mechanically galvanized or powder coated/ yellow dichromate plated steel. All primary fasteners shall be 304 alloy stainless steel. Fasteners with yellow dichromate treatment have an electro-deposited, 99.9% pure zinc substrate applied from a specially formulated solution sealed with a yellow dichromate top coat designed to work in conjunction with the zinc plating.

Bolt Caps / Bolt Guards and foot shrouds are injection molded plastic. Foot Pads are cast aluminum 383 alloy with powder coat finish.

**POWDER COATING:** Powder-coat shall be an electrostatically applied custom formula of TGIC polyester powder. All components will be free of sharp edges and excess weld spatter and shall be cleaned in a multi stage bath system including a rust inhibitor, and a sealer to prevent flash rusting before coating. The coating shall have a super tough finish with maximum exterior durability and will have superior adhesion characteristics. Typical characteristics are: 3.0 - 5.0 mil thickness and oven cured between 375 to 425 degrees Fahrenheit. Pencil Hardness H (ASTM D-3363), Impact (ASTM D-2794-69), Wedge Bend (ASTM D-522-68), Adhesion (Cross Hatch ASTM D-3359 & Knife Scratch ASTM D-2197), Environmental (Stain Resistance ASTM D-1308, Humidity ASTM D 2247 - 87, Salt Spray ASTM B-117 & Fadometer 300 hrs with no loss of gloss), Oven-bake Stability 100% at 400 degrees Fahrenheit."

