



### Written Coatings Specification

- Stage I:** All products to be coated shall receive a 96 second Alkaline cleaner application followed by a 48 second fresh water rinse at ambient temperature.
- Stage II:** Shall be a 60 second Phosphoric Acid 4% solution treatment with a Fluoride accelerant followed by a 48 second reverse osmosis water rinse at ambient temperature. The rinse will be followed by a high pressure air spray to remove all moisture from the product.
- Stage III:** Shall be a 48 second Non-Chrome Polymer sealer application.
- Stage IV:** Shall start with 16 minutes in a drying oven at 400 degrees.

**Stage V:** Shall be an electrostatic application of polyester powder in a downdraft spray booth and applied by articulated robotic arm sprayer and over sprayed by an application technician. Polyester powder over spray shall be recoverable and reusable.

**Stage VI:** Shall be 25 minutes oven curing at 450 degrees to harden the powder finish and create final appearance and adhesion to the substrate. Curing shall be followed by 9.5 minutes in a cooling tunnel to prepare for un-racking.

Pre-Treatment and curing processes shall be followed by quality checks for adhesion using a cross-hatch test and for proper curing by means of a solvent rub test. Coatings process shall meet or exceed AAMA-2604-05 standard.

### Standard Finishes



**BKT** - BLACK TEXTURED



**WHT** - WHITE TEXTURED



**PGT** - PARK GREEN TEXTURED



**ABZT** - ARCHITECTURAL MEDIUM BRONZE TEXTURED



**DBT** - DARK BRONZE TEXTURED

Smooth finishes are available upon request

### Custom Finishes



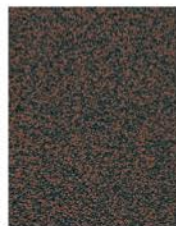
**CM** - CUSTOM MATCH



**OI** - OLD IRON



**RT** - RUST



**WBR** - WEATHERED BROWN



**CD** - CEDAR



**WBK** - WEATHERED BLACK



**TT** - TWO TONE

### Sternberg Select Finishes



**VG** - VERDE GREEN



**SI** - SWEDISH IRON



**OWGT** - OLD WORLD GRAY TEXTURED

#### Notes

- Standard and Select finishes are no extra charge.
- Custom finishes will have an additional charge.
- Metallic colors are subject to additional charges pending receipt and approval of color chips.
- All colors shown are approximate and may have a slight variation.