



AZZ|CENTRAL ELECTRIC PAINT SPECIFICATIONS

1. Central Electric purchases only top quality hot rolled, pickled and oiled steel. The pickling process removes scale and other surface impurities that exist after the rolling process. After pickling, the steel is coated with oil to inhibit corrosion.
2. After the enclosure has completed fabrication, it is prepared for the prime coating using the following process:
3. All welds and hard-to-reach areas are power cleaned with a steel wire wheel.
4. A power grinder is used to remove any corrosion, weld splatter, rust, scale or other detrimental foreign matter.
5. All enclosures are then cleaned with a phosphatizing solution mixed with water at 130 degrees F and sprayed at a pressure of 1,000 psi, which cleans and etches the surfaces. The enclosure is then thoroughly rinsed with water to remove all residues.
6. The enclosure is moved to the drying area to air dry.
7. After the enclosure is completely air dried, it is moved into the paint booth where a tack cloth is used to remove any dust or other contamination that may have settled on the surface during air dry.
8. Central Electric's standard exterior paint is a two-coat system. The primer is a two component epoxy primer manufactured by Wilko Paint, Inc. This is a high solids primer with an excellent balance of hardness, flexibility, and toughness. The coating is applied with an electrostatic spray gun to a minimum Dry Film Thickness (DFT) of 3.0 to 4.0 mils on all exterior surfaces. All weld seams and points receive a second coat of primer.
9. Central Electric's standard top coat is a high-solid, high-film build, two component polyurethane paint manufactured by Wilko Paint, Inc. This paint exhibits excellent gloss and color retention during its extended service life. The top coat is also applied with an electrostatic spray gun to a minimum DFT of 3.0 to 4.0 mils on all exterior surfaces.
10. The painted surface is allowed to dry, after which a paint inspection is performed to check for a quality finish to ensure uniformity and smoothness. The Dry Film Thickness is measured using an electronic type magnetic paint gauge. For exterior surfaces, a DFT of 6.0 to 8.0 mils is required.
11. Central Electric's standard interior paint is also a two-coat system. The primer is a two component epoxy primer manufactured by Wilko Paint, Inc. This coating is applied to a minimum Dry Film Thickness of 1.5 to 3.0 mils. The top coat is an acrylic enamel, high solids, semi gloss paint that is also supplied by Wilko Paint, Inc. It is applied to 1.5 to 2.0 minimum DFT for a total of 3.0 to 5.0 DFT on all interior surfaces.