



Specifications for all Black Poles

POLE FINISH:

**Surface preparation-**  
The exterior steel surface shall be blasted clean in accordance with the requirements outlined in the Steel Structures Painting Council Surface Preparation Specification, Number 6, (SSPCSP60) utilizing a dry abrasive, closed cycle, recirculating system with centrifugal wheels and abrasive. The abrasive used shall be steel shot conforming to the society of automotive engineers (SAE) recommended practice #J827 with particle size meeting SAE shot number S280.

**Zinc Coating-**

The pole assembly shall be hot-dip galvanized to the requirements of, either ASTM A123 (Fabricated items), or ASTM A153 (Hardware items) by immersion in a molten bath of prime western grade zinc, maintained between 810 and 850 degrees F. Maximum aluminum content of the bath shall not exceed 0.01%.

**Top Coat-**

All visually-exposed exterior surfaces shall be coated with a urethane or triglycidyl isoyanurate (TGIC) polyester powder to a minimum dry film thickness (DFT) of 0.05mm (2.0 MILS). Prior to application of the top coat, the surface shall be mechanically etched and pre-heated to 450 degrees F for a minimum of one hour. The coating shall be electrostatically applied and cured at a minimum temperature of 400 degrees F, and the color shall be Black.