

PAINT PROCESS SPECIFICATION

Enclosures Metal Preparation and Painting



TESCO
CONTROLS, INC.
100% Employee-Owned



Tesco Controls Paint Line

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General:

Enclosures and fittings shall be prepared for finishing, utilizing a five stage 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:

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 cross-hatch (tape pull), M.E.K. rub, and manual bend testing in compliance with California Test Method 645.

A Fade & Chalk Test:

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, uncoated aluminum, clear anodized or painted in accordance with these specifications. Stainless steel enclosures are available either painted in accordance with these specifications or left uncoated with a natural finish.

Standard Colors

ANSI 61 Gray, ANSI 49 Gray, White, Autumn White, Camel Tan, Dark Olive Green, Gloss Black, Mint Green, Ranch Green





PAINT PROCESS SPECIFICATION

Available RAL Colors

| | | | | | | | |
|------------------------------------|---|--|-----------------------------------|----------------------------------|------------------------------------|-----------------------------------|------------------------------------|
| RAL 1000 Green beige | RAL 1001 Beige | RAL 1002 Sand yellow | RAL 1003 Signal yellow | RAL 1004 Golden yellow | RAL 1005 Honey yellow | RAL 1006 Maize yellow | RAL 1007 Daffodil yellow |
| RAL 1011 Brown beige | RAL 1012 Lemon yellow | RAL 1013 Oyster white | RAL 1014 Ivory | RAL 1015 Light ivory | RAL 1016 Sulfur yellow | RAL 1017 Saffron yellow | RAL 1018 Zinc yellow |
| RAL 1019 Grey beige | RAL 1020 Olive yellow | RAL 1021 Rape yellow | RAL 1023 Traffic yellow | RAL 1024 Ochre yellow | RAL 1026 Luminous yellow | RAL 1027 Curry | RAL 1028 Melon yellow |
| RAL 1032 Broom yellow | RAL 1033 Dahlia yellow | RAL 1034 Pastel yellow | RAL 2000 Yellow orange | RAL 2001 Red orange | RAL 2002 Vermilion | RAL 2003 Pastel orange | RAL 2004 Pure orange |
| RAL 2005 Luminous orange | RAL 2007 Luminous bright orange | RAL 2008 Bright red orange | RAL 2009 Traffic orange | RAL 2010 Signal orange | RAL 2011 Deep orange | RAL 2012 Salmon orange | RAL 3000 Flame red |
| RAL 3001 Signal red | RAL 3002 Carmine red | RAL 3003 Ruby red | RAL 3004 Purple red | RAL 3005 Wine red | RAL 3007 Black red | RAL 3009 Oxide red | RAL 3011 Brown red |
| RAL 3012 Beige red | RAL 3013 Tomato red | RAL 3014 Antique pink | RAL 3015 Light pink | RAL 3016 Coral red | RAL 3017 Rose | RAL 3018 Strawberry red | RAL 3020 Traffic red |
| RAL 3022 Salmon pink | RAL 3024 Luminous red | RAL 3026 Luminous bright red | RAL 3027 Raspberry red | RAL 3031 Orient red | RAL 4001 Red lilac | RAL 4002 Red violet | RAL 4003 Heather violet |
| RAL 4004 Claret violet | RAL 4005 Blue lilac | RAL 4006 Traffic purple | RAL 4007 Purple violet | RAL 4008 Signal violet | RAL 4009 Pastel violet | RAL 4010 Tellemagenta | RAL 5000 Violet blue |

| | | | | | | | |
|---------------------------------|-------------------------------------|----------------------------------|---------------------------------|-----------------------------------|-------------------------------------|------------------------------------|-----------------------------------|
| RAL 5001 Green blue | RAL 5002 Ultramarine blue | RAL 5003 Sapphire blue | RAL 5004 Black blue | RAL 5005 Signal blue | RAL 5007 Brilliant blue | RAL 5008 Gray blue | RAL 5009 Azure blue |
| RAL 5010 Gentian blue | RAL 5011 Steel blue | RAL 5012 Light blue | RAL 5013 Cobalt blue | RAL 5014 Pigeon blue | RAL 5015 Sky blue | RAL 5017 Traffic blue | RAL 5018 Turquoise blue |
| RAL 5019 Capri blue | RAL 5020 Ocean blue | RAL 5021 Water blue | RAL 5022 Night blue | RAL 5023 Distant blue | RAL 5024 Pastel blue | RAL 6000 Patina green | RAL 6001 Emerald green |
| RAL 6002 Leaf green | RAL 6003 Olive green | RAL 6004 Blue green | RAL 6005 Moss green | RAL 6006 Grey olive | RAL 6007 Bottle green | RAL 6008 Brown green | RAL 6009 Fir green |
| RAL 6010 Grass green | RAL 6011 Reseda green | RAL 6012 Black green | RAL 6013 Reed green | RAL 6014 Yellow olive | RAL 6015 Black olive | RAL 6016 Turquoise green | RAL 6017 Yellow green |
| RAL 6018 May green | RAL 6019 Pastel green | RAL 6020 Chrome green | RAL 6021 Pale green | RAL 6022 Olive drab | RAL 6024 Traffic green | RAL 6025 Fern green | RAL 6026 Opal green |
| RAL 6027 Light green | RAL 6028 Pine green | RAL 6029 Mint green | RAL 6032 Signal green | RAL 6033 Mint turquoise | RAL 6034 Pastel turquoise | RAL 7000 Squirrel grey | RAL 7001 Silver grey |

*Actual color may vary slightly. Please refer to our website for more accurate color

*Paint chips are available upon request

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Available RAL Colors



| | | | | | | | |
|----------------------------------|----------------------------------|---------------------------------|-----------------------------------|------------------------------------|-----------------------------------|-----------------------------------|------------------------------------|
| RAL 7002 Olive grey | RAL 7003 Moss grey | RAL 7004 Signal grey | RAL 7005 Mouse grey | RAL 7006 Beige grey | RAL 7008 Khaki grey | RAL 7009 Green grey | RAL 7010 Tarpaulin grey |
| RAL 7011 Iron grey | RAL 7012 Basalt grey | RAL 7013 Brown grey | RAL 7015 Slate grey | RAL 7016 Anthracite grey | RAL 7021 Black grey | RAL 7022 Umbra grey | RAL 7023 Concrete grey |
| RAL 7024 Graphite grey | RAL 7026 Granite grey | RAL 7030 Stone grey | RAL 7031 Blue grey | RAL 7032 Pebble grey | RAL 7033 Cement grey | RAL 7034 Yellow grey | RAL 7035 Light grey |
| RAL 7036 Platinum grey | RAL 7037 Dusty grey | RAL 7038 Agate grey | RAL 7039 Quartz grey | RAL 7040 Window grey | RAL 7042 Verkehrsgrau A | RAL 7043 Verkehrsgrau B | RAL 7044 Silk grey |
| RAL 7045 Telegrau 1 | RAL 7046 Telegrau 2 | RAL 7047 Telegrau 4 | RAL 8000 Green brown | RAL 8001 Ocher brown | RAL 8002 Signal brown | RAL 8003 Clay brown | RAL 8004 Copper brown |
| RAL 8007 Fawn brown | RAL 8008 Olive brown | RAL 8011 Nut brown | RAL 8012 Red brown | RAL 8014 Sepia brown | RAL 8015 Chestnut brown | RAL 8016 Mahogany brown | RAL 8017 Chocolate brown |
| RAL 8019 Grey brown | RAL 8022 Black brown | RAL 8023 Orange brown | RAL 8024 Beige brown | RAL 8025 Pale brown | RAL 8028 Terra brown | RAL 9001 Cream | RAL 9002 Grey white |
| RAL 9003 Signal white | RAL 9004 Signal black | RAL 9005 Jet black | RAL 9006 White aluminum | RAL 9007 Grey aluminum | RAL 9010 Pure white | RAL 9011 Graphite black | RAL 9016 Traffic white |
| RAL 9017 Traffic black | RAL 9018 Papyrus white | | | | | | |

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*Paint chips are available upon request

**Ask about our clear coatings - available in all chemistries

Anti-Graffiti Coating:

Graffiti is a continuing problem. Removal is both costly and labor intensive. In our continued effort to provide our customers real solutions, Tesco offers an optional anti-graffiti coating. The purpose of anti-graffiti coating is to allow removal of graffiti without damage to the coating.

*Ask about additional custom applications

TESCO®

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Examples of Popular Finishes
Standard Cabinet Colors



Autumn White



White



Mint Green



Camel Tan



Ranch Green



ANSI 61 Gray



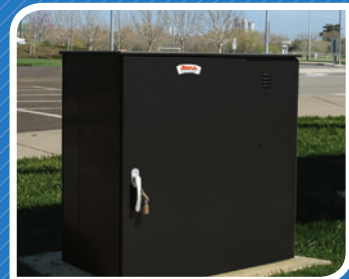
Dark Olive Green



ANSI 49 Gray



Gloss Black



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