

# PAINT PROCEDURE

## Pole Type Tank Finish

### PRODUCT DATA SHEET

**File Number:** PDS010

**Revised:** 04/01/16

**File Location:** Catalog

**Supercedes:** 08/02



### Pole Type Tank Finish

#### Metal Preparation

Chemical Etching - 5 Stage Washing and Phosphatizing

#### Painting

Spray with TGI Polyester Powder  
 Force cure  
 Spot check for 3.0 Mils minimum dry build  
 Caulk inside joint at tank on lift hoods, hanger brackets and support lugs

#### Performance Tests

**Salt Spray** (ASTM B117)  
 Pass 1000 hours

**Crosshatch Adhesion** (ASTM D3359)  
 100% adhesion

**Humidity** (ASTM D4585)  
 1000 hours, no blisters

**Impact** (ASTM D2794)  
 80 in/Lbs - No rust

**Oil Resistance**  
 72 hours - No color shift, blisters, loss of adhesion, streaking

**QUV Weathering** (ASTM G53)  
 500 hours - Less than 50% gloss loss

**Abrasion** (ASTM 4060)  
 1000 Gram weight, pass 3000 cycles

**SCAB** (ASTM D1654)  
 Average rating of 6 or above

**Gravelometer** (ASTM D3170)  
 Minimum rating 4B



#### Certification

The finish system is tested to be in full compliance with ANSI C57.12.31-2010 for Pole Mount Transformers.

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