

SECTION S679 - POWDER COATING

S679-1 DESCRIPTION

Work consists of treatment of street lighting poles and arms with powder coated finish as required in Contract Documents and as directed by Project Manager.

For purposes of this specification, all references are in accordance with *NYSDOT Standard Specifications (US Customary Units dated May 1, 2008)* edition, including any addenda.

S679-2 MATERIALS

To insure quality control, manufacturer of street lighting pole and arm is to also apply powder coating. Powder coating is to capable of providing corrosion protection and abrasion resistance of steel substrate for minimum period of 10 years.

After street lighting pole and arm has been galvanized, exterior surface is to be bias cleaned in accordance with Steel Structures Painting Council Surface Preparation Specification 7. Blast cleaning is to be done using re-circulating, closed cycle centrifugal wheel system with abrasive in accordance with SAE Shot #S280. After blasting, exterior surface is to be visually inspected for any signs of delamination.

Exterior surface of street lighting pole and arm is to be coated with urethane or triglycidyl isocyanurate (TG1C) polyester powder to minimum dry film thickness of 2 mil (0.002 inches). Interior surface of base end of street lighting pole is to be mechanically cleaned and coated with zinc rich epoxy powder to minimum depth of 2 feet.

Coatings are to be applied electro statically and cured in gas fired convection oven by heating steel substrate to between 350°F and 400°F. Finish coating for exterior surface is to be colored in accordance with ANSI 313. Finish color will be specified in Contract Documents.

For protection of powder coated finish during shipping, street lighting pole and arm are to be wrapped with 3/16 inch ultra-violet inhibited plastic backed foam envelope with built-in mechanism for easy removal of protective wrap. In addition, street lighting pole is to be cradled in 1 inch thick rubberized foam base.

S679-4 METHOD OF MEASUREMENT

Quantity to be measured for payment will be number of street lighting poles or arms powder coated.

S679-5 BASIS OF PAYMENT

Unit price bid includes cost of: surface preparation; furnishing and applying powder coating; coloring; additional packaging; and furnishing all labor, material and equipment necessary to satisfactorily complete work.

Payment will be made under:

Note: XX in bid item number and X' in item description represents size of street lighting pole or arm to be powder coated. i.e.: 20 foot street lighting pole would be bid as S679.0120 Powder Coating - 20' Street Lighting Pole.

ITEM NO.	ITEM	PAY UNIT
S679.01XX	Powder Coating - X' Street Lighting Pole	Each
S679.02XX	Powder Coating - X' Street Lighting Arm	Each

REVISED March 3, 2015