



Corporate Office
o: 972. 488. 0635
f: 972. 488. 0636
1838 Forms Drive
Carrollton, TX 75006

SECTION 05 0515 - SHOP-APPLIED WOODGRAIN POWDER COATINGS

This section includes editing notes to assist the user in editing the section to suit project requirements. These notes are included as hidden text, and can be revealed or hidden by one of the following methods:

Microsoft Word 2013: Display the FILE tab on the ribbon, click OPTIONS, then DISPLAY. Select or deselect HIDDEN TEXT.

Microsoft Word 2010: Display the FILE tab on the ribbon, click OPTIONS, then on left menu click on DISPLAY. Under ALWAYS SHOW THESE select or deselect HIDDEN TEXT.

Microsoft Word 2007: Click the OFFICE button, select WORD OPTIONS, select DISPLAY, then select or deselect the HIDDEN TEXT option.

Corel WordPerfect: From the pull-down menus select VIEW, then select or deselect the HIDDEN TEXT option.



GENERAL

1.1 SUMMARY

A. Section Includes:

1. Shop-applied architectural powder coatings for [railings] [architectural metalwork] [roof panels] [wall panels] [doors] [frames] [entrances] [storefronts] [windows] [curtain walls] [sun screens] [light fixtures] [fencing] [and] [_____].

B. Related Sections:

1. Division 01: Administrative, procedural, and temporary work requirements.
2. Section [05 5000- Metal Fabrications] [05 7000 - Decorative Metals] [05 5800 - Formed Metal Fabrications] [____ - _____]: Architectural metalwork to receive shop-applied powder coatings.
3. Section [05 5000 - Metal Stairs] [05 5200 - Metal Railings] [____ - _____]: Metal railings to receive shop-applied powder coatings.
4. Section [08 1113 - Hollow Metal Doors and Frames] [____ - _____]: Steel doors and frames to receive shop-applied powder coatings.
5. Section [08 1116 - Aluminum Doors and Frames] [____ - _____]: Aluminum doors and frames to receive shop-applied powder coatings.
6. Section [08 3213 - Sliding Aluminum-Framed Glass Doors] [____ - _____]: Aluminum sliding doors to receive shop-applied powder coatings.
7. Section [08 4113 - Aluminum Entrances and Storefronts] [____ - _____]: Aluminum entrances and storefronts to receive shop-applied powder coatings.
8. Section [08 4200 - Entrances] [____ - _____]: Metal entrances to receive shop-applied powder coatings.
9. Section [08 4413 - Glazed Aluminum Curtain Walls] [____ - _____]: Aluminum curtain wall to receive shop-applied powder coatings.
10. Section [08 5113 - Aluminum Windows and Glass Doors] [____ - _____]: Aluminum windows and glass doors to receive shop-applied powder coatings.
11. Section [10 1400 - Signage] [____ - _____]: [Interior] [Exterior] signs to receive shop-applied powder coatings.
12. Section [26 5000] [____ - _____]: Light fixture to receive shop-applied powder coatings.
13. Section [32 3100] [____ - _____]: Metal fences to receive shop-applied powder coatings.

1.2 REFERENCES

A. American Architectural Manufacturers Association (AAMA):

1. 2604 - Voluntary Specification, Performance Requirements and Test Procedures for High Performance Organic Coatings on Architectural Extrusions and Panels.
2. 2605 - Voluntary Specification, Performance Requirements and Test Procedures for Superior Performing Organic Coatings on Architectural Extrusions and Panels.

1.3 SUBMITTALS

A. Submittals for Review:

1. Product Data: Manufacturer's descriptive data and test results for specified finishes.
2. Samples: [3 x 3] [__ x __] inch coating samples [showing available colors,] [in specified colors,] on representative backing.



- B. Quality Control Submittals:
 - 1. Certificates of Compliance: Applicator's certification that coatings applied on Project components comply with referenced AAMA standards.

- C. Closeout Submittals:
 - 1. Maintenance Data: Provide information regarding touch-up, cleaning, and maintenance of coatings.

1.4 QUALITY ASSURANCE

- A. Applicator Qualifications:
 - 1. Minimum 5 years experience in work of this Section.
 - 2. Certified by AAMA.

1.5 DELIVERY, STORAGE AND HANDLING

- A. Apply manufacturer's standard protective coverings to finished surfaces.
- B. Deliver, store, and handle finished components in manner to prevent damage to finishes.
- C. Furnish touch-up paint along with each material shipment.

1.6 WARRANTIES

- B. Furnish coating manufacturer's [5] [10] year warranty providing coverage for color and gloss retention.

PART 2 PRODUCTS

2.1 APPLICATORS

- A. Contract Documents are based on products by Quality Powder Coating. (www.qualitypowdercoating.com)
- B. Substitutions: [Under provisions of Division 01.] [Not permitted.]

2.2 MATERIALS

- A. Powder Coating:
 - 1. Meet or exceed requirements of AAMA [2604.] [2605.]
 - 2. Color: [Custom] [] color [to be selected from manufacturer's full color range].

2.3 SHOP-APPLIED FINISHES

- A. Surface Preparation: Pretreat surfaces to receive coatings using applicator's proprietary wash coat process including chemical conversion and five stage wash.
- B. Application:
 - 1. Apply coatings in accordance with manufacturer's instructions to uniform surface free from blemishes.
 - 2. Electrostatically apply powder coating base coat to 2 to 4 mil thickness.
 - 3. After application polymerize coatings at 400 degrees F for 20 minutes.



4. Completely wrap preprinted transfer film with organic photosensitive pigments and cellulose resin around components, with airtight seal.
5. Place components on moveable trolley or large membrane frame.
6. Remove air using vacuum suction system, bringing printed film into contact with coated surface.
7. Place components into integrated curing oven, turning ink pigments from solid to gas and back to solid inside initial layer of powder.
8. Remove from oven after substrate reaches designated temperature.
9. Force air into paper to release from substrate.

PART 3 EXECUTION

3.1 ADJUSTING

- A. Touch up minor scratches and abrasions in coatings in accordance with manufacturer's instructions; replace components having damage that cannot be successfully touched up.

3.2 CLEANING

- A. Clean finished surfaces after installation in accordance with manufacturer's instructions.

3.3 SCHEDULE

COMPONENT	COLOR AND PATTERN
Aluminum Window Trim	White Oak
Interior Aluminum Frames	Custom color and pattern to be selected

PART 1 END OF SECTION