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Finishing Standards including Color Codes for Custom Parts for Suppliers

Purpose:

This document outlines standard add-on finishing requirements and associated color codes for custom manufactured, fabricated or otherwise processed custom parts.

Scope:

This document applies to all suppliers who supply to ESG manufactured, fabricated, or processed parts as part of meeting the contractual requirements of an ESG-issued and supplier accepted Purchase Order. Specific requirements within this document apply as appropriate to the parts or services being supplied to ESG.

Definitions:

***ESG*:** Energy Systems Global is a line of business within the EnerSys corporation.

ATL: Alpha Technologies Ltd. or EnerSys Burnaby site.

ATS: Alpha Technologies Services or EnerSys Bellingham site.

Custom Part: A part, component or assembly that is fabricated, processed, or manufactured per requirements specified in ESG part or assembly drawings/documents.

ATL Part Number*:* The unique identifier applied to an ATL-custom designed or manufactured part. This number is noted on ATL-provided drawing(s) as well as the ATL PO.

Supplier*:* An organization that supplies goods, raw materials and/or services to ESG.

Finishing*:* An add-on process to alter a part's surface to achieve a better aesthetic look or part performance. A non-exhaustive list includes Electro-plating, Powder Coating, Spray Painting, Anodizing, and E-coating etc.

Finish Code*:* A three-digit number assigned in this document to represent the finishing to be applied to a part during the fabrication process.

Legacy Finish Code*:* A two-digit Alpha-numeric code as the last two digits of legacy ATL Part Number or legacy Argus Part Number in the format "XXX-XXX-FF" to represent the finishing required for the part.

Example: 613-656-W3 W3 is the legacy finish code for this part.

0700002 Rev BE (10/2025)
F-19-09 Rev 1.3

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***Part Number Table**:* A table can be found in ATL part or assembly drawings relating Part Numbers and finishing requirements represented by Finish Codes.

1.0 Precedence Level:

In case of requirements conflict, follow this priority from highest to lowest:

1: TDN (Temporary Deviation Notification)

2: ESG Engineering Drawing/Documentation

3: This standard

4: Other ESG Engineering published standards where applicable

5: Supplier/manufacturer internal standard

2.0 Part Number Table

The part finishing is defined in the Part Number Table in the part/assembly drawing. To each specific part number, a finish code, or a combination of finish codes, will be assigned with a brief description for reference. When a graphics silkscreen is required, the silkscreen number will be indicated. Additional finishing requirements can be found in both drawing notes and extra columns of Part Number Table.

When an add-on finish is not required for a specific part number, either "-" or "N/A" (Not Applicable) will be used instead of a finish code. Typical applicable finish descriptions are:

BARE – use the part as is after fabrication, without any add-on finish.

MILL FINISH – the original finish processed by the material mill shall be preserved, without any alteration.

Examples of Part Number Tables:

Sheet metal parts based on the same drawing with different powder coatings or without add-on finish:

PART NUMBER TABLE FINISH CODE IN ACCORDANCE WITH ALPHA DOCUMENT #0700002			
PART NUMBER	FINISH CODE	DESCRIPTION	SILKSCREEN #
5900238-001	238	LIGHT GRAY	NONE
5900238-002	211	WHITE	NONE
5900238-003	209	BLACK	NONE
5900238-004	-	BARE	NONE
5900238-005	252	UMBRA GRAY	NONE
5900238-006	268	BLACK GREEN	NONE

Die cast metal parts based on the same drawing with multiple finishes applied:

PART NUMBER TABLE FINISH CODE IN ACCORDANCE WITH ALPHA DOCUMENT #0700002			
PART NUMBER	FINISH CODE	DESCRIPTION	SILKSCREEN #
5901181-001	102 AND 243	CLEAR ALODINE AND BLACK POWER COAT	0800055-00
5901181-002	102 AND 243	CLEAR ALODINE AND BLACK POWER COAT	0800174-00

Sheet metal cabinet weldment assembly with different powder coatings or without add-on finish:

PART NUMBER TABLE FINISH CODE IN ACCORDANCE WITH ALPHA DOCUMENT #0700002		
PART NUMBER	FINISH CODE	DESCRIPTION
5901471-001	203	BLACK, SEMI-GLOSS, POWDER COAT
5901471-002	201	GRAY, SEMI-GLOSS, POWDER COAT
5901471-003	N/A	MILL FINISH, VINYL CLAD
5901471-004	249	GREY, RAL 9007

Plastic injection molded parts based on the same drawing with coloring requirements on resin and no add-on finish:

PART NUMBER TABLE			
PART NUMBER	FINISH CODE	DESCRIPTION	SILKSCREEN #
5700163-001	-	RAL 5010, GENTIAN BLUE	0800227-00
5700163-002	-	RAL 3027, RASPBERRY RED	0800228-00
5700163-003	-	BLACK	0800236-00
5700163-004	-	RAL 7012, BASALT GREY	0800245-00
5700163-005	-	RAL 5010, GENTIAN BLUE	0800247-00

3.0 Legacy Finish Code Documents

Alpha and Argus legacy finishes may or may not be identified on a drawing that references a different document number than this one. In those cases, please refer to the following legacy finish code documents:

Part drawings that refer to “Alpha Document 070-022-00” (which is included in the ATL Supplier Production Standards package) containing ATS specific code information which should be confirmed with ESG prior to proceeding to avoid any confusion or conflict.

Part drawings that refer to “Argus Document 070-024-83” (which is included in the ATL Supplier Production Standards package) containing legacy code information, which should be confirmed with ESG prior to proceeding.

4.0 General Requirements

RoHS: All finishes must be RoHS compliant. If a particular finish specification does not meet RoHS, please notify ESG Purchasing immediately.

5.0 Finish Requirements

5.1 Painting Requirements:

All screw threads must be free of paint.

All hinges shall be free to turn as intended after finishing.

Painted surfaces shall be uniformly smooth, with no visible imperfections, when viewed from a distance of 3 feet with the unaided eye. The following conditions are unacceptable:

a) Wrong Color – Color or gloss, which deviates from specification or contrast requirements.
b) Poor Coverage – Paint, which does not cover or extends beyond specified areas.
c) Scratches – Rubs, tears, or scrapes, which damage the paint surface, or which expose base metal or primer coats.
d) Smudges, Mars, or Blemishes – Surface imperfections introduced during painting or drying that affect the appearance of the paint coat, such as smears, streaks, or blurry areas.
e) Blisters, Voids, or Chips – Painted surfaces that exhibit signs of poor adhesion to the base metal, gaps or openings in the coating, or fragments broken out of the surface, which are visible to the naked eye.
f) Orange Peel – Paint coating where the skin exhibits a rough or wrinkled appearance like the outside of an orange.
g) Sags and Runs – Paint coatings, which exhibit irregular surfaces due to uneven paint flow.
h) Rough Coating – Paint coating where the surface lacks smooth appearance due to improper spray technique. Roughness of the coating may be detected by running the fingertips across the painted surface.

i) Contaminated Coating – Coatings which are rough or irregular due to application over sand, dirt, grit or metal particles.

j) Excessive Paint – Surfaces where the coating exhibits noticeable layering or global formation due to application of a more than adequate amount of paint or improper touch-up.

k) Thin Coating – Coatings fail to obliterate the background over which it is applied due to insufficient paint application or insufficient hiding power of the coating. The resulting surface allows the base metal to show through the surface coat.

l) Wet Paint – Paint coatings that are wet, tacky, soft, or uncured due to insufficient drying time or improper mixing.

5.2 Powder Coating Requirements:

Powder coating design thickness: 0.0015” – 0.0040” unless otherwise specified on an ATL drawing.

All screw threads must be free of powder coat.

All hinges shall be free to turn as intended after finishing.

When specified in part drawing the surface classification, acceptance will be viewed and judged from an at-arms-length distance, allowing 10 seconds per surface.

a) Level A = Critical Surface

b) Level B = Other Sides

c) Level C = Internal

Acceptance Table

Defect Type	**Maximum Size**	**Surface Classification**		
		Level A	**Level B**	**Level C**
Scratch	1” L X1/8” W	0	0	4
Non-Adhesive or peeling	¼” Dia.	0	0	3 for a total of ¼” Dia.
Stain & Discolor	¼” Dia.	0	1	3
Dents/Pits with surface coverage tack	¼” Dia.	0	1	3
Foreign Material/ Debris	¼” Dia.	0	2	3

5.3 Electrophoretic coating (or Electrocoating or E-coating) Requirements:

Electrocoating design thickness: 0.0004” – 0.0012” unless otherwise specified on an ATL drawing.

5.4 Inorganic/Metallic Coating/Plating Requirements:

Per Plating/Coating Specifications in the table.

5.5 Silkscreening Requirements:

These requirements also apply to other graphics application methods on parts like pad-printing, hot stamping, laser marking etc.

All materials must be RoHS compliant.

Graphics on part shall pass CSA test for the permanence of markings outlined in CSA C22.2 No. 62368-1, section F.3.10. Graphics of packaging materials are exempted from this requirement.

5.6 Cleanliness and Post Processing Requirements:

All parts shall be clean and free from residual manufacturing substances including but not limited to:

a) Machining lubricants and coolants.
b) Oils or grease.
c) Mold release agents.
d) Dirt, dust, or machining byproducts such as shavings.

6.0 Finish Codes

6.1 Inorganic/Metallic Coating/Plating

Code	Description	Applicable Substrate	Plating/Coating Specification
101	~~Chromate conversion Yellow (a.k.a. gold Alodine or gold Irridite)~~	Aluminum	~~Conversion coating per MIL-DTL-5541F, Class 3, Type 1~~ Obsolete code, do not use

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Code	Description	Applicable Substrate	Plating/Coating Specification
102	Clear Chromate conversion (a.k.a. clear Alodine or clear Irridite)	Aluminum	Conversion coating per MIL-DTL-5541F, Class 3, Type II
103	Clear anodize	Aluminum	Anodize per MIL-A-8625F, either Type I, IB, IC, II or IIB are acceptable, Class 1, non-dyed
104	Black anodize	Aluminum	Anodize per MIL-A-8625F, either Type I, IB, IC, II, or IIB, are acceptable, Class 2, dyed black
105	Bright Electro Tin plated Class B	Copper, Brass, Aluminum, Iron and Steel	ASTM B545-97 Class B (minimum 5um) for electrical contact application, with minimum 1.3um thick porous free Nickel underplating.
106	Matte Electro Tin plated Class C	Copper, Brass, Aluminum, Iron and Steel	ASTM B545-97 Class C (8um) for soldering application, with minimum 1.3um thick porous free Nickel underplating.
107	Zinc Plated minimum 5um(0.0002") thick, Clear Chromate Conversion	Iron and Steel	Zinc Plating Per ASTM B633-19, Service Condition 1 (mild), Type III with Colorless Chromate Conversion Coatings
108	Zinc plated minimum 8um (0.0003") thick, Clear Chromate Conversion	Iron and Steel	Zinc Plating Per ASTM B633-19, Service Condition 2 (moderate), Type III with Colorless Chromate Conversion Coatings
109	Zinc plated minimum 12um (0.0008") thick, Yellow Chromate Conversion	Iron and Steel	Zinc Plating Per ASTM B633-19, Service Condition 3 (severe), Type II with Colored§ Chromate Coatings
110	Zinc plated minimum 25um (0.001") thick, Yellow Chromate Conversion	Iron and Steel	Zinc Plating Per ASTM B633-19, Service Condition 4 (very severe), Type II with Colored§ Chromate Coatings
111	Zinc plated minimum 25um (0.001") thick Black Chromate Conversion	Iron and Steel	Zinc Plating Per ASTM B633-19, Service Condition 1 (mild), with Black Chromate Conversion
112	Steel, hot dip galvanized (Zinc coating)	Iron and Steel	Zinc (hot dip galvanized) coating per ASTM A123/A123M.
113	Matte Electro Tin plated Class B	Copper, Brass, Aluminum, Iron, and Steel	ASTM B545-97 Class B (minimum 5um) for electrical contact application, with minimum 1.3um thick, porous free Nickel underplating

Code	Description	Applicable Substrate	Plating/Coating Specification
114	Silver Plated, Semi-bright, (2.5um minimum)	Copper, Brass, Aluminum†, Iron and Steel	ASTM B700-90 Type 1, Grade D (99.9% pure, semi-bright), Class N or S. Coating thickness: minimum 2.5uM for electrical contact application.
115	Black Oxide Coating	Iron and Steel, including Stainless Steel	Black Oxide Coating per ISO 11408.
116	Hard Chrome Plating	Zinc die cast	Hard Chrome Plating per SAE-AMS-QQ-C-320, Class 2b, minimum thickness 0.002" (.08mm), bright finish.
117	Bright Electro Tin plated Class C	Copper, Brass, Aluminum, Iron and Steel	ASTM B545-97 Class C (8um) for soldering application, with minimum 1.3um thick, porous free Nickel underplating

§ Further specification may be required in the drawing if variance in color may affect the aesthetic look of the product.

†Consult plating supplier before specifying with Aluminum substrate.

6.2 Organic Coating:

Code	Description	Approved Coating Manufacturer and P/N
201	ASA-61 Gray, Semi-gloss, Powder Coat	Tiger Drylac 49/70050 ASA-61 Gray Polyester Powder Coat (UL Recognized) Cardinal T008-GR736 Gray Powder Coat (UL Recognized)
202	Gray leatherette, Textured, Powder Coat	Protech HT212A4 (was H1000AT4) Textured Gray Hybrid Powder Coat (UL Recognized)
203	Black, Semi-gloss, Powder Coat	Protech PS311N13 (was DS311N12) Semi Gloss Black TGIC Polyester Powder Coat (UL Recognized)
204	Light tan, Powder Coat	Glidden Pulvalure 6DI06 Lite Tan TGIC Polyester Powder Coat (UL Recognized)
205	Clear Powder coat	Tiger Drylac 39/00020 TGIC Polyester (UL Recognized)

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Code	Description	Approved Coating Manufacturer and P/N
206	Midnight blue, Powder Coat	Protech PS211B2 (was P100B2) Midnight Blue TGIC Polyester Powder Coat (UL Recognized)
207	Platinum, Powder Coat	Protech HS412H36 (was H1000H36) Platinum Hybrid Powder Coat (UL Recognized)
208 *	Textured Blue	Textured Polane, Pantone #281C Blue (Pending powder coat P/N)
209	Black, Gloss, Powder Coat	Cardinal T009-Bk12 #17038 Black TGIC Polyester Powder Coat
210	Sea foam green, Powder Coat	H.B. Fuller Kativo IF-2411 Sea Foam TGIC Polyester Powder Coat Morton 20-6023 Corvel Green Polyester Powder Coat Tiger Drylac 249/52200 Alpha Sea Foam Green Polyester Powder Coat Cardinal 6408-14672
211	White, Powder Coat	Protech P100W14 White TGIC Polyester Powder Coat (UL Recognized) Tiger Drylac Polyester 39/10160 Horizon White (UL Recognized) Cardinal T009-WH11 Horizon White Powder Coat Sherwin Williams PWS9-01169 Protech PS112W104
212	Flat Black, Powder Coat	Morton Thiokol 80-7001 Corvel Solar Black TGIC Polyester Powder Coat Cardinal #E300-BK147 Flat Black Epoxy
213	Gray, Textured, Powder Coat	Protech PC 4732 Blue-Gray Textured Hybrid (Epoxy/Polyester) Powder Coat
214	Gray, Textured, Epoxy Polyester Powder Coat	Cardinal H312-BG160 Beige Textured Epoxy Polyester Hybrid Powder Coat Sherwin-Williams H-2415-2T Pro Grey Texture
215	Safety red, Powder Coat	DOW Plastics ENVELON Series Safety Red (SR) Powder Coat Cardinal T009-RD03 TGIC Polyester Powder Coat. Axalta PFR400S9 RED BARON TGIC-Polyester Powder Coat
216	Beige, Polyester Powder Coat	Tiger Drylac Series 49/70520 (RAL9002) TGIC Polyester Powder Coat
217	Light Silver, Polyester Powder Coat	Tiger Drylac Series 38/91020 Anodized Silver TGIC Polyester Powder Coat

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Code	Description	Approved Coating Manufacturer and P/N
218	Dark green, Semi-gloss, Polyester Powder Coat	Cardinal C006-GN03 Green TGIC Free Polyester Powder Coat, Semi Gloss Smooth Green
219	Light Silver, Polyester Powder Coat	Tiger Drylac Series 38/91020 Anodized Silver TGIC Polyester Powder Coat
220	White Powder Coat	Apollo White Glossy, Tiger Drylac #39/10210
221	Fieldstone tan Powder Coat	Sherwin-Williams 47982 Code F2NG59 Fieldstone Tan
222	Black, textured , Epoxy Powder Coat	Protech ET442N2 (was E2000NT2) Textured Black Epoxy Powder Coat
223	Light blue, Polyurethane Powder Coat	Cardinal 6405-6842 Light Blue Polyurethane
224	Dark Blue, Polyester Powder Coat	Cardinal TO32-BL64 Dark Blue TGIC Polyester Powder Coat
225	White, Polyester Powder Coat	Hentzen P4156WPC White TGIC Polyester Powder Coat
226	Charcoal Gray, Polyester Powder Coat	Cardinal C241-GR663 Charcoal Gray Polyester Powder Coat
227	Almond, Semi-gloss, Powder Coat	Fuller O'Brien #PFT-500-S8 Almond, Semi-Gloss Powder Coat. Tiger Drylac Series 39/15020 Almond Smooth Glossy
228	Hybrid Gray Powder Coat	Tiger Drylac 459/70150 Cardinal GR1465-C004 Sherwin Williams PAS400623
229	Central Office White, Powder Coat	Dupont China AD3000-9181536 TGIC Type Powder (White) Dupont (O'Brien) UFW563S3 Polyester Powder Coat (for application of Pantone Cool Gray 1)

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Code	Description	Approved Coating Manufacturer and P/N
230*	ASA61 Gray, Semi-Gloss, Powder Coat (UL Recoginzed)	Glidden No.5 Pulvalure Gray Powder Coat (UL Recognized) Fuller Kativo IF-3164 (KUR-13255-40) Gray Polyester Powder Coat (UL Recognized) Morton Thiokol 20-7056 (U1575-17056) Powder Coat (UL Recognized) Protech PS311A13 (was P1000A13) ASA61 Gray Polyester Powder Coat (UL Recognized) (Pending verification if this is the same as #201)
231*	Gray, Textured, Polyester Powder Coat	Tiger Drylac 449/71190 Fuller Kativo 3449-12B Blue-Gray Textured TGIC Polyester Powder Coat (Pending verification if this is the same as #213)
232	Warm Gray 3C Powder Coat	Calix #3C Warm Gray – Cardinal T032-GR693 – Polyester TGCI Powder Coating Semi-Gloss Texture LS#4266
233	Metallic Brown, Polyurethane Powder Coat	Protech UM512M48 Polyurethane (smooth, metallic brown)
234	Exterior Gray, Polyester Powder Coat	Spectrum GY10 SP618 Cardinal - Gray Quartz Exterior p/n# T243 GR301 Polyester Powder Coat
235*	Charcoal Gray Powder Coat	Newbridge Charcoal Gray (pending powder coat P/N)
236	Motorola Shadow Black, Polyester/Epoxy Powder Coat	Spectrum BK10 SP241 Morton Thiokol 20-7304 Polyester Powder Coat Morton Thiokol 10-7393 Epoxy Powder Coat
237	Charcoal Gray Powder Coat	Tiger Drylac (China and Canada) 49/80076 - Polyester TGIC Powder Coat. Sherwin Williams PAT100705
238	Light Gray Powder Coat	Cardinal GR142-T241
239	Telco Green Powder Coat	Spectrum GN80-P235 – Polyester Powder Coat – High Gloss Texture
240	Off White Powder Coat	Cardinal BG583-T038 - Polyester TGIC Powder Coat - High Gloss Texture
241	Spruce Green Powder Coat	Protech PS311G644 - Polyester TGIC

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Code	Description	Approved Coating Manufacturer and P/N
242	“Traffic” Green Powder Coat	Cardinal T007-GN16 - Polyester TGIC Powder Coat - High Gloss Smooth
243	Black, Textured, Semi-Gloss, Polyester Powder Coat	Cardinal C241-BK01 - Polyester Powder Coat (TGIC free) Hua Cai Yuan TH1646 (China) Sherwin Williams PBT100607 Sherwin Williams RBT100005 (TGIC free) Protech PX411N42
244	Black, Epoxy Electrocoat	PPG Powercron 6000CX Epoxy Electrocoat
245	Signal Grey Smooth Glossy (RAL 7004) Powder Coat	Tiger Drylac 49/73300 - Interior/Exterior, Weather Resistant TGIC Polyester Powder Coating
246	Cream, Smooth Glossy (RAL 9001) Powder Coat	Protech TD6204-5 – Erie Anti-Graffiti Polyurethane Coating, Color (RAL 9001) Cream, Smooth Glossy
247	Warm Gray 1C Powder Coat	Calix #1C Warm Gray – Cardinal T032-GR692 – Polyester TGCI Powder Coating Semi-Gloss Texture LS#4262
248	Nut Brown (RAL8011), Glossy, Powder Coat	Tiger Drylac 49/66100 - Interior/Exterior, Weather Resistant TGIC Polyester Powder Coating, Color Nut Brown (RAL 8011), Glossy
249	Gray Aluminum, Metallic, Glossy (RAL9007) Powder Coat	Tiger Drylac 49/92880 - Interior/Exterior, Weather Resistant TGIC Polyester Powder Coating
250	Light Gray, Low Gloss (RAL7035) Powder Coat	Envirocron PCTC 70268, Exterior Polyester Powder Coating (RAL7035), Low Gloss Cardinal T013-GR185 Axalta 678062B
251	White, Textured, Semi-Gloss, Polyester Powder Coat	Cardinal #C031-WH120, Polyester Powder Coating, Semi-Gloss Texture, White
252	Umbra Gray (RAL7022) Powder Coat	Tiger Drylac 49/72850 – Interior/Exterior, Weather Resistant TGCI Polyester Powder Coating, Color Umbra Gray (RAL 7022)
253	Satuary Bronze Powder Coat	DuPont Alesta PFJ407A5 TGIC Polyester Powder Coat

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Code	Description	Approved Coating Manufacturer and P/N
254	Anti-graffiti Clear Powder Coat	Sherwin-Williams Powdura UCS9-00007
255	Anti-graffiti White Powder Coat	Tiger Drylac 44/10008
256	Aluminum, Fed Std #17178 Powder Coat	Aluminum Finish, Federal Standard 595C #17178, approved powder coat suppliers: PPG, DuPont, Sherwin-Williams
257	Dark Green, Fed Std 14036 Powder Coat	Sherwin Williams PGS5-00505
258	Super OGF Black Powder Coat	IFS Coatings SRSS 10004 TGIC Polyester Powder Coat, Super Out Gas Forgiving (OGF)
259	Olive Brown, RAL 8008 Powder Coat	Tiger Drylac 49/66110 or 38/60008 Powder Coat
260	Patrician Bronze 1452 Powder Coat	Vitracoat PDL50011-1 Polyester Powder Coat
261	Midnight Neutral Powder Coat	Cardinal # X009-BKN01767 Powder Coat
262	Black, Fed Std 27038 Powder Coat	Cardinal / Tiger Drylac / Sherwin Williams Polyester powder coat matching Federal Standard 595B Color 27038
263	Green Powder Coat	Protec PSG111G162 Sherwin Williams DGS8-70031-C50
264	Dark Brown, Fed Std 20040, Powder Coat	Cardinal / Tiger Drylac / Sherwin Williams Polyester powder coat matching Federal Standard 595B Color 20040 Protech ZS341M321
265	Luster Gray, RAL 7042, Powder Coat	Tiger Drylac 49/73250 or 38/70042
266	Dove Gray, PU96104, Powder Coat	Spraylat Polyurethanes PU96104

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Code	Description	Approved Coating Manufacturer and P/N
267	Dark Hemlock Green Powder Coat	TCI 9010-62306
268	RAL 6012 Black Green Powder Coat	Tiger Drylac 38/50012 or 49/51540 TCI 9840-61262R
269	RAL 7040 Window Grey Powder Coat	TCI 9840-71979R, Polyester TGIC Powder Coating, 80-89 Gloss Smooth
270	Gloss Smooth Beige Powder Coat	Cardinal T009-BG16, Polyester TGIC Powder Coating, Full Gloss Smooth
271	Gloss White, Powder Coat	Protech PS111W2 Gloss White Polyester (UL Recognized)
272	Comet Black U1578-1, Powder Coat	AkzoNobel, Interpon 600, JN103QF (Formerly 30-7018), Comet Black U1578-1, Polyester TGIC Powder Coating
273	Clear, Anti-graffiti, Smooth Glossy Powder Coat	Tiger Drylac 44/00018
274	Chrome Green UD (RAL 6020), Powder Coat	Envirocron PCTA49121, RAL 6020 Chrome Green UD Polyester
275	Stormy Sky, Satin (ICI A1938) Powder Coat	Protech ZS341G483, Stormy Sky
276	Fir Green (RAL 6009) Powder Coat	Tiger Drylac 149/52849 Smooth Glossy
277	Black, Textured, Semi-Gloss, Polyester Powder Coat	Cardinal # C241-BK303, Polyester Powder Coating, Semi-Gloss Texture, Black
278	Black Matte, Polyester Powder Coat	Tiger Drylac 39/80020, TGIC Polyester Powder Coat
279	ASA-70 Light Grey, Polyester Powder Coat	Tiger Drylac 139/70010, TGIC Polyester Powder Coat

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Code	Description	Approved Coating Manufacturer and P/N
280	Light Grey, Fed Std 16473 Powder Coat	Sherwin Williams PAS560124

* Some clarification may be required for these codes, please contact ATL's Design Services team when specifying these codes.

END OF DOCUMENT

For assistance, contact Alpha Technical Support:
Toll Free North America: 1-888-462-7487
International: +1-604-436-5547
Monday - Friday, 5:00 AM - 5:00 PM PST for regular inquires
24/7 for emergency support
Click here to report a problem