

B. Security Panels:

1. Frame: 1" x 1" x 1/8" angle finished to match door. Fasten with Torx screws finished to match frame.
2. Infill: 12-gage cold-rolled steel, mill-galvanealed both sides; perforated with minimum open area of 51% and visibility quotient of 2.60.

a. Finish: Powder Coating.

Coat with a colored polymeric urethane powder coating, minimum thickness of 3 mils. Coatings containing epoxy or lead are not acceptable. Substrate: Provide mechanical cleaning, chemical cleaning and then application of a corrosive inhibiting zinc coating before the final powder coat. Uniformly apply powder coating by the electrostatic method and then oven-cure at 400 degrees F to chemically bond the finish. All fabrication including cutting, coping, grinding and welding shall be completed prior to application of corrosion inhibiting agent. Colors: As selected by Project Architect.

The powder coating shall comply with ASTM standards as follows:

Adhesion cross hatching test	D-3359B
Flexibility conical mandrel	D-522
Pencil hardness test	D-3363
	(H-2H)
Impact resistance test	D-2794
Overbake resistance test	D-2454
Salt spray resistance test	B-117
Abrasion resistance test	D-4060
	(Mod)

Alum Frame: Clear Satin  
FRP Door: Standard Green

