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Finish Specification

Finish	Powder coat
Colour	Dark Grey
Gloss	—
Texture	textured
Film thickness (DFT)	70.0 um (60.0 - 90.0)
Pretreatment	—
Cure	—
Adhesion class	—
Standard	Powder coat, dark grey textured
Powder density	—
Transfer efficiency	—

Parts Covered

Part	Qty	Area (m2)	Powder (kg)
Exterior Support Tube	26	1.300	
Base	59	1.505	
Interior Support Tube	33	1.012	
Exterior Vertical Tube	2	0.899	
Internal Vertical Tube	9	4.239	
Column Left Lateral Tube	2	0.077	
Column Right Lateral Tube	2	0.077	
Column Left Connection Tube	2	0.062	
Column Vertical Tube	2	0.299	
Column Right Connection Tube	2	0.062	
TOTAL coated area		9.530	

Readings — filled in at the coater

Characteristic	Specified	Reading	OK / NG
DFT point 1	60.0 - 90.0 um		
DFT point 2	60.0 - 90.0 um		
DFT point 3	60.0 - 90.0 um		
DFT point 4	60.0 - 90.0 um		
DFT point 5	60.0 - 90.0 um		
Gloss	—		
Colour match	Dark Grey		
Adhesion	—		
Coverage	No bare metal, runs or orange peel		

1. FILM THICKNESS IS MEASURED ON THE PART, NOT ON A TEST PANEL. TAKE THE READINGS ON THE LARGEST FLAT FACE AND ON ONE INSIDE CORNER.

2. THE POWDER FIGURE PER PART IS WHAT ENDS UP ON THE PART (AREA x FILM THICKNESS x DENSITY). WHAT IS SPRAYED IS MORE — COMPARE ACTUAL CONSUMPTION AGAINST THE ISSUE ROW.

3. THE READINGS ARE TAKEN AND SIGNED AT THE COATER, BEFORE THE PARTS SHIP.

4. A PART OUT OF THE THICKNESS RANGE OR FAILING ADHESION IS STRIPPED AND RECOATED — NOT TOUCHED UP.

5. NUMBERED CHARACTERISTICS ARE THE INSPECTION CONTRACT.

6. DO NOT SCALE FROM THIS DRAWING — THE DIMENSIONS GOVERN. POWDER MASS NOT CALCULATED — NO POWDER DENSITY ON THE SPECIFICATION. A POWDER RUNS 1.2 TO 1.8 g/cm3; ASK THE SUPPLIER RATHER THAN ASSUMING ONE.

Dept.

QA

Technical reference

+/- 0.5mm

Created by

AG

Weight

8/10/26

Thickness

Document type

Inspection - Finishing

Title

Tube Frame

Finish

Material

DWG No.

TF-FIN

Rev.

1

Date of issue

08/10/2026

Sheet

1/1

PRODUCT INTELLIGENCE

A

B

C

D

E

F

A

B

C

D

E

F