

	<b>Title:</b>	Coating Standard – Wausau Tile	<b>Date</b>	<b>Rev</b>	<b>Document #</b>
	<b>Author:</b>	Dan Siebert	11/9/2020	E	Coating Standard
	<b>Approval:</b>	Mark Rounds	<b>Position:</b>	Corporate Sales Director	

**1.0 PURPOSE**

To define the standard for coating of steel, galvanized steel, and aluminum products.

**2.1 Scope**

To establish coating standards for the following material conditions:

- Mild Steel (Steel)
- Galvanized Steel
- Aluminum

**3.0 Authority and Responsibility**

Mark Rounds – Corporate Sales Director

**4.1 Wausau Tile Standards**

Coating Type:

- Epoxy Primer on Steel – a thermoset epoxy coating applied 1.5 to 3 mils thick. The primer must be compatible with TGIC and TGIC free polyester super durable topcoats.
- E-Coat Primer on Steel (or Electrocoat) – a thermoset epoxy coating applied .5 to 1.5 mils thick. The e-coating must be compatible with TGIC and TGIC free polyester super durable topcoats.
- Topcoat on Steel – using a thermoset polyester, TGIC or TGIC free super durable coating applied 2 to 4 mils thick. The topcoat must meet AAMA 2603-02 standards.
- Topcoat with Epoxy Primer on Steel – must have a minimum combined thickness of 4 mils.
- Topcoat with E-coat Primer on Steel – must have a minimum combined thickness of 3.1 mils.
- Topcoat on Galvanized Steel – using a thermoset polyester, TGIC or TGIC free super durable coating applied 1.5 to 3.5 mils thick. The topcoat must meet AAMA 2603-02 standards.
- Topcoat on Aluminum – using a thermoset polyester, TGIC or TGIC free super durable coating applied 1.5 to 3.5 mils thick. The topcoat must meet AAMA 2603-02 standards.
- Thermo Plastic on Steel– a thermoplastic coating applied 24 to 36 mils thick.

**5.0 Process**

Coating vendor is responsible for proper cleaning and surface preparation, to insure adhesion of coating to base material. All coating must comply with Wausau Tile’s testing procedures.

Wausau Tile will give color instructions for each product when the purchase order is placed.

Revision:	Date:	Revision By:	Description:
A	03-05-2014	Dan Siebert	Initial Write up
B	05-20-2014	Dan Siebert	Changed coating thicknesses
C	11-26-2014	Dan Siebert	Added Galvanized Steel Specification
D	03-19-2018	Dan Siebert	Revised E-Coat (Electrocoat) standards
E	11-9-2020	Mark Rounds	Revised epoxy coating mil thickness