

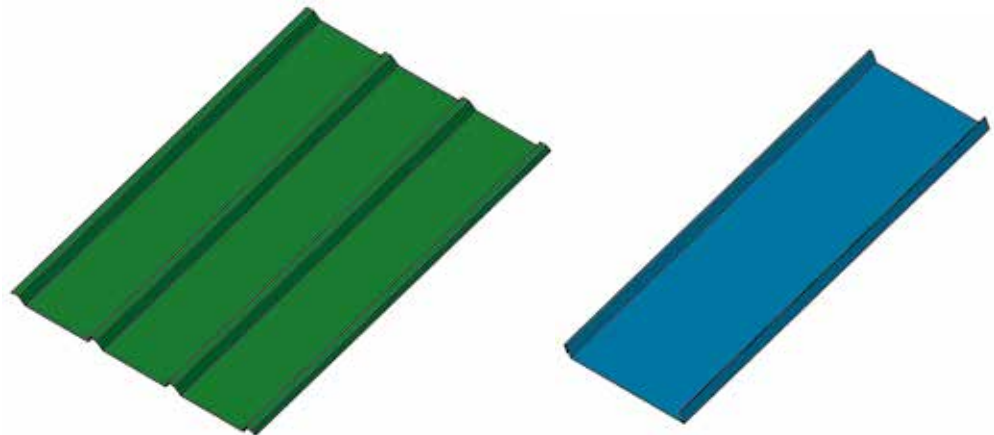
colors

**A** pallet of colors is available for steel frame finishes and metal roof panels.

**P**owder coat colors for the steel frame



**K**ynar 500 colors for 24 ga. metal roofing

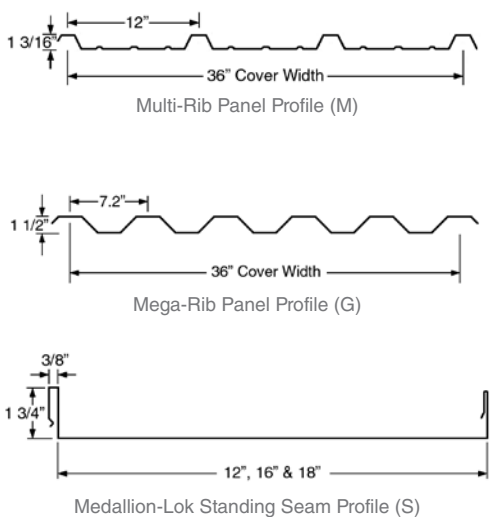


# roof options



*24 Ga. Steel Panels*

24-gauge galvalume roof panels with a Kynar 500 paint finish. Multi-Rib and Mega-Rib are 36" wide panels that are pre-cut in our factory to fit your shelter. Field adjustment may be necessary for proper fit. Medallion-Lok standing seam roofing is provided uncut to be cut to fit in the field by others. Matching trim in 26 ga. galvalume and fasteners are provided.



*Pre-Cut SIPs*

Structural panels (SIPs) are factory-assembled, 4-5/8" thick, laminated and cut to fit on the structure. The composition is 7/16" OSB, 3-1/2" EPS foam core, and a 5/8" skin of T1-11 siding.

### *Standard Steel Roof Colors*

Kynar 500 coated roof panels with 24 guage Galvalume® substrate



Notes:  
 \*Roman Blue in Medallion-Lok may incur extra costs.  
 \*\*Galvalume Plus is not Kynar 500 coated.



*2x6 Tongue and Groove*

The 2x6 tongue and groove wood roof deck is Western Lodgepole Pine, kiln dried, #2 or better, one edge V'd, one edge grooved. Fascia is cedar plank. T&G requires finished roofing materials.

*Actual colors may vary from printed samples*



# frame options



*Prime Painted*



*Hot Dipped Galvanized*



*E-Coat and Powder Coat*

Factory-priming protects the steel components from corrosion throughout the shipping and erection process. The steel is cleaned to remove loose mill scale, loose rust, loose paint, and other loose detrimental foreign matter. The cleaned steel will then be prime painted with quick dry, lead and chromate free alkyd primer. Finish painting in the field is required.

The hot-dip galvanizing process produces a zinc coating on steel products by immersion of the material in a bath of molten zinc metal. The steel to be coated is first cleaned to remove all oils, greases, soils, mill scale and rust. Because galvanized steel requires no maintenance for decades, its use in public construction is an efficient use of public funds.

ICON's premier steel coating is a combination of liquid epoxy primer and two coats of TGIC polyester powder coating. The process is:

1. The steel is shot-blasted to the specification of SSPC-SP10 (shot-blasted to near white condition), removing all oil residue, mill scale, weld spatter and slag.
2. The steel is immersed in zinc phosphate in an eight stage pretreatment process.
3. It is immersed in an electrostatically applied liquid epoxy and coated to a uniform 0.7-0.9 mils. This E-coat totally encapsulates the part, preventing rusting.
4. A double coat of TGIC polyester powder is applied, one coat of color and one clear coating for a final finish that is 8-12 mils thick.

## *Powder Coat Colors*

(Actual colors may vary from printed samples)



ICON can coat your shelter with powders chosen from the RAL color chart. Shown are several RAL colors (\$\$) that have been popular on ICON projects recently. Actual colors may vary from printed samples. Please request actual color samples.

**SELECTING AN RAL COLOR FROM THIS CHART WILL INCUR ADDED COSTS.**

In highly corrosive environments, ICON recommends a hot-dipped zinc galvanizing prior to powder coating. This may produce a less smooth finish once coated.

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# standard steel frame powder coat finish

No matter how much design savvy and expertise is put into the fabrication of your steel structure, it all comes to nothing if the finish doesn't hold up to the elements. The standard steel frame finish for all ICON shelters is a TGIC powder coat over a durable electro-coat primer. The process is described as follows:

1. The steel shall be shot-blasted to the specification of SSPC-SP10 (shot-blasted to near white condition), this will remove all oil residue, mill scale, weld spatter and slag.
2. The steel is washed and zinc phosphated in an eight stage electro deposition (E-coat) pretreatment process.
3. It is immersed in an electro-statically applied liquid epoxy and coated to a uniform 0.7-0.9 mils. This E-coat totally encapsulates the part, preventing rusting.
4. A double coat of TGIC polyester powder is applied, one coat of color and one clear coating for a final finish that is 8-12 mils thick.
5. All materials shall be inspected to meet 100% coating, proper cure, film thickness and impact resistance.
6. Color to be selected from the manufacturer's standard color chart.

In highly corrosive environments, ICON recommends that the steel frame receive a hot-dipped zinc galvanizing prior to finish. While this may provide a less than smooth finish once coated, the galvanizing will provide added protection against corrosion in coastal areas where salt spray is in the air.

ICON Shelter Systems, Inc. offers the best, most durable finish in the industry. The way we figure, it's easier to produce a benchmark product than it is to justify cutting corners.