



**Standard  
and  
Coastal**



**Sternberg Lighting is a market leading manufacturer of decorative outdoor lighting with a legacy of durability and craftsmanship dating back to the company's founding in 1923.**

Our luminaires and smart city solutions are featured design elements throughout downtowns, parks, campuses, roadways and retail centers across North America, serving the Municipal, Utility, DOT and Commercial markets. Designed and manufactured to demanding quality standards, all of our products integrate rugged cast, spun or extruded aluminum materials.

**How do our products last through the service life of 20 years or greater without corrosion and serious degradation of the aluminum substrate and structure?**

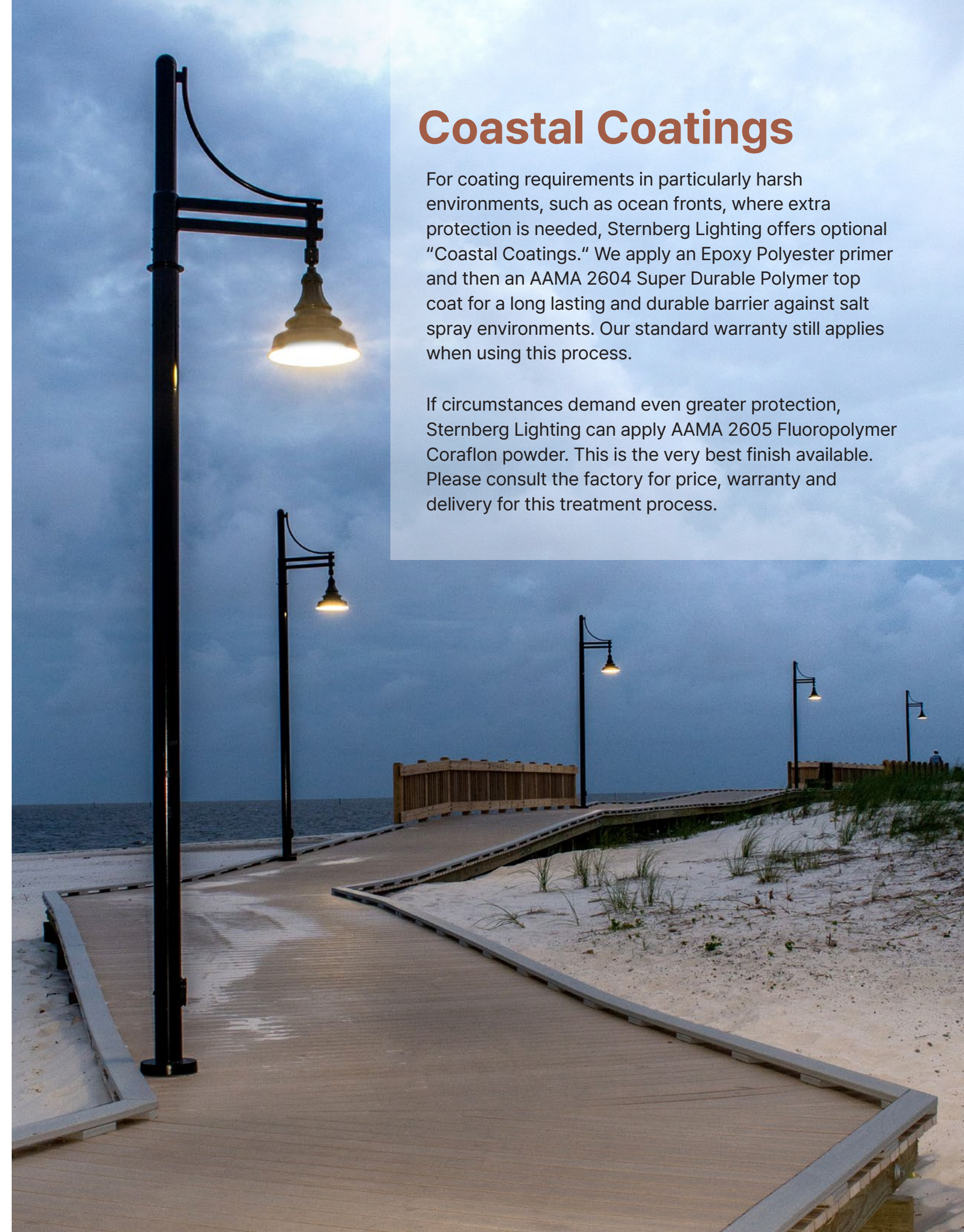
The answer is Sternberg's Polyester Powder Coat system. We apply the highest quality coatings in the industry over pre-treated aluminum. Our coating processes are used to protect fabricated lighting equipment in normal four season environments, harsh northern and desert climates, as well as punishing coastal ocean applications.



## Coastal Coatings

For coating requirements in particularly harsh environments, such as ocean fronts, where extra protection is needed, Sternberg Lighting offers optional "Coastal Coatings." We apply an Epoxy Polyester primer and then an AAMA 2604 Super Durable Polymer top coat for a long lasting and durable barrier against salt spray environments. Our standard warranty still applies when using this process.

If circumstances demand even greater protection, Sternberg Lighting can apply AAMA 2605 Fluoropolymer Coraflon powder. This is the very best finish available. Please consult the factory for price, warranty and delivery for this treatment process.





# Sternberg Coating Process

## Stage I

All products to be coated shall receive a 96 second alkaline cleaner application followed by a fresh water rinse at ambient temperature.

## Stage II

A 60 second iron phosphate solution treatment is added with a fluoride accelerant followed by a 48 second reverse osmosis water rinse at ambient temperature. The rinse is followed by a high pressure air spray to remove all moisture from the product.

## Stage III

48 second non-chrome polymer sealer is applied.

## Stage IV

16 minutes in a drying oven at 400 degrees.

## Stage V

The electrostatic application of polyester powder is applied in a spray booth by automated articulating robotic arm sprayers and application technicians. Polyester powder overspray is recoverable and reusable.

## Stage VI

25 minutes in curing oven at 450 degrees to cure the powder application creating a hard, durable finish. Final appearance is achieved in this step, ie gloss, texturing, etc. Curing is followed by 9.5 minutes in a cooling tunnel prior to un-racking.

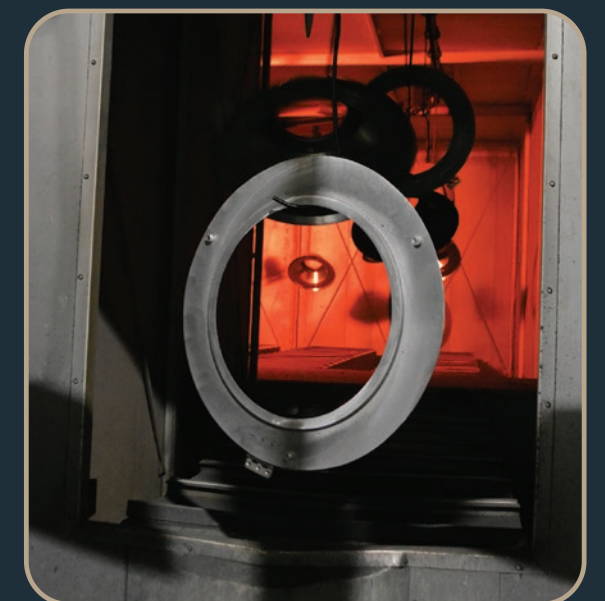
## Inspection

After cooling and un-racking, each part is inspected for quality and consistency before being released for shipment. Quality tests include:

- Cross hatch for adhesion
- Solvent rub for proper curing

Testing of finished product is also done at the powder manufacturer. Tests include:

- Fade Test —  $< 5.0 \Delta E$
- Gloss Retention — 60% for five years
- Salt Spray — AAMA 2604 5 years, 3,000 hours  
— AAMA 2605 10 years 4,000 hours



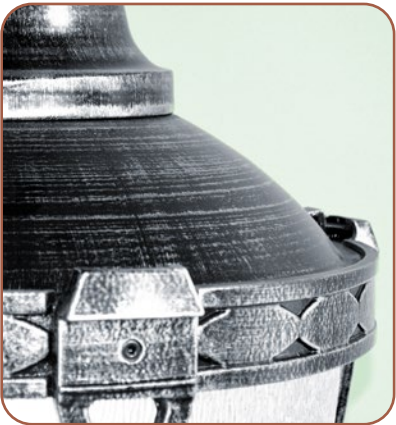




Our famous Verde Green and Swedish Iron Coatings are hand painted right in our Sternberg Lighting factory, just as we have been doing for decades.



Verde Green



Swedish Iron

Sample of Custom Finishes



Rust



Old Iron

Sternberg Color Finishes

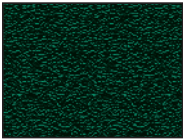
Standard Finishes Traditional Products



**BKT**  
Black Textured



**WHT**  
White Textured



**PGT**  
Park Green Textured

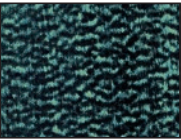


**ABZT**  
Arch. Medium Bronze Textured



**DBT**  
Dark Bronze Textured

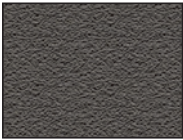
Select Finishes Traditional Products



**VG**  
Verde Green



**SI**  
Swedish Iron

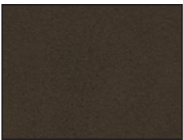


**OWGT**  
Old World Gray Textured

Urban Standard Finishes Urban and Contemporary Products



**BKT**  
Black Textured



**UB**  
Bronze Matte



**UBT**  
Bronze Textured



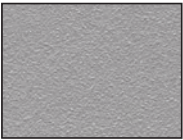
**UWH**  
White Matte



**UWHT**  
White Textured



**USL**  
Silver Matte



**USLT**  
Silver Textured



**UGM**  
Gun Metal Matte



**UGMT**  
Gun Metal Textured

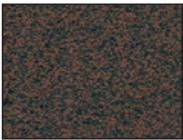
Custom Finishes All Products – Consult Factory For Pricing & Availability



**OI**  
Old Iron



**RT**  
Rust



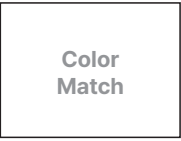
**WBR**  
Weathered Brown



**CD**  
Cedar



**WBK**  
Weathered Black



**CM**  
Custom Match



**TT**  
Two Tone

Smooth finishes available on request.  
All colors are approximate and may have a slight variation.



# Sternberg's 5 Year Coatings Promise For ALUMINUM Products



1. Our coatings will meet or exceed municipal and roadway requirements for street and area lighting equipment.
2. Our unique processes will guard against color fading of more than five (5) units as measured by the Hunter L\*A\*B\* color difference set forth in ASTM D523 using 60 degree readings.
3. Our coatings will retain a minimum of 60% of its original gloss as measured in accordance with ASTM D523.
4. Our coatings will not chalk in excess of the standard number 8 rating for colors and number 6 for whites illustrated in the ASTM D4214 test method A.
5. Our coatings and substrate will not corrode nor show lack of adhesion.

Please see our web site for complete finish warranty details.



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