**No. 2720 *Humboldt* Bench with Armrest.**

Seat shall be TimberForm® *Humboldt*™ series model No. 2720 with armrests, in the length and color finish selected by the owner's representative and in the quantity shown on the bill of materials or the project drawings. Manufacturer, Columbia Cascade Company, [www.timberform.com](http://www.timberform.com), Phone 800/547-1940

1. **Materials**

Bench frame with armrest shall be fabricated from 3/8 inch thick mild steel plate. Mounting shall be (-E) embedment or (-P) pedestal (fixed surface). Pedestal frame shall include four 5/8 inch diameter holes for anchoring devices (by others).

Wood slats shall be kiln-dried, premium Alaska yellow cedar or Ipé hardwood. There shall be no loose knots nor knotholes. To eliminate slivering, slats shall be free of wane, smoothly dressed four sides to a nominal size of 2 inch x 3 inch, and have their edges and ends heavily eased.

**2. Construction**

Each bench frame shall be assembled and welded into a single unit. Welds shall be smooth and continuous with no gaps or pin holes. Final product shall be free of weld spatters and burrs. Slats shall attach to frame with stainless steel pan head screws.

**3. Finish**

Steel parts shall be color finished with CASPAX-7™, a tough, opaque, UV resistant exterior grade polyester powder coating applied to a minimum thickness of 6 mils. *Liquid, epoxy or lead-containing powder coatings are not acceptable.*

Preparation of the mild steel substrate shall incorporate the phosphate system. Substrate preparation shall consist first of mechanical cleaning to remove heavy mill scale, rust, varnish, grease, etc., with surfaces uniformly abraded to promote quality of finish coating. Chemical cleaning in accordance with TT-C-490C, Methods I and III shall remove impurities from the surfaces.

After the two-step cleaning process, the metal substrate shall receive a corrosion-inhibiting iron phosphate pre-coating in accordance with TT-C-490C, Type II, prior to the application of the powder color coat. The color coating shall be applied by the electrostatic method and then oven-cured at 400 degrees Fahrenheit to chemically bond the coating to the substrate and to render the coated metal resistant to abrasion, impact, chipping, weathering, and rusting.