



Specification Guide

Hot Mix Asphalt



SPECIFICATION GUIDE

Hot Mix Asphalt

Table of Contents

	Page
Introduction	
▪ Identifying painting requirements	3
▪ How do I use this specification guide	3
▪ Contacting my local Axalta Representative	3
Paint Selection	
▪ Identifying the correct paint system	4
▪ Table I- Hot Mix Asphalt Equipment Specification (Equipment in POOR Condition-Long Term Durability)	5
▪ Table II- Hot Mix Asphalt Equipment Specification (Equipment in Fair to Good Condition)	6
▪ Table III- Hot Mix Asphalt Equipment Specification (Equipment in Good Condition-Color Change Only)	7
▪ Table IV- Truck, Rolling Stock and Misc. Equipment Specification (Axalta General Industrial Solid Color)	8
▪ Table V- Truck, Rolling Stock and Misc. Equipment Specification (Cromax™ Metallic Color)	9
▪ Table VI- Asphalt Batch Plant Specification (Equipment in Good Condition-color change or upgrade)	10
▪ Table VII- Description of recommended products	11-16
Painting	
▪ Surface preparation description by substrate	17
▪ Methods of paint application	18-19
Color	
▪ Color code paint schemes	20-21

SPECIFICATION GUIDE

Hot Mix Asphalt

Introduction

We have prepared this specification guide for Hot Mix Asphalt based on our analysis of your new construction and maintenance painting needs. In studying your industry, we have found that you would prefer a simplified approach to painting. An approach that would keep your Hot Mix Asphalt equipment in good condition, easy to clean and maintain, simplify your paint selection, minimize painting problems, and above all, give you the greatest value for your painting dollars.

Axalta's approach also addresses your health, safety, and environmental permitting needs. In addition to the systems mentioned in this guide, custom designed systems that meet and/or exceed your local air regulatory agency requirements are also available. Detailed information may be obtained by contacting your authorized Axalta Coating Systems distributor for evaluation. Your authorized Axalta Coating Systems distributor stands ready to work with you in handling all your paint and painting problems. If, however, you prefer to manage your own maintenance program, you can by following the information given in this guide.

The topics covered in this specification guide include selecting the right paint for each job, preparing surfaces for painting, simplified painting techniques and helpful ways to use color.

Copies of product literature for all the products specified in this guide are available from our web site, axalta.us. This information, plus that given in Section II (Paint Selection), will help you in ordering the right products for your painting.

To use these specifications, simply refer to the appropriate Section. All information normally required for maintenance painting can be found there. Should you need further information, please contact your authorized Axalta Coating Systems Distributor, who is ready to assist you in all phases of your painting. The authorized Axalta Coating Systems in your area can be found on our website, axalta.us or by calling toll-free:

1 855 6 AXALTA

****NOTE: The information contained in this guide supersedes any prior product recommendations.****

SPECIFICATION GUIDE

Hot Mix Asphalt

Paint Selection

Paint Selection - The “Paint System” Approach

The simplified approach to painting Hot Mix Asphalt Equipment is the use of a “paint system” designed for your equipment. A “paint system” is the proper combination of (1) surface preparation, (2) paint products and (3) application for a given surface. These three elements play an important role in the most economical performance of finishes for your equipment.

We have selected system recommendations for each application that you are likely to encounter. Our Hot Mix Asphalt Equipment repaint systems are focused on:

1. Equipment that will be abrasive blast cleaned to SSPC-SP 6 Commercial condition prior to repainting. This paint system will have the most long-term durability.
2. Equipment that has painted surfaces in fair to good condition that requires some form of surface preparation, spot priming prior to repainting the existing painted surface. This equipment is generally in good condition but has some areas that require Hand and Power Tool Cleaning: SSPC-SP-2/3, prior to repainting.
3. Equipment that is in good condition and requires cleaning to remove all greases and oils and scuff sanding prior to painting. This equipment will be repainted for appearance only, and includes repainting of equipment that will be rented, sold at auction, or where owner has requested a color change.

Select the appropriate painting system for Hot Mix Asphalt Equipment to be painted from Tables I -VII according to the current condition. You will find a brief description, as well as application information and dry times for each of the products referenced in the Product Descriptions Table VIII.

SPECIFICATION GUIDE

Hot Mix Asphalt

TABLE I
PAINT SPECIFICATIONS FOR:
ASPHALT EQUIPMENT REPAINT
(Equipment in POOR Condition-Long Term Durability)

EQUIPMENT TO BE PAINTED	SURFACE PREPARATION	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Misc. asphalt Equipment, pavers, cutters, reclaimer, pug mixers, profiler, stabilizer	Steel preparation: SSPC SP-6 Commercial blast cleaned.	Good	Topcoat: Imron® 2.1 HG-D™ + (4-5)	New High gloss polyurethane DTM
		Better	Primer: Corlar® 2.1 PR-P™ (3-4) Topcoat: Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	Fast dry smooth epoxy primer. New High gloss polyurethane topcoat New High gloss polyurethane topcoat
		Best	Primer: Corlar® 2.1 ST™ (4-5) Topcoat: Imron® Industrial Strength (2-3) Or Imron® Industrial Strength Reduced Gloss Topcoat (2-3) or Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3) Clearcoat: Imron® EZ-3460S™ (1.8-2)	High solids epoxy mastic Ultra Low VOC High Gloss Polyurethane Ultra Low VOC (0.3) Reduced Gloss Polyurethane Enamel Topcoat New High gloss polyurethane topcoat New High gloss polyurethane topcoat High gloss easy to clean polyurethane clearcoat

SPECIFICATION GUIDE

Hot Mix Asphalt

TABLE II
PAINT SPECIFICATIONS FOR:
ASPHALT EQUIPMENT REPAINT
(Equipment in FAIR TO GOOD condition.)

EQUIPMENT TO BE PAINTED	SURFACE PREPARATION	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Misc. asphalt Equipment, pavers, cutters, reclaimer, pug mixers, profiler, stabilizer	Steel preparation: Water Wash 1000 psi SSPC SP-2 or 3 Hand or power tool cleaned. Product may be applied over marginally prepared substrates with some reduced performance. For best results, good surface preparation practices to remove all rust and corrosion should be done	Good	Topcoat: Imron® 2.1 HG-D™ + (4-5)	New High gloss polyurethane DTM
		Better	Primer: Tufcote® 3.3 PR™ (3-4) or Imron® Industrial Strength Low VOC Polyurethane Primer (3-5) Topcoat: Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	Fast dry universal alkyd primer High Solids Low VOC Polyurethane Primer New High gloss polyurethane topcoat New High gloss polyurethane topcoat
		Best	Primer: Corlar® 2.1 PR-P™ (3-4) Topcoat: Imron® Industrial Strength (2-3) or Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3) Clearcoat: Imron® EZ-3460S™ (1.8-2)	Fast dry smooth epoxy primer Ultra Low VOC High Gloss Polyurethane Topcoat New High gloss polyurethane topcoat New High gloss polyurethane topcoat High gloss, easy to clean polyurethane clearcoat

Note: For application over marginally primed surfaces, Corlar® 2.1 ST™ may also be substituted for the best condition.

SPECIFICATION GUIDE

Hot Mix Asphalt

TABLE III
PAINT SPECIFICATIONS FOR:
ASPHALT EQUIPMENT REPAINT
(Painted equipment in GOOD condition)
(Equipment that will be rented, sold at auction, color change/upgrade)

EQUIPMENT TO BE PAINTED	SURFACE PREPARATION	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Misc. asphalt Equipment, pavers, cutters, reclaimer, pug mixers, profiler, stabilizer	Previously painted surface in good condition. Surface preparation is a solvent wipe and/or detergent clean to SSPC-SP1 to remove all greases and oils prior to painting. Surfaces should be scuff sanded.	Good	Topcoat: Tufcote® 3.5 HG-D™ (2-3) (Spot primer required if paint film broken to steel substrate.)	Gloss alkyd enamel topcoat
		Better	Topcoat: Imron® 2.1 HG-D™ + (2-3)	New High gloss polyurethane DTM
		Best	Primer: Corlar® 2.1 PR-P™ (2-3) Topcoat: Imron® Industrial Strength (2-3) or Imron® Industrial Strength Reduced Gloss Topcoat (2-3) Or Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3) or Imron® 2.1 HG-D™ + (5)	Fast dry smooth epoxy primer Ultra Low VOC High Gloss Polyurethane Topcoat Ultra Low VOC (0.3) Reduced Gloss Polyurethane Enamel Topcoat New High gloss polyurethane topcoat New High gloss polyurethane topcoat New High gloss polyurethane DTM

SPECIFICATION GUIDE
Hot Mix Asphalt
TABLE IV
PAINT SPECIFICATIONS FOR:
BULK HAUL / ROLLING EQUIPMENT REPAINT
(Axalta Coating Systems | General Industrial - Solid Colors)

EQUIPMENT TO BE PAINTED	SURFACE PREPARATION	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Fiberglass	Fiberglass	Good	Primer: Imron® 1.5 ST-D™ (3-4) Topcoat: Imron® 1.2 HG™ (2-3)	Waterborne polyurethane copolymer Primer Waterborne polyurethane copolymer topcoat
		Better	Primer: Corlar® 2.1 PR-P™ (2-3) or Imron® Industrial Strength Low VOC Polyurethane Primer (3-5) Topcoat: Imron® 2.1+ or 3.5 +	High production epoxy primer-sealer High Solids Low VOC Polyurethane Primer New High gloss polyurethane enamel
		Best	Primer: Corlar® 2.1 PR-P™ (2-3) Topcoat: Imron® Industrial Strength (2-3) Or Imron® Industrial Strength Reduced Gloss Topcoat (2-3) or Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3) Clearcoat: Imron® EZ-3460S™ (1.8-2.0)	High production epoxy primer-sealer Ultra Low VOC High Gloss Polyurethane topcoat Ultra Low VOC (0.3) Reduced Gloss Polyurethane Enamel Topcoat New high gloss polyurethane topcoat New high gloss polyurethane topcoat High gloss, easy to clean polyurethane clearcoat
Sheet Metal	Carbon Steel	Good	Primer: Imron® 1.5 ST-D™ (3-4) Topcoat: Imron® 1.2 HG™ (2-3)	Waterborne polyurethane copolymer primer Waterborne polyurethane copolymer topcoat
		Better	Primer: Corlar® 2.1 PR-P™ (3-4) or Imron® Industrial Strength Low VOC Polyurethane Primer (3-5) Topcoat: Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	High production epoxy primer-sealer High Solids Low VOC Polyurethane Primer New high gloss polyurethane topcoat New high gloss polyurethane topcoat
		Best	Primer: Corlar® 2.1 ST™ (4-5) Topcoat: Imron® Industrial Strength (2-3) or Imron® Industrial Strength Reduced Gloss Topcoat (2-3) or Imron® 2.1 HG™ + (1.5-2) Clearcoat: Imron® EZ-3460S™ (1.8-2)	Epoxy mastic primer Ultra Low VOC High Gloss Polyurethane topcoat Ultra Low VOC (0.3) Reduced Gloss Polyurethane Enamel Topcoat New high gloss polyurethane topcoat High gloss, easy to clean polyurethane clearcoat

SPECIFICATION GUIDE

Hot Mix Asphalt

TABLE V
PAINT SPECIFICATIONS FOR:
BULK HAUL / ROLLING EQUIPMENT REPAINT
(Axalta Coating Systems - Metallic Colors)

EQUIPMENT TO BE PAINTED	SURFACE PREPARATION	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Fiberglass Cab	Fiberglass	Better	Primer: Imron® Industrial Strength Low VOC Polyurethane Primer (2.0) Topcoat: Rival™ RV28 or RV35 (2.0)	VOC conforming, 0.8 lbs/ gallon primer 2.8 or 3.5 VOC single stage polyurethane enamel
		Best	Primer: Uro® 1380S™ Topcoat: Imron® Elite Productive Single Stage "EX" (1.8-2.2) or Imron® Elite Productive "EW" (1.0-1.5) Imron® 8821S clearcoat (2.0)	2.1 VOC Urethane primer-filler 2.8 or 3.5 VOC polyurethane enamel single stage topcoat 3.5 HS polyurethane basecoat 2.1 polyurethane clearcoat
Sheet Metal, Steel & Chassis	Carbon Steel	Better	Primer: Imron® Industrial Strength Low VOC Polyurethane Primer (2.0) Topcoat: Rival™ RV28 or RV35 (2.0)	VOC conforming, 0.8 lbs/ gallon primer 2.8 or 3.5 VOC single stage polyurethane enamel
		Best	Primer: Corlar® 921S™ (1.8) Topcoat: Imron® Elite Productive Single Stage "EX" (1.8-2.2) Imron® Elite Productive "EW" (1.0-1.5) Imron® 8821S clear coat (2.0)	2.1 VOC Epoxy polyamide primer 2.8 or 3.5 VOC polyurethane enamel single stage topcoat 3.5 HS polyurethane basecoat 2.1 polyurethane clearcoat

SPECIFICATION GUIDE

Hot Mix Asphalt

TABLE VI PAINT SPECIFICATIONS FOR: ASPHALT BATCH PLANT REPAINT

EQUIPMENT TO BE PAINTED	SURFACE PREPARATION	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Kiln, stacks and ducts - High Heat up to 450 degrees F -	Steel preparation: SSPC SP-6 Commercial blast cleaned.	Best	Primer: Corlar® 2.1 HTA™ (5-6)	Epoxy mastic Primer/Finish in Aluminum color
Conveyors, bins, silos, mix hoppers, piping, structural steel.	Steel preparation: SSPC SP-6 Commercial blast cleaned.	Good	Topcoat: Imron® 2.1 HG-D™ + (4-5)	New High gloss polyurethane DTM.
		Better	Primer: Corlar® 2.1 PR-P™ (3-4) Topcoat: Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	Fast dry smooth epoxy primer. New high gloss polyurethane topcoat New high gloss polyurethane topcoat
		Best	Primer: Corlar® 2.1 ST™ (5-6) Topcoat: Imron® Industrial Strength (2-3) or Imron® Industrial Strength Reduced Gloss Topcoat (2-3) or Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2.0-3)	Epoxy mastic primer Ultra Low VOC High Gloss Polyurethane topcoat Ultra Low VOC (0.3) Reduced Gloss Polyurethane Enamel Topcoat New high gloss polyurethane topcoat New high gloss polyurethane topcoat
Walls	Concrete, Masonry, Stone	Good	Primer: Tufcote® 1.9 HG-D™ (Fill) Topcoat: Imron® 1.2 HG™ (2-3)	Waterborne acrylic DTM enamel Waterborne polyurethane copolymer topcoat
		Better	Primer: Tufcote® 1.9 HG-D™ (Fill) Topcoat: Imron® 2.1HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	Waterborne acrylic DTM enamel New high gloss polyurethane topcoat New high gloss polyurethane topcoat
		Best	Primer: Corlar® LV SG™ (Fill) Topcoat: Imron® Industrial Strength (2-3) or Imron® Industrial Strength Reduced Gloss Topcoat (2-3) or Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	Very high solids epoxy mastic Ultra Low VOC High Gloss Polyurethane topcoat Ultra Low VOC (0.3) Reduced Gloss Polyurethane Enamel Topcoat New high gloss polyurethane topcoat New high gloss polyurethane topcoat

SPECIFICATION GUIDE

Hot Mix Asphalt

TABLE VII PRODUCT DESCRIPTIONS PRIMERS, FINISH & DIRECT TO METALS

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® Industrial Strength Ultra Low VOC Polyurethane Enamel	Next generation polyurethane with High Gloss , 0.3 VOC, improved adhesion & productivity with outstanding gloss & color retention.	Imron 9TXX 9T00-A™ Activator See PDS for application thinner details.	4 Parts 9TXX Color 1 Part 9T00-A Activator See PDS for application thinner details.	Brush, roll or spray 3-5 mils wet 2-3 mils dry	Dry to touch 1 hr. Dry to handle 2 hr. Dry to Recoat 2 hr.
Imron® Industrial Strength Ultra Low VOC Polyurethane Enamel	Next generation polyurethane Reduced Gloss , 0.3 VOC, improved adhesion & productivity with outstanding color retention.	Imron 9TXX 9T00-A™ Activator See PDS for application thinner details.	8 Parts 9TXX Color 1 Part 9T00-A Activator See PDS for application thinner details.	Brush, roll or spray 3-5 mils wet 2-3 mils dry	Dry to touch 1 hr. Dry to handle 2 hr. Dry to Recoat 2 hr.
Imron® 1.2 HG™	A high performance, low VOC, no HAPS, quick dry waterborne polyurethane copolymer designed for use over Imron® 1.5 PR primer.	Single component	Ready to Spray * see PDS	Spray is preferred. 5-7 mils wet 2-3 mils dry	Dry to touch 20-30 minutes Dry to handle 1 hour Dry to recoat 30 minutes Hard Dry 2 hours
Imron® 2.1 HG™ + High Gloss Polyurethane	New Imron® technology delivering a high solids, high gloss two-package, 2.1 lbs/gal VOC, extremely durable finish with outstanding chemical resistance, abrasion resistance & flexibility as well as outstanding gloss & color retention.	Imron® 2.1 HG™ + Color 9T00-A™ Activator See PDS for application thinner details. Brush & Roll Additive: 9M05™	3 Parts Color 1 Part Activator 0 to 10% Reducer. Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 2 - 3 mils wet 1.5 - 2.0 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805™ *See product data sheet.

SPECIFICATION GUIDE
Hot Mix Asphalt
TABLE VII
PRODUCT DESCRIPTIONS
PRIMERS, FINISH & DIRECT TO METALS

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® 2.1 + Reduced Gloss Polyurethane	New Imron® technology delivering a high solids, reduced gloss two-package 2.1 lbs/gal VOC, extremely durable finish with outstanding chemical resistance, abrasion resistance & flexibility as well as outstanding gloss & color retention. Available in variable gloss levels: semi gloss, satin and flat.	Imron® 2.1 + Color 9T00-A™ Activator 9T20™ Flattener See PDS for application thinner details. Brush & Roll Additive: 9M05™	6 Parts Color 1 Part Activator 0 to 10% Reducer. Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 2 - 3 mils wet 1.5 - 2.0 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805™ *See product data sheet.
Imron® 3.5 HG™ + High Gloss Polyurethane	New Imron® technology delivering a high solids two-package, high gloss , 3.5 lbs/gal VOC with low HAPS polyurethane enamel. Extremely durable finish delivers outstanding chemical resistance, abrasion resistance & flexibility with outstanding gloss & color retention.	Imron® 3.5 HG™ + Color 9T00-A™ Activator See PDS for application thinner details. Brush & Roll Additive: 9M05™	4 Parts Color 1 Part Activator 0 to 5% Reducer Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 3 - 5 mils wet 2 - 3 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805. *See product data sheet.
Imron® 3.5 + Reduced Gloss Polyurethane Available in variable gloss levels: semi gloss, satin and flat	New Imron® technology delivering a high solids two-package, reduced gloss , 3.5 lbs/gal VOC with low HAPS polyurethane enamel. Extremely durable finish delivers outstanding chemical resistance, abrasion resistance & flexibility with outstanding gloss & color retention.	Imron® 3.5 + Color 9T00-A™ Activator 9T20™ Flattener See PDS for application thinner details. Brush & Roll Additive: 9M05™	8 Parts Color 1 Part Activator 0 to 5% Reducer Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 3 - 5 mils wet 2 - 3 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805. *See product data sheet.

SPECIFICATION GUIDE Hot Mix Asphalt

TABLE VII PRODUCT DESCRIPTIONS PRIMERS, FINISH & DIRECT TO METALS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® 2.1 HG-D™ + High Gloss DTM	New Imron® technology DTM high gloss, high build, two-package, low HAPS, acrylic polyurethane.	Imron® 2.1 HG-D™ + 9T00-A™ Activator	6 Parts Imron® 2.1 HG-D™ + 1 Part 9T00-A™ Activator	Brush, roll or spray 10 mils wet 5 mils dry	Dry to touch --- Dry to handle --- Dry to Recoat ---
Imron® EZ-3460S™ Clearcoat High gloss polyurethane clear	A high-performance, air-dry clear Excellent cleaning properties (resist dirt, road tar and tree sap). Delivers excellent durability and chemical resistance	Imron® EZ-3460S™ Clear coat Imron® EZ-3461S™ Activator	3 Parts Imron® EZ-3460S™ 1 Part EZ-3461S™ Activator	Spray Only One cross-coat 1.8 - 2.2 mils dry	Dry to touch: 4-6 hours Dry to handle: 72 hours Note: Up to 2 oz of 389S™ accelerator can be used for faster dry times.
Corlar® 2.1 HTA™ High temperature aluminum epoxy mastic	A high solids high build 2 component VOC compliant aluminum epoxy mastic	Dual Component Resin 2.1 HTA Activator FG-2HTA	1 Part Resin 1 Part Activator	Spray Only 8-12 mils wet 5-8 mils dry	Dry to touch 3 hours Dry to handle 5 hour Recoat 12 hours max.
Corlar® 2.1 ST™ Satin, High Gloss Epoxy Mastic.	High solid, low VOC (2.1 lbs. /gal), polyamide epoxy mastic primer.	Fac-Pac colors; LF-63225P White LF-63325P Shale Gray LF-Cirrus Gray LF-71125P Red Oxide LF-64025P Black VF-525 activator	1 Part Base 1 Part Activator Reduces 5-15% for spray application.	Spray for best appearance. Primer: 3-8 mils dry.	Dry to touch 2-3 hours Dry to handle 4 hours Dry to recoat 3 hours
Corlar® 2.1 PR-P™	High solids, two components, low VOC (2.1 lbs. /gal.), low HAPS, productive epoxy primer, based on Axalta modified polyamide epoxy technology.	Fac-Pac Colors: 525-880 Red Oxide 525-882 Buff 525-885 ANSI 61 Grey 525-886 Black 525-971 ANSI 70 Grey	2 Parts Corlar® 2.1 PR-P™ Base 1 Part FG-040 Activator * Reduction Optional 5% by volume. T-1021 below 80°F T-1025 above 80°F	Apply by spray for Maximum Appearance. Film Build: 6 mils wet 3 mils dry	Dust free 30 minutes Dry to touch 1 hour Dry to recoat 45 minutes Hard Dry 2 hours

SPECIFICATION GUIDE
Hot Mix Asphalt
TABLE VII
PRODUCT DESCRIPTIONS
PRIMERS, FINISH & DIRECT TO METALS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® Industrial Strength Low VOC Polyurethane Primer	Next generation Imron® Industrial Strength Low VOC Polyurethane Primer is a durable, fast dry, high solids, two-package, VOC conforming, 0.8 lbs/ gallon primer which can be brushed, rolled or sprayed.	Imron 9TXX 9T00-A™ Activator See PDS for application thinner details.	8 Parts 9PXX Color 1 Part 9T00-A Activator See PDS for application thinner details.	Brush, roll or spray 6-10 mils wet 3-5 mils dry	Dry Times @ 75°F & 50% RH Dust Free 15 Mins. Dry to handle 1 hr 15 Mins. Dry to Recoat 45 Mins.
Corlar® 2.8 PR™ Epoxy modified polyamide epoxy	A two component fast dry epoxy primer. VOC compliant.	Corlar® 525-33009 Base, FG-33011 Lt. Salmon, FG-33044 Red Oxide, FG-33045 Dk Salmon, FG-33046 Buff, FG-33272 Gray, FG-33278 Black	1 Part Corlar® 2.8 Base 1 Part Corlar® 2.8 Colored Activator	Apply by spray only. Can be B, R + Spray 6 mils wet 3 mils dry No reduction is necessary	Dust free 1 hour Dry to touch 1 hour Dry to recoat 2-3 hours Dry to handle 4 hours
Tufcote® 1.9 HG-D™ (Tufcote® 72P™) Waterborne acrylic DTM enamel	High quality, chalk-resistant acrylic interior/exterior finish for wood and galvanized metal. Self priming on bare wood and metal surfaces.	Single component	No reduction required	Brush, roll or spray 5.5 mils wet 2 mils dry	Dry to touch 1 hour Dry to handle 3 hours Dry to re coat 3 hours
Tufcote® 2.5 PR™ High solids fast dry alkyd primer	Phenolic modified alkyd primer lead and chromate free.	Single component	1 Part Ready to Spray	Brush, roll or spray 4 mils wet 2 mils dry	Dry to touch 30 minutes Dry to handle 2 hour Recoat 1 hour
Tufcote® 3.5 HG-D™ Acrylic-Modified Alkyd Gloss Topcoat	A quality gloss alkyd enamel topcoat with quick dry properties & exceptionally tough film	Single component	1 Part Ready to Spray	Spray is preferred 4 mils wet 2 mils dry	Dry to touch 20 minutes Dry to handle 1 hour Recoat 30 -120 minutes

SPECIFICATION GUIDE

Hot Mix Asphalt

TABLE VII PRODUCT DESCRIPTIONS PRIMERS, FINISH & DIRECT TO METALS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® Elite Productive "EX" Quality	2.8 or 3.5 VOC, high performance, topcoat delivers excellent durability, premium appearance and excellent color	Imron® Elite "EX" Mix Quality Imron® 153XXS™ Activator	At 2.8 VOC - 2.5 parts Imron® Elite "EX" mix color with 1 part Imron® 15309™ activator <hr/> At 3.5 VOC - 3 parts Imron Elite "EX" mix color with 1 part Imron 153XX activator	1.8 - 2.2 mils dry	Dry to Touch 0.5-1 hour Tack Free 2-3 hours Tape Free 3-5 hours Dry to Assemble 72 hours (With 389S™ Activator)
Imron® Elite Productive Basecoat "EW" Quality	3.5 VOC, high performance, basecoat delivers excellent durability, premium appearance and excellent color	Imron® Elite "EW" Mix Quality Imron® 153XXS™ Activator	3 parts Imron® Elite "EW" mix color with 1 part Imron® 153XX™ activator	1.0 - 1.5 mils dry	Dry to Touch 30 mins Tack Free 60 mins Tape Free 90 mins Dry to clear coat 30 min to 16 hrs (With 189S™ Activator)
Uro® 1380S™	A high performance, very low VOC (<2.1 lbs/gal RTS), two component lead and chromate free urethane primer-filler.	A two-package, low VOC urethane primer that is activated with Imron® 193S™ Activator (or Imron® 194S™ Activator for lower HAPS applications)	To 4 parts Uro® 1380S™ add 1 part Imron® 193S™ or Imron® 194S™ Activator. To the activated gallon, add up to 2 oz. MasterTint® 389S™ Accelerator	1.2 - 2.2 mils dry	Dry to Touch 30 - 45 min Tack Free 1 - 2 hours Print Free 2 - 3 hours Product must be sanded if allowed to dry more than 24 hours.
Corlar® 921S™	Corlar® 921S™ provides excellent durability and corrosion resistance, especially when topcoated with Axalta High Solids Topcoats.	A high performance, low VOC (2.1 lbs/gal RTS), epoxy polyamide primer-sealer. Corlar® 921S™ is a two-component, light gray primer-sealer that is lead and chromate free.	Two (2) parts Corlar® 921S™ Epoxy Primer-sealer with one (1) part Corlar® 922S™ Fast or 923S™ Slow Activator.	1.2 - 1.8 mil dry	Dry to Touch 30 minutes Tack Free 30 minutes Print Free 1 hr

SPECIFICATION GUIDE
Hot Mix Asphalt

TABLE VII
PRODUCT DESCRIPTIONS
PRIMERS, FINISH & DIRECT TO METALS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® Elite 8821™ Clear Coat	A two-component, 2.1 VOC and low HAPS polyurethane clear coat	A two-component urethane clear coat.	3:1 Mix: 3 parts Imron® Elite 8821™ Clear Coat to 1 part 15309™ Activator	1.8 - 2.2 mils dry	Dry to Touch 1-2 hours Tack Free 2-4 hours Tape Free 4-6 hours Dry to Assemble 72 hours

SPECIFICATION GUIDE

Hot Mix Asphalt

PAINTING

Surface Preparation

As part of Axalta’s simplified approach to painting of Hot Mix Asphalt Equipment, we have analyzed the various types of surface preparation most likely needed in your industry. If you follow the recommendations presented below for each of the different types of surfaces you will be painting, you will get the best results from your painting investment.

It is important to remember, however, that some surface preparation is always required. All paint products are designed to perform at their best when used correctly; unless the surface is correctly prepared to receive the paint, it will not adhere properly and may fail very early in its lifetime.

All surfaces must be clean and free of all contamination. Clean all surfaces with detergent and rinse with clean water rinse allowing dry prior to additional surface preparation. All previously painted surfaces in good condition should be scuff sanded after detergent cleaning, to insure adequate adhesion.

Previously painted surfaces if fair to poor condition, (peeling paint, rusting, or any lack of adhesion) need to be hand and or power tooled cleaned after detergent cleaning. Then the surface must be primed, with recommended Axalta Coating Systems general industrial primer.

STEEL (except galvanized)	Good- Detergent/Solvent Clean (SSPC-SP 1) Better, Hand and power tool clean (SSPC-SP2/3) Best, Abrasive blast clean (SSPC-SP6)
GALVANIZED STEEL	Good- Detergent/Solvent Clean (SSPC-SP 1) Better, Hand and power tool clean (SSPC-SP2/3) Best, Abrasive blast clean (SSPC-SP7 or SP 11)
ALUMINUM*	Good*- Detergent/Solvent Clean, (SSPC-SP 1) Better*- Hand and power tool clean (SSPC-SP2/3) Best- Abrasive blast clean, or etched (SSPC-SP7 or SP11)

* must be anodized or alodized aluminum

SPECIFICATION GUIDE

Hot Mix Asphalt

PAINTING

Application

Doing a good painting job also depends on how well you apply the paint. No matter how well the surface is prepared, or how good the paint product, you will get the best results by applying the paint properly.

Conditions During Painting

Generally speaking, the best temperatures for painting are normal room temperatures. About the only time you need worry about ambient temperature for indoor painting is when it is hotter than 95°F. When painting outdoors on a cool day, wait until the air temperature is at least 50°F; don't paint outdoors if the temperature is near 100°F.

Humidity can affect your painting, too. If it is too humid, it will slow the drying of most paints. Likewise, don't paint outdoors when it's raining, or just about to. Rain can quickly spoil a paint job.

Finally, watch out for winds when painting outdoors. Wind can blow dust and dirt onto the wet paint, and can also interfere with spray painting. If it's windy, wait until the wind dies down or paint those areas that are protected from the wind.

Application Methods

The method you select for painting depends on the type of surface being coated, the size of the job, what paint you are using and your labor costs for painting.

Spray → All things considered, spray painting is usually the most economical painting method in the long run. Conventional air spray is most commonly used, but for very large, flat surfaces, you should consider using airless spraying. Airless spraying cans sometimes double your painting productivity as compared with air spraying. There are several types of spray equipment; all designed to do particular jobs. Be sure your spray equipment is in good operating condition; fluid lines and pressure pots clean; pressure gauges and diaphragm valves operating; spray guns clean and properly adjusted. See that effective traps for water and oil are in the air feed side of each pressure pot and are bled before use. Properly adjusted spray equipment can save you money, for every stroke of the gun uses up paint and labor; wrong settings can double your spraying costs. Follow the correct spraying techniques for the job you are doing. Hold the spray gun at the right angle, keep the gun the right distance from the surface and move it correctly across the surface.

SPECIFICATION GUIDE

Hot Mix Asphalt

PAINTING

APPLICATION (Continued)

Brush→ Brushing paint is ordinarily the slowest and most expensive way of applying a coating and for applying primers or undercoats to lap joints, deep pits, rivets or hand-cleaned steel. Brushes should be clean, of good quality and the right size and shape for the surfaces to be painted. Some of today's newer brush filament materials may improve your painting, speed up your work and save you money.

Roller→ A very economical way to apply coatings, but usually not used to repaint equipment.

SPECIFICATION GUIDE

Hot Mix Asphalt

COLOR

Axalta Coating Systems may match most OEM Equipment colors.

EQUIPMENT Color Name	Imron® 2.1 HG™ + Polyurethane	Imron® 3.5 HG™ + Polyurethane	Imron® 1.2 HG™ Waterborne	Tufcote® 3.4 HG-D™ Alkyd	Imron® Industrial Strength GN,GO,GP GQ Qualities
White	1333-67632	42P-1632	1632 WG	LF-63234P	9T11 (1632 White)
Black	1333-67640	42P-1640	1640 WG	LF-64034P	9T02 (1640 Black)
New Holland Ford Blue	VF-3071	42P-3071	3071WG	LF-307134P	3071
Omaha Orange	1333-23662	42P-1662	1662 WG	LF-66234P	1662
New Cat Yellow	VF-3069	42P-3069	3069 WG	34-3069	3069
Caterpillar Highway Yellow	VF-3133	42P-3133	3133 WG	34-3133	3133
BFI Blue	VF-3067	42P-3067	3067 WG	LF-306734P	3067
Waste Management Green	VF-3356	42P-3356	3356 WG	34-3356	3356
John Deere Green	VF-1566	42P-1566	1566 WG	LF-156634P	1566
John Deere Industrial Yellow	VF-1564	42P-1564	1564 WG	LF-156434P	1564
International Harvester (Case) Red	VF-3068	42P-3068	3068 WG	LF-306834P	3068
Case Power Tan	VF-3070	42P-3070	3070 WG	34-3070	3070
Case Gray	VF-3134	42P-3134	3134 WG	34-3134	3134
New Holland Ind. Yellow	VF-3072	42P-3072	3072 WG	34-3072	3072
New Holland Agriculture Yellow	VF-3135	42P-3135	3135 WG	34-3135	3135
New Holland Agriculture (Case) Red	VF-3136	42P-3136	3136 WG	LF-313634P	3136
Safety Blue	VF-1665	42P-1665	1665 WG	LF-166534P	1665

SPECIFICATION GUIDE
Hot Mix Asphalt

COLOR (Continued)

Axalta Coating Systems may match most OEM Equipment colors.

EQUIPMENT Color Name	Imron® 2.1 HG™ + Polyurethane	Imron® 3.5 HG™ + Polyurethane	Imron® 1.3 HG™ Waterborne	Tufcote® 3.4 HG-D™ Alkyd	Imron® Industrial Strength GN,GO,GP,GQ Qualities
Genie Blue	VF-BS913	BS913-42	BS913WG	34-BS913	NA
Genie Gray	VF-LS191	LS191-42	LS191WG	34-LS191	NA
National Rent Vehicle Yellow	VF-B8779	B8779-42	B8779WG	34-B8779	B8779
JLG Orange	VF-YS073	YS073-42	YS073WG	34-YS073	NA
JLG Tan	VF-YS386	YS386-42	YS386WG	34-386	NA
TEREX White	VF-3001	42P-3001	3001WG	34-3001	3001
TEREX Gray	VF-3002	42P-3002	3002WG	34-3002	3002
Nations Rent Decal Yellow	VF-Q1391	Q1391-42	Q1391WG	34-Q1391	1391
Bob Cat Gray	VF-DS023	DS023-42	DS023WG	34-DS023	NA
Bob Cat Orange	VF-YS019	YS019-42	YS019WG	34-YS019	NA
Bob Cat White	VF-LS006	LS006-42	LS006WG	34-LS006	NA
Ingersol Rand Beige	VF-F1561	F1561-42	F1561WG	34-F1561	NA
Veneer Yellow	VF-3069	42P-3069	3069WG	34-3069	3069
Ditch Witch Red	VF-YS024	Ys024-42	YS024WG	34-YS024	NA
John Deere Yellow	VF-1565	42P-1565	1565WG	34-1565	1565
Upright Blue	VF-3606	42P-3606	BS460WG	34-BS460	NA
Sunbelt Green	VF-Q1343	Q1343-42	Q1343WG	34-Q1343	Q1343

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