AXALTA

Specification Guide

Ready-Mix Concrete

SPECIFICATION GUIDE
Ready Mix Concrete

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Introduction

We have prepared this specification guide for Ready Mix Concrete 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 Fleet and Facilities 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 needs. 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 Axalta Coating Systems on 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 Distributor 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.****

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PAINT SYSTEMS FOR READY MIX CEMENT

CONCRETE VEHICLE & EQUIPMENT PAINT SYSTEM

(Axalta Coating Systems - Metallic Colors)

CONCRETE TRUCK & EQUIPMENT	SURFACE	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 polyurethane primer 3.5 VOC polyurethane enamel single stage topcoat 3.5 HS polyurethane basecoat 2.1 HS polyurethane clear coat
Sheet Metal, Steel Drum & 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:** 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 polyurethane primer 3.5 VOC polyurethane enamel single stage topcoat 3.5 HS polyurethane basecoat 2.1 HS polyurethane clear coat

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PAINT SYSTEMS FOR READY MIX CEMENT

CONCRETE VEHICLE & EQUIPMENT PAINT SYSTEM

(Axalta Coating Systems – Solid Colors)

CONCRETE TRUCK & EQUIPMENT	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Fiberglass Cab. (smooth sanded finish)	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 polyurethane primer 3.5 VOC polyurethane enamel single stage topcoat 3.5 HS polyurethane basecoat 2.1 HS polyurethane clear coat
Sheet Metal. (smooth sanded finish)	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:** 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 polyurethane primer 3.5 VOC polyurethane enamel single stage topcoat 3.5 HS polyurethane basecoat 2.1 HS polyurethane clear coat
		Good	**DTM:** Imron® 2.1 HG-D™ + (5) **Topcoat:** Imron® 2.1 EZ-3460S™ (2.5)	**New** High build, high gloss urethane DTM High gloss polyurethane clearcoat
Carbon Steel Mixing Barrels, Shoots, Fenders & Chassis (blasted surfaces).	Carbon Steel	**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 PR-P™ (3) **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® 2.1 EZ-3460S™ (2.5)	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 High gloss polyurethane clearcoat

TABLE II
PAINT SYSTEMS FOR READY MIX CEMENT
BATCH PLANT AREAS

SERVICE AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Roof, Walls, Ceilings, Structural Steel, Sign Posts, Light Poles, Columns, Railings, Fences, Fence Post, Piping, Equipment, Sprinkler Systems, Piping, Machinery & Utility Boxes	Carbon Steel.	**Good**	**Primer:** Imron® 1.5 ST-D™ (4-5) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne polyurethane primer Waterborne polyurethane topcoat
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) or Tufcote® 3.3 PR™ (3-4) **Topcoat:** Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	High solid alkyd primer High solid alkyd 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® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	High solids epoxy mastic Ultra Low VOC High Gloss Polyurethane Topcoat **New** High gloss polyurethane topcoat **New** High gloss polyurethane topcoat
Roof, Walls, Ceilings, Structural Steel, Sign Posts, Light Poles, Columns, Railings, Fences, Fence Post, Piping, Equipment, Sprinkler Systems, Piping, Machinery & Utility Boxes	Galvanized Steel	**Good**	**Primer**: Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne polyurethane primer Waterborne polyurethane topcoat
		Better	**Primer:** Corlar® 2.1 PR-P™ (2-3) or Imron® Industrial Strength Low VOC Polyurethane Primer (3-4) **Topcoat** Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	High production epoxy primer 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) or Imron® 3.5 HG™ + (2-3)	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

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TABLE II
PAINT SYSTEMS FOR READY MIX CEMENT
BATCH PLANT AREAS (Continued)

SERVICE AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Walls	Concrete, Masonry, Stone	**Good**	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne polyurethane primer Waterborne polyurethane topcoat
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	High solids epoxy mastic **New** High gloss polyurethane topcoat **New** High gloss polyurethane topcoat
		Best	**Primer:** Corlar® LV SG™ (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)	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
Wash Bays	Concrete Block	**Good**	**Primer:** Corlar® 2.1 ST™ (4-5) **Topcoat:** Corlar® 2.1 ST™ (3-4)	High solids mastic High solids epoxy mastic
		Best	**Primer:** Corlar® LV SG™ (4-5) **Topcoat:** Corlar® LV SG™ (3-4)	Very high solids epoxy mastic Very high solids epoxy mastic
Line marking	Asphalt	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic enamel Waterborne acrylic enamel
		Best	**Primer**: Imron® 1.5 ST-D™ (4-5) **Topcoat:** Imron® 1.2 HG™ (4-5)	Waterborne polyurethane primer Waterborne polyurethane topcoat
Line marking	Poured concrete	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic enamel Waterborne acrylic enamel
		Better	**Primer**: Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne polyurethane primer Waterborne polyurethane topcoat
		Best	**Primer:** Corlar ® 2.8 HG-D™ (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)	High build 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

TABLE II
PAINT SYSTEMS FOR READY MIX CEMENT
BATCH PLANT AREAS (Continued)

Parking & stopping curbs	Concrete	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic enamel Waterborne acrylic enamel
		Best	**Primer:** Imron® 1.5 PR™ (3-4) **Topcoat:** Imron® 1.2 HG™ (3-4)	Waterborne polyurethane primer Waterborne polyurethane copolymer
Doors, Frames & Trim	Wood	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic enamel Waterborne acrylic enamel
		Better	**Primer**: Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (3-4)	Waterborne polyurethane primer Waterborne polyurethane topcoat
		Best	**Primer:** Corlar® 2.1 PR-P™ (3-4) **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)	High Productive 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

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TABLE III - PRODUCT DESCRIPTIONS

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™ Waterborne Polyurethane Topcoat.	High gloss, iso-free, single component, VOC conforming (1.2 lbs. /gal) zero HAPS, waterborne polyurethane topcoat.	Single component. Fac-Pac and Custom Color.	Ready to spray	Spray for best appearance.	Tack free:2.0-2.5 hours Dry to handle 1 hour Dry to recoat 30 minutes Hard dry 2 hours
Imron® 1.5 STD™ Waterborne polyurethane primer.	High performance, low VOC (1.5 lbs. /gal); zero HAPS, quick dry waterborne polyurethane primer. For use under Imron® 1.2 HG™	Single component. Fac-Pac colors;	Ready to spray.	Spray for best appearance. 4 mils wet 2 mils dry	Tack free 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.

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TABLE III - PRODUCT DESCRIPTIONS

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® 2.1 + Reduced Gloss Polyurethane Available in variable gloss levels: semi gloss, satin and flat.	**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 with outstanding gloss & color retention.	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® 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® 3.5 HG™ + High Gloss Polyurethane	**New Imron® technology** delivering a high solids, **high gloss**, 3.5 lbs/gal VOC with low HAPS, extremely durable finish with outstanding chemical & 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, **reduced gloss**, 3.5 lbs/gal VOC with low HAPS, extremely durable finish with outstanding chemical & 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.

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TABLE III
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
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® LV SG™ Very High Solids Semi-Gloss Epoxy Mastic	High build, very high solids, two component, low VOC (0.71 lbs. /gal), amine epoxy DTM.	Fac-Pac colors; LF-64090P Black LF-63290P White LF-63790P Cirrus Gray LF-6AL90P Aluminum LF-71190P Red Oxide FG-090 Activator T-6013 Reducer	2 Parts base 1 part activator Reduction T-6013 0-5% by volume	Spray for best appearance. 6 mils wet 5 mils dry	Dry to touch 4 hours Dry to recoat 8 hours Full cure24 hours
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 Productive Epoxy Primer	High solids, two component, VOC conforming (2.1 lbs. /gal), low HAPS productive polyamide epoxy primer.	525-880 Red Oxide 525-882 Buff 525-885 ANSI 61 Gray 525-886 Black 525-971 ANSI 70 Grey FG-040 Activator	2 Parts base 1 Part activator Reduction optional, 5% by volume. T-1021 normal T-1025 warm	Spray for best appearance. 6 mils wet 3 mils dry	Dust free 30 minutes Dry to touch 1 hour Dry to recoat 45 minutes Hard dry 2 hours
Corlar® 2.8 HG-D™ High Gloss, High Build Epoxy DTM	High solid, low VOC (2.8 lbs. /gal), high gloss, polyamide epoxy DTM. Used as a primer or DTM where not exposed to UV.	Fac-Pac colors; LF-63226P White LF-63326P Shale Gray LF-63726P Cirrus Gray LF-64026P Black VF-026 Activator	1 Part Base 1 Part Activator reduces 0-20% with T-8054	Spray for best appearance. Primer: 5 mils dry.	Dry to touch 3 hours Dry to handle 16 hours Dry to recoat 16 hours

TABLE III
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
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.
Tufcote®1.9 HG-D™ High Gloss Waterborne Acrylic DTM	High gloss, single-package, VOC conforming (1.9 lbs. /gal), waterborne acrylic technology	Single component	Ready to Spray * May be reduced up to 15% by volume with clean water.	Spray, brush or roll application. Spray for best appearance. 5.5 mils wet 2.0 mils dry	Dry to touch 1 hour. Dry to handle 3 hours Dry to recoat 3 hours. Hard dry24 hours
Tufcote® 2.5 PR™ High Solids Fast Dry Alkyd Primer	fast dry, low VOC (2.5 lbs. /gal), phenolic modified alkyd primer.	Single component. Fac-Pac colors; 681-20704 Red Oxide 681-21072 Med. Gray	Ready to Spray. Optional reducers: Spray TY-3810	Spray for best appearance. 4 mils wet 2 mils dry	Dry to touch 30 minutes Dry to handle 2 hours Dry to recoat 1 hour Hard dry12 hours
Tufcote® 3.3 PR™ High Solids Fast Dry Alkyd Primer	High solids, fast dry, low VOC (3.3 lbs./gal), phenolic modified alkyd primer.	Single component. Fac-Pac colors; 681-700 White 681-704 Red Oxide 681-705 Buff 681-709 Gray	Ready to spray. Optional reducers: TY-3810 medium TY-3819 slow	Spray for best appearance. 4 mils wet 2 mils dry	Dry to touch 30 minutes Dry to handle 2 hours Dry to recoat 1 hour Hard dry: 12 hours
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 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™ Accelerator)
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™ Accelerator)

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Imron® Elite 8840S™ Polyurethane Clearcoat	high-performance, clear coat delivering premium appearance with excellent durability and chemical resistance (3.5 VOC lbs. /gal)	Imron® Elite 8840S™ Clearcoat 194S Activator.	3 Parts clear 1 part activator	Spray only. 1.8 – 2.2 Dry mils	Dry to touch 6 hours Tack free12 hours Tape free 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

Facilities Surface Preparation

As part of Axalta's simplified approach to painting Ready Mix Concrete facilities, we have analyzed the various types of surface preparation needed in your facilities. 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 that some surface preparation is nearly always required; whatever the surface or paint you use. Even if surface preparation means only dusting the surface or solvent washing to remove any loose material, **DO NOT OMIT THIS STEP**. 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 prematurely.

STEEL (except galvanized)
► Wire brush or spot sand to remove all loose rust, Failing material and foreign matter. Tightly adhering paint and mill scale may remain. Abrasive blast clean per product data sheet is recommended.

GALVANIZED STEEL
► Remove all oil and grease. Remove all white rust by washing with soap and water and rinsing thoroughly.

WOOD
► ***New Wood:*** Sand lightly and remove all loose sawdust, dirt and sand grit. Fill nail holes and cracks with suitable putty or filler.

PREVIOUSLY FINISHED WOOD
► **Remove** all loose and failing material by sanding or scraping. Fill nail holes and cracks with suitable putty or filler, except when finishing floors.

CONCRETE, MASONRY & MASONRY BLOC
► Remove all loose dirt, failing material, foreign (Note: All new concrete and mortar joint should be aged a minimum of 30 days before painting).

Note: Mildew must be removed from all surfaces by scraping followed by a thorough washing with a solution composed of:

►2/3 cup trisodium phosphate (e.g. Soilax®)
►1/3 cup detergent (e.g. Tide®) 1 qt. Household
►bleach (e.g. Clorox®)
►warm water to make 2 gallons Rinse thoroughly
►With clear water and allow to dry before painting.

Application Methods

Performing 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 temperature for painting is normal room temperature around 75°F. When the ambient temperature or substrate is greater than 95°F, rapid solvent evaporation adversely affects the paint. When painting on cold days where the substrate or temperature is below 50°F, several paint chemistries will fail to dry. Humidity can affect your painting, too. High humidity will slow the drying of most paints and may create surface blushing. Finally, be aware of wind conditions when painting outdoors. Wind can blow contaminants into the wet paint, and can also interfere with spray painting.

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 may double painting productivity as compared with air spraying. There are several types of spray equipment, all designed to do particular jobs. Be sure your equipment is in good operating condition, fluid lines and pressure pots clean, pressure gauges and diaphragm valves operating, and 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 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.

Roller → Roller application is the next most economical means of painting, indoors and outdoors, and may be necessary in those areas where spray painting is not possible. As with spray equipment, use the right equipment for the job. Today there are special rollers for flat surfaces, corners and rounded objects. The roller cover you use is determined by the paint. A general rule of thumb is, "the smoother the surface, the shorter the nap". Again, be sure that your rollers and other equipment are clean before using.

Application Methods (Continued)

Brush → Brushing paint is ordinarily the slowest and most expensive way of applying a coating, although it is most commonly used for woodwork and trim, 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. Should you have any questions about brush selection or brushing techniques, consult with your Axalta Representative.

Color

Putting Color to Work For You

To get the most of color in your facility, remember that it is now possible to select from either factory packaged colors or custom colors that may be developed to match your company standards.

The proper use of color will help you in many ways, such as improving plant working conditions, lifting employee morale, increasing productivity, reducing glare and eyestrain and eliminating many unsafe working conditions.

The "Axalta OSHA Safety Colors" may be used in improving identification of your equipment (especially mechanical equipment and apparatus) and in spotlighting potential safety hazards at your facility site.

Your Axalta Representative is trained to help you in selecting the color schemes for your facility. However, if you wish to select your own colors, you can be sure that the colors offered represent the latest thinking in color technology.

Safety Colors, Piping & Equipment Color Codes

Color	Axalta Part Number	Use
Yellow	1663 Safety	Yellow Gas/Vapor lines, safety guards, yellow & black stripes for machinery
Orange Inside of cover	1662 Safety Orange	Oil lines, grease fittings, inside cover of electrical switch boxes
Red lines	1664 Safety Red	Fire protection equipment, high-pressure sprinkler valve and lines
Blue	1665 Safety Blue	Electrical conduit, beams and hanger rods
Green	1666 Safety Green	Water lines
Black	1640 Black	Drain lines, waste water
White	1632 White	Electrical conduit, beams and hanger rods
Medium Gray	1633 Shale Gray	Walls and columns
Light Gray	1637 Cirrus Gray	Machinery-compressors, pumps, motors, fans
Light Brown less	1635 Clay Tan	Low pressure air lines 40 psi or less
Dark Blue	1014 Dark Blue	Hot water and boiler feed water line
Dark Brown	1288 Bark Brown	High pressure air lines over 40 psi
Light Green	1062 Spotlight Green	Chilled water lines
Medium Green	1642 Meadow Green	Control cabinets and panels
Light Blue	1638 Falls Blue	Cooling water lines
Aluminum	6AL25P Aluminum	Steam and condensate lines, hot surfaces, boilers, stacks, cooling fins on air compressors; hot equipment to 500°F

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