AXALTA

BLEND SUPPLY

Specification Guide

Commercial & Industrial Facilities

SPECIFICATION GUIDE
Commercial & Industrial Facilities

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Introduction

We have prepared this specification guide for Commercial and Industrial Facilities 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 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 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.****

Paint Selection - The "Paint System" Approach

A basic feature of the simplified approach to painting Axalta has developed for Commercial and Industrial Facilities is the use of "paint systems" designed for specific areas and substrates.

By a "paint system" we mean the proper combination of (1) surface preparation, (2) paint products and (3) application for a given surface. Each of the three elements plays an important role in the final and most economical performance of paints and finishes for your ski resort.

We have selected the proper combination for each type of application you are likely to encounter. The paint systems for Exterior Exposure, listed by substrate, are listed in Table I. Paint systems for Interior Exposure, listed by substrate, are listed in Table II. After you have selected the appropriate system for the area or structure you want to paint, you can find the paints necessary for each system by referring to Table III- Product Selection. This table provides you with a brief description of each of the products specified in Table I and II as well as application information and dry times for each of the products. Both tables will allow you to readily determine, which is the recommended system for each area or item to be painted or type of substrate encountered, or your Axalta Representative will be happy to work with you on painting specifications tailored to your specific requirements.

For additional information on these products, you may also wish to consult the product data sheets on each of the products referred to in this Section. Product data sheets and Material Safety Data Sheets may be obtained through our website at axalta.us**.**

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TABLE I

PAINT SYSTEMS FOR COMMERCIAL & INDUSTRIAL FACILITES

FACILITY AREAS – OUTDOORS

FACILITY AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Roof	Carbon Steel	**Good**	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry alkyd primer **New** High gloss polyurethane
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry productive epoxy primer **New** High gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (4-5) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane
Walls	Concrete Block	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Corlar® 2.1 ST™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Satin epoxy mastic High gloss acrylic latex
		Best	**Primer:** Corlar® 2.1 ST™ (to fill) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane
Walls	Concrete, Masonry, Stone	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2 or to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Best	**Primer:** Corlar® 2.1 ST™ (4 or to fill) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane
Walls	Carbon Steel	**Good**	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer topcoat
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Tufcote® 3.5 HG-P™ (2-3)	Fast dry alkyd primer Modified alkyd polyurethane
		Best	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3)	Fast dry productive epoxy primer Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane
Sign Posts, Light Poles, Columns, Railings, Fences & Posts	Carbon Steel	**Good**	**DTM:** Imron® 2.1 HG-D™ **+** (5)	**New** DTM high gloss polyurethane
		Better	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer topcoat
		Best	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3)	Fast dry productive epoxy primer Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane

Note: Imron® 3.5 HG™ **+** may also be used where Imron® 2.1 HG™ **+** is listed.

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FACILITY AREAS – OUTDOORS

FACILITY AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Overhead Doors, Canopies	Pre-coated Metal	**Good**	**DTM:** Imron® 1.5 ST-D™ (4-5)	Waterborne urethane copolymer
		Better	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer
		Best	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ + (2-3)	Fast dry productive epoxy primer **New** High gloss polyurethane
Line marking	Poured concrete, Asphalt	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Best	**Primer:** Tufcote® 1.9 HG-D™ (2.0) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ + (2-3) Or Imron® 3.5 HG™ + (2-3)	High gloss acrylic latex Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane **New** High gloss polyurethane
Parking & stopping curbs	Concrete	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2 or to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Tufcote® 1.9 HG-D™ (2 or to fill) **Topcoat:** Imron® 2.1 HG™ + (2-3) Or Imron® 3.5 HG™ + (2-3)	High gloss acrylic latex **New** High gloss polyurethane **New** High gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ + (2-3) Or Imron® 3.5 HG™ + (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane **New** High gloss polyurethane
Piping & Utility Boxes	Carbon Steel	**Good**	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer topcoat
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Tufcote® 3.5 HG-P™ (2-3)	Fast dry alkyd primer High gloss alkyd modified polyurethane
		Best	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ + (2-3) Or Imron® 3.5 HG™ + (2-3)	Fast dry productive epoxy primer Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane **New** High gloss polyurethane

TABLE I (CONTINUED)
PAINT SYSTEMS FOR COMMERCIAL & INDUSTRIAL FACILITES
FACILITY AREAS – OUTDOORS

FACILITY AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Doors, Frames & Trim	Carbon Steel	**Good**	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer topcoat
		Better	**Primer:** Tufcote® 2.5 PR™ (3-4) **Topcoat:** Tufcote® 3.5 HG-P™ (2-3)	Fast dry alkyd primer High gloss alkyd modified polyurethane
		Best	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3) Or Imron® 3.5 HG™ **+** (2-3)	Fast dry productive epoxy primer Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane **New** High gloss polyurethane
Miscellaneous Areas	Wood	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:**: Imron® 2.1 HG™ **+** (2-3) Or Imron® 3.5 HG™ **+** (2-3)	Fast dry, productive, epoxy primer **New** High gloss polyurethane topcoat **New** High gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3) Or Imron® 3.5 HG™ **+** (2-3)	Ultra-smooth, fast dry, epoxy primer Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane **New** High gloss polyurethane

TABLE II
PAINT SYSTEMS FOR COMMERCIAL & INDUSTRIAL FACILITES
FACILITY AREAS – INDOORS

FACILITY AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Service Bay Area, Customer Service Entrance, Body Shop Area, Service & Body Shop Estimating Area, Paint Booth, Paint Mix Room, Detail Area, Warehousing & Storage	Pre-coated Metal Ceilings	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Topcoat:** Imron® 2.1 HG-D™ **+** (3-4)	**New** DTM high gloss polyurethane
		Best	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry alkyd primer **New** high gloss polyurethane
Service Bay Area, Customer Service Entrance, Body Shop Area, Service & Body Shop Estimating Area, Paint Booth, Paint Mix Room, Detail Area, Warehousing & Storage	Galvanized Ceilings	**Good**	**DTM:** Tufcote® 1.9 HG-D™ (3-4)	High gloss acrylic latex
		Better	**DTM:** Corlar® 2.8 HG-D™ (3-4)	DTM high gloss epoxy
		Best	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Corlar® 2.8 HG™ (2-3)	Fast dry productive epoxy High gloss epoxy
Walls	Concrete Block	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Corlar® 2.8 HG-D™ (to fill) **Topcoat:** Corlar® 2.8 HG-D™ (5)	DTM high gloss epoxy DTM high gloss epoxy
		Best	**Primer:** Tufcote® 1.9 HG-D™ (to fill) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3) Or Imron® 3.5 HG™ **+** (2-3)	High gloss acrylic latex Ultra Low VOC High & Reduced Gloss Polyurethane **New** High gloss polyurethane **New** High gloss polyurethane
Walls	Concrete, Masonry, Stone	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:**: Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Corlar® 2.8 HG™ (3 or to fill) **Topcoat:** Corlar® 2.8 HG™ (3-4)	High gloss epoxy High gloss epoxy topcoat
		Best	**Primer:** Corlar® 2.1 ST™ (3-4) **Topcoat:** Corlar® 2.8 HG™ (2-3)	Satin epoxy mastic High gloss epoxy

TABLE II (CONTINUED)
PAINT SYSTEMS FOR COMMERCIAL & INDUSTRIAL FACILITES
FACILITY AREAS – INDOORS

FACILITY AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Walls	Gypsum Board	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Topcoat:** Corlar® 2.8 HG™ (to fill)	High gloss epoxy
		Best	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3) Or Imron® 3.5 HG™ **+** (2-3)	High gloss acrylic latex **New** high gloss polyurethane **New** high gloss polyurethane
Lift Station, Parking deck machinery	Machinery	**Good**	**DTM:** Imron® 1.5 ST-D™ (3-4)	Waterborne urethane copolymer
		Better	**DTM:** Corlar® 2.8 HG-D™ (4-5)	DTM high gloss epoxy
		Best	**DTM:** Imron® 2.1 HG-D™ **+** (5)	**New** DTM high gloss polyurethane
Overhead Doors, Columns, Railings, Posts	Pre-coated Metal	**Good**	**DTM:** Imron® 2.1 HG-D™ **+** (4-5)	**New** high gloss polyurethane
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Corlar® 2.8 HG-D™ (2-3)	Fast dry alkyd primer High gloss epoxy
		Best	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat :** Imron® 2.1 HG™ **+** (2-3)	Fast dry alkyd primer **New** high gloss polyurethane
Piping & Equipment , Sprinkler Systems	Carbon Steel	**Good**	**DTM:** Imron® 2.1 HG-D™ **+** (4-5)	**New** DTM high gloss polyurethane
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Corlar® 2.8 HG™ (2-3)	Fast dry alkyd primer High gloss epoxy
		Best	**Primer:** Tufcote® 2.5 PR™ (2.0) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry alkyd primer **New** high gloss polyurethane

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TABLE II (CONTINUED)

PAINT SYSTEMS FOR COMMERCIAL & INDUSTRIAL FACILITES

FACILITY AREAS – INDOORS

FACILITY AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Doors, Frames & Trim	Carbon Steel	**Good**	**DTM:** Imron® 2.1 HG-D™ **+** (4-5)	**New** DTM high gloss polyurethane
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Corlar® 2.8 HG-D™ (2-3)	Fast dry alkyd primer High gloss epoxy
		Best	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® 2.1 HG-D™ **+** (2-3)	Fast dry alkyd primer **New** DTM high gloss polyurethane
Line marking	Poured concrete	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
Wash Bays	Concrete block	**Good**	**Primer:** Corlar® 2.1 ST™ (5 or to fill) **Topcoat:**: Corlar® 2.8 HG™ (3)	Satin epoxy mastic High gloss epoxy
		Best	**Primer:** Corlar® 2.1 ST™ (5 or to fill) **Topcoat:** Corlar® 2.1 ST™ (5)	Satin epoxy mastic Satin gloss epoxy
Automated Car Wash Interior Walls	Concrete block	**Good**	**Primer:** Corlar® 2.1 ST™ (5 or to fill) **Topcoat:** Corlar® 2.8 HG-D™ (3)	Satin epoxy mastic High gloss epoxy
		Better	**Primer:** Corlar® 2.1 ST™ (5 or to fill) **Topcoat:** Corlar® 2.1 ST™ (5)	Satin epoxy mastic Satin epoxy mastic
		Best	**Primer:** Corlar® 2.1 ST™ (5) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (2-3) Or Imron® 3.5 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** High gloss polyurethane **New** High gloss polyurethane
Automated Car Wash Exterior Walls	Concrete Block	**Good**	**Primer:** Corlar® 2.1 ST™ (5 or to fill) **Topcoat:** Corlar® 2.8 HG™ (3-4)	Satin epoxy mastic High gloss epoxy
		Best	**Primer:** Corlar® 2.1 ST™ (5) **Topcoat:** Imron® 2.1 HG™ **+** (2-3) Or Imron® 3.5 HG™ **+** (2-3)	Satin epoxy mastic **New** High gloss polyurethane **New** High gloss polyurethane
Automated Car Wash Equipment, Columns & Trim	Carbon Steel	**Good**	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Corlar® 2.8 HG-D™ (3-4)	Fast dry alkyd primer High gloss epoxy
		Better	**Primer:** Corlar® 2.1 ST™ (5) Topcoat: Corlar® 2.1 ST™ (5)	Satin epoxy mastic Satin epoxy mastic
Special Applications	High temperature surfaces up to 450°F continuous/ 500°F intermittent	**Best**	Corlar® 2.1 HTA™ (5)	High temperature aluminum epoxy mastic

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 1 Part	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 copolymer topcoat	A high performance, low VOC, no HAPS, quick dry waterborne polyurethane copolymer topcoat	Single component	No reduction required	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 with itself; 1 hour with solvent borne
Imron® 1.5 ST-D™ Waterborne polyurethane copolymer satin finish direct-to-metal coating	A high performance, low VOC, no HAPS, quick dry waterborne polyurethane copolymer designed for use as a satin finish DTM or primer under Imron® 1.2 HG-C™ or Imron® 1.2 HG™.	Single component	No reduction required	Spray is preferred. 8-12 mils wet 3-5 mils dry	Dry to touch 20-30 minutes Dry to handle 1 hour Dry to recoat 30 minutes with itself; 1 hour with solvent borne
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.

TABLE III
PRODUCT DESCRIPTIONS (Continued)

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® 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 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.

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TABLE III
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
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.
Corlar® 2.1 ST™ Amido amine modified polyamide epoxy	A two-package high solids/build multi use epoxy mastic coating. Use over tight rust/blasted steel.	Corlar® 2.1 ST™ VF-525 activator Y-32035 for spray, 5%	1 Part 1 Part	Brush, roll or spray Primer: 3-8 mils dry Mid-coat: 4-6 mils dry	Dry to touch 2-3 hours Dry to handle 4 hours Dry to recoat 3 hours
Corlar® 2.1 PR-P™ Epoxy modified polyamide	VOC conforming low HAPS productive primer based on Axalta modified polyamide epoxy technology.	Corlar® 2.1 PR-P™ Activator FG-040 Reducers T-1025 for hot weather, brush & roll. T-1021 cold weather	2 Part 1 Part	Apply by spray only 6 mils wet 3 mils dry No reduction is necessary	Dust free 30 minutes To touch 60 minutes To recoat 45 minutes Hard dry 2 hours
Corlar® 2.1 HTA™ Amido amine modified polyamide epoxy – aluminum filled	A two-package, high solids, high build, VOC conforming multi-use epoxy mastic coating used for high temperature applications up to 450°F continuous, 500°F intermittent.	1HTA25P™ FG-2HTA activator Y-32035 for airless spray, 2-5%; conventional spray, 7-10%. Use T-8054 on hot or windy days. RT001P for 15%	1 Part 1 Part	Brush, roll/spray Single coat: 5-8 mils dry non-corrosive. 10-12 mils corrosive Primer: 3-8 mils Mid coat: 4-6 mils Immersion:10-12	Dry to touch 2-3 hours Dry to handle 4 hours Dry to recoat 3 hours

TABLE III
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Corlar® 2.8 HG™ Amido amine modified polyamide epoxy	A two package high solids multi use epoxy enamel topcoat with high gloss, chemical & abrasion resistance & easy application (colors will chalk/fade in UV)	Corlar® 2.8 HG™ VG-026 activator Use T-8054 on hot or windy days	1 Part 1 Part 1 hour induction	Brush, roll or spray 3 mils wet 2 mils dry	Dry to touch 3 hours Dry to handle 16 hours Dry to recoat 16 hours
Corlar® 2.8 HG-D™ Modified polyamide epoxy	Excellent choice for industrial, commercial, institutional for durability & ease of use.	Corlar® 2.8 HG-D™ VF-026 (HB DTM activator)	1 Part 1 Part 1 hour induction	Brush, roll or spray 8 mils wet 5 mils dry	Dry to touch 3 hours Dry to handle 16 hours Dry to recoat 16 hours
Tufcote® 1.9 HG-D™ 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 recoat 3 hours
Tufcote® 2.5 PR™ Fast Dry Primer Acrylic modified alkyd	A single package, fast drying universal primer for use under all topcoats including enamels	Single component	Ready to spray no reduction required	Spray is preferred 4 mils wet 2 mils dry	Dry to touch 30 minutes Dry to handle 2 hours Dry to recoat 1 hour

Surface Preparation

As part of Axalta's simplified approach to painting for commercial and industrial facilities, we have analyzed the various types of surface preparation most likely 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 whatever the paint you use. Even if surface preparation means only dusting the surface and removing, 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 very early in its lifetime.

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.

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 BLOCK
- ► Remove all loose dirt, failing material, foreign (Note: All new concrete and mortar joints 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

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; do not 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, do not paint outdoors when it is 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 is 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 can 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 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.

Application (Continued)

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.

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 Coating Systems 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 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 in your facility.

Your Axalta Coating Systems 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 Ordering No.	Use
Yellow	1663 Safety Yellow	Gas lines, safety guards, yellow & black stripes for moving machinery
Orange	1662 Safety Orange	Oil lines, grease fittings, inside cover of electrical switch boxes
Red Pressure	1664 Safety Red	Fire protection equipment, high-pressure sprinkler valves and lines
Blue Breakers	1665 Safety Blue	Electrical switch boxes, controls breakers
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 motors, fans	1637 Cirrus Gray	Machinery-compressors, pumps, motors
Light Brown	1635 Clay Tan	Low pressure air line 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	1HTA25P Aluminum	Steam and condensate lines, hot surfaces, boilers, stacks, cooling fins on air compressors, hot equipment to 500°F

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