Specification Guide

Propane Gas

SPECIFICATION GUIDE
PROPANE GAS

Table of Contents

Page

Introduction
- Identifying painting requirements   3
- How do I use this Specification Guide   3
- Contacting my local Axalta Coating Systems Distributor   3

Paint Selection
- Identifying the correct paint system   4
- Table I - Recommended paint specifications for Propane Gas Tanks   5
- Table II - Recommended paint specifications for Propane Bulks Plants   6-7
- Table III - Recommended paint specifications for Propane Vehicles   8-9
- Table IV - Description of recommended products   10-14

Plant Site Painting Guidelines
- Surface preparation description by substrate   15
- Methods of paint application   16-17

Color
- Putting Color to Work for You   18
- Color Code Paint Schemes   19

SPECIFICATION GUIDE
PROPANE GAS
Introduction

We have prepared this specification guide for the Propane Industry based on our analysis of your new equipment 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 Propane tanks and 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 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.

Paint Selection

Paint Selection - The "Paint System" Approach

A basic feature of the simplified approach to painting Axalta has developed for Propane Gas Suppliers is the use of "paint systems" designed for specific areas of your facility.

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.

We have selected the proper combination for each type of application you are likely to encounter. Paint systems for propane gas tanks can be found in Table I. The paint systems for propane bulk plants use are listed in Table II. Axalta Coating Systems products for vehicles are available in Table III where metallic coatings are required. These tables will allow you to readily determine which is the recommended system for each area, or type of durability you desire.

Although your Axalta Representative will be happy to prepare all of your facility painting specifications, you may wish to perform your own paint selection. If so, use Table I or Table II as a reference. Then after you have selected the appropriate system for the area you want to paint, you can identify the paints necessary for each system by referring to Table IV. This table provides you with a brief description of each of the products specified in the system tables as well as application information and dry times for each of the products.

For complete information on these products, you may also wish to consult the product data sheets on each of the products referred to in Table IV. Product data sheets as well as Material Safety Data Sheets can be found on our website, axalta.us.

PROPANE GAS

TABLE I
PAINT SYSTEMS FOR PROPANE BOTTLES & SMALL TANKS
Single Coat Primer/Finish Direct to Metal

SERVICE AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Propane Exchange and Small Tanks	Carbon Steel	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne DTM acrylic
		Better	**Topcoat:** Tufcote® 3.5 HG-D™ (3-4)	High gloss DTM alkyd
		Best	**Topcoat:** Imron® 2.1 HG-D™ **+** (3-4)	**New** High gloss polyurethane DTM

TABLE II - PAINT SYSTEMS FOR PROPANE PLANTS
BULK PLANT AREAS – EXTERIOR

SERVICE AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Roof, Walls	Carbon Steel	Good	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic DTM Waterborne acrylic DTM
		Better	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5HG™ **+** (2-3)	High solids, productive epoxy primer **New** High gloss polyurethane **New** High gloss polyurethane
		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 gloss epoxy mastic Ultra Low VOC High & Reduced Gloss polyurethane topcoat **New** High gloss polyurethane **New** High gloss polyurethane
Structural Steel	Galvanized Steel	Good	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic DTM Waterborne acrylic DTM
		Better	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5HG™ **+** (2-3)	High solids, productive epoxy primer **New** High gloss polyurethane **New** High gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) or Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5HG™ **+** (2-3)	High gloss epoxy mastic Ultra Low VOC High & Reduced Gloss polyurethane topcoat **New** High gloss polyurethane **New** High gloss polyurethane
Concrete Piers and Saddles	Concrete, Masonry, Stone	Good	**Primer:** Tufcote® 1.9 HG-D™ (Fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic DTM Waterborne acrylic DTM
		Better	**Primer:** Tufcote® 1.9 HG-D™ (Fill) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5HG™ **+** (2-3)	Waterborne acrylic DTM **New** High gloss polyurethane **New** High gloss polyurethane
		Best	**Primer:** Corlar® LV SG™ (Fill) **Topcoat:** Imron® Industrial Strength (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 **New** High gloss polyurethane **New** High gloss polyurethane

PROPANE GAS

TABLE II (Continued) - PAINT SYSTEMS FOR PROPANE PLANTS
BULK PLANT AREAS – EXTERIOR

SERVICE AREA	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Propane Tanks and Steel Cylinders	Carbon Steel	Good	**DTM:** Imron® 2.1 HG-D™ **+** (3-4)	**New** High gloss polyurethane DTM
		Better	**Primer:** Tufcote® 3.3 PR™ (3-4) **Topcoat:** Tufcote® 3.5 HG-P™ (2-3)	Fast dry alkyd primer High gloss polyurethane alkyd enamel
		Best	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) or Imron® 2.1 HG™ **+** (1.5-2.0) or Imron® 3.5HG™ **+** (2.0-3.0)	High solids, productive epoxy primer Ultra Low VOC High Gloss polyurethane topcoat **New** High gloss polyurethane **New** High gloss polyurethane
Piping & Utility Boxes	Carbon Steel	Good	**DTM:** Imron® 2.1 HG-D™ **+** (3-4)	**New** High gloss polyurethane DTM
		Better	**Primer:** Tufcote® 3.3 PR™ (3-4) **Topcoat:** Tufcote® 3.5 HG-P™ (2-3)	Fast dry alkyd primer High gloss polyurethane alkyd enamel
		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® 3.5HG™ **+** (2-3)	High solids, productive epoxy primer Ultra Low VOC High Gloss polyurethane topcoat **New** High gloss polyurethane **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)	Waterborne acrylic DTM Waterborne acrylic DTM
Machinery	Machinery	Good	**Primer:** Imron® 1.5 PR™ (3-4) **Topcoat:** Imron® 1.2 HG™ (3-4)	Waterborne copolymer primer Waterborne polyurethane copolymer
		Better	**Primer:** Tufcote® 3.5 PR™ (2-3) **Topcoat:** Tufcote® 3.5 HG-D™ (2-3)	Fast dry alkyd primer High gloss DTM alkyd
		Best	**Primer:** Tufcote® 3.3 PR™ (2-2) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5 HG™ **+** (2-3)	Fast Dry alkyd primer **New** High gloss polyurethane **New** High gloss polyurethane
Miscellaneous Areas	Wood	Good	**Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne acrylic DTM
		Better	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5 HG™ **+** (2-3)	High solids, productive epoxy primer **New** High gloss polyurethane **New** High gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5 HG™ **+** (2-3)	High solids epoxy mastic **New** High gloss polyurethane **New** High gloss polyurethane

TABLE III PAINT SYSTEMS FOR PROPANE
PROPANE VEHICLE & EQUIPMENT PAINT SYSTEM

Axalta Coating Systems – Solid & Metallic Colors

PROPANE 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 Tank & 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) or 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
PROPANE GAS

TABLE III PAINT SYSTEMS FOR PROPANE
PROPANE VEHICLE & EQUIPMENT PAINT SYSTEM

Axalta Coating Systems | General Industrial – Solid Colors

PROPANE TRUCK & EQUIPMENT	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Sheet Metal (i.e., rear fenders)	Carbon Steel	Good	**Primer** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne polyurethane primer Waterborne polyurethane copolymer
		Better	**Primer:** Corlar® 2.8 HG-D™ (4) **Topcoat:** Imron® 3.5 HG-C Clear™ (2.5)	High build polyamide epoxy DTM Polyurethane clear (smooth finish)
		Best	**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 productive epoxy primer **New** High gloss polyurethane **New** High gloss polyurethane
Steel Tank & Chassis	Carbon Steel	Good	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne polyurethane primer Waterborne copolymer enamel
		Better	**Primer:** Corlar® 2.8 HG-D™ (4-5) **Topcoat:** Imron® 3.5 HG-C Clear™ (2.5)	High build polyamide epoxy DTM Polyurethane clear (smooth finish)
		Best	**Primer:** Corlar® 2.8 HG-D™ (4-5) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2) or Imron® 3.5 HG™ **+** (2-3)	High build polyamide epoxy DTM **New** High gloss polyurethane **New** High gloss polyurethane

PROPANE GAS

TABLE IV
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 with **Reduced Gloss**, 0.3 VOC, improved adhesion & productivity with outstanding gloss & color retention.	Imron 9TXX 9T00-A™ Activator See PDS for application thinner details.	8 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® 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.
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.

TABLE IV
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
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.
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® 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® 2.1 PR™ Polyurethane primer or direct to metal (DTM) coating.	Low VOC, low HAPS primer based on Axalta polyurethane technology.	162-1060 ANSI 70 Grey 162-1072 ANSI 61 Grey 162-1632 White 162-1640 Black 162-795 Buff 162-711 Red Oxide FG-0162 Activator	4 parts 1 part	6-8 mils wet 3-4 mils dry	Dry to touch 2 hour Dry to handle 8-12 hour With 2 oz. 389S: Dry to touch 30-45 minutes Dry to handle 2-3 hours

PROPANE GAS

TABLE IV
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
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® 3.5 HG-C™ (Imron® 611P™) Aliphatic acrylic-polyester polyurethane clear enamel	A high solids two package polyurethane enamel. Imron® 3.5 HG-C™ is an extremely durable finish with outstanding chemical resistance and smooth finish.	Resin VG-611 Activator Application thinners: Spray: 68083< 80°F Spray: Y-32401 > 80°F	3 Parts 1 Part	Spray only 2.5-3.5 mils wet 2.0-2.5 mils dry	Accelerators: 2 oz/gal. 389s -Touch 1.5 hours Re coat 3 hours Handle 8 hours VHY-691 Touch 1 hour Recoat 1 hour Handle 1.5 hours
Corlar® LV SG™ (Corlar® VHS 90P™) Very high solids semi-gloss epoxy mastic.	A high build, very high solids semi-gloss epoxy. Can be used as a DTM coating, intermediate coat or topcoat.	Corlar® LV SG™ FG-090 Activator	2 parts 1 part	Single coat: 10-12 mils Primer: 5-8 mils Intermediate coat: 5-8 mils	Dry to touch 4 hours Dry to recoat 8 hours
Corlar® 2.1 ST™ (Corlar® 25P™) Amido amine modified polyamide epoxy	A two-package high solids/build multi use epoxy mastic coating. Use over tight rust/blasted steel.	Resin 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® 2.8 PR™ Epoxy modified polyamide Replaces (Corlar® 525-333™)	A two package smooth epoxy primer easily applied without dry over spray. Mix 1:1 with your choice of 3 activators. No induction time and long pot life.	525-33009 Base FG-33011 Lt. Salmon FG-33044 Red Oxide FG-33045 Dk. Salmon FG-33046 Buff FG-33272 Gray FG-332789 Black	1 Part 1 Part	Apply by spray only 6 mils wet 3 mils dry No reduction is necessary	Dust free 60 minutes Dry to touch 1 hour Dry to re coat 2-3 hours
Corlar® 2.8 HG™ (Corlar® 26P™) 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)	Resin 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™ (Corlar® 26P HB DTM™) Modified polyamide epoxy	Excellent choice for industrial, commercial, institutional for durability & ease of use (colors will chalk/fade in UV)	Resin 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

PROPANE GAS

TABLE IV
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
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 recoat 3 hours
Tufcote® 2.8 PR™ (Axalta 67 FD™) High Solids Fast Dry Primer Acrylic-modified alkyd	A single package, fast drying primer, DTM or "shopcoat" for use on carbon steel and wood under all topcoats including enamels.	Single component	Ready to spray No reduction	Spray is preferred 4 mils wet 2 mils dry	Dry to touch 30 minutes Dry to handle 60 minutes Dry to recoat 30 minutes
Tufcote® 3.3 PR™ (Axalta 681 FD™) High solids, fast dry alkyd primer	Very quick drying primer for use on carbon steel and wood.	Single component	No reduction required	4 mils wet 2 mils dry	Dry to touch 30 minutes Dry to handle 2 hours Dry to recoat 1 hour
Tufcote® 3.5 PR™ (Axalta 67 FD™) Fast Dry Primer Acrylic-modified alkyd	A single package, very quick drying universal primer for use under all topcoats, including enamels. Delivers good corrosion resistance.	Single component	Ready to Spray No reduction	Spray is preferred 4 mils wet 2 mils dry	Dry to touch 30minutes Dry to handle 60 minutes Dry to recoat 30 minutes
Tufcote® 3.5 HG-P™ (Axalta 34P™) Acrylic-modified V-T alkyd topcoat	A quality gloss alkyd enamel topcoat with quick dry properties & exceptionally tough film.	Single component Or FG-034 activator	8 parts 1 part	Spray is preferred. 4 mils wet 2 mils dry	Dry to touch 20 minutes Dry to handle 1 hour Dry to recoat 30-120 minutes.
Tufcote® 3.5 HG-D™ (Axalta 34P™) Acrylic-modified Alkyd Topcoat	A quality gloss alkyd enamel topcoat with quick dry properties & exceptionally tough film.	Single component or FG-034 activator	8 Parts 1 Part	Spray is preferred 4 mils wet 2 mils dry	Dry to touch 20 minutes Dry to handle 1 hour Recoat 30 –120 minutes

TABLE IV
PRODUCT DESCRIPTIONS (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 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)
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

Facilities Surface Preparation

As part of Axalta's simplified approach to painting Propane Gas 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 humid 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.

The method you select for painting depends on the type of surface that is 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 the 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. But if you wish to select your own colors, you can be sure that the colors offered represent the latest thinking in color technology.

PROPANE GAS

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	1662 Safety Orange	Oil lines, grease fittings, inside cover of electrical switch boxes
Red	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	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 500ºF

Available at **blendsupply.com**
1.800.647.9279
orders@blendsupply.com

In the United States: **In Canada:**
1.855.6.AXALTA   **1.800.668.6945**
axalta.us   **axalta.ca**

BLEND SUPPLY
DISTRIBUTOR OF COATINGS, TOOLS & REFINISH SUPPLIES

AXALTA®