AXALTA

Specification Guide

Portable & Modular Buildings

SPECIFICATION GUIDE
PORTABLE & MODULAR BUILDING

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SPECIFICATION GUIDE

PORTABLE & MODULAR BUILDING

Introduction

We have prepared this specification guide for the Portable & Modular Building industry 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. Our approach would keep your Portable or Modular Building in good condition, easy to clean & 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 - The "Paint System" Approach

A basic feature of the simplified approach to painting Axalta has developed for Portable & Modular Buildings market, is the use of "paint systems" designed for specific substrates of your product line.

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 product line.

We have selected the proper combination for each type of application you are likely to encounter. The paint systems for outdoor use are listed in Table I. The paint systems for indoor use are listed in Table II. Both tables will allow you to readily determine the recommended system for each area or type of exposure within your product line.

Although your Axalta Coating Systems Distributor or Representative will be happy to prepare all of your facility painting specifications, you may wish to do 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 find out what paints are necessary for each system by referring to Table III. This table provides you with a brief description of each of the products specified in Tables I and II as well as application information and dry times for each of the products.

For full 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 PORTABLE & MODULAR BUILDINGS

SUBSTRATE – EXTERIOR EXPOSURE

BUILDING COMPONENT	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Roof, Walls, Support steel	Carbon Steel	**Good**	**Primer:** Tufcote® 2.5 PR™ (2-3) **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
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ + (1.5-2) or Imron® 3.5 HG™ + (2-3)	Fast dry smooth epoxy primer **New** high gloss polyurethane **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)	Satin epoxy mastic Ultra Low VOC High Gloss polyurethane **New** high gloss polyurethane **New** high gloss polyurethane
Walls	Concrete Block	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex DTM High gloss acrylic latex DTM
		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™ + (1.5-2) Or Imron® 3.5 HG™ + (2-3)	Fast dry smooth epoxy primer Ultra Low VOC High Gloss polyurethane **New** high gloss polyurethane **New** high gloss polyurethanes
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
		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)	Satin epoxy mastic Ultra Low VOC High Gloss polyurethane **New** high gloss polyurethane **New** high gloss polyurethane
Walls	Sheet Rock	**Good**	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ + (1.5-2) Or Imron® Industrial Strength (2-3) Or Imron® 3.5 HG™ + (2-3)	Fast dry smooth epoxy primer Ultra Low VOC High Gloss polyurethane **New** high gloss polyurethane

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TABLE I (CONTINUED)

PAINT SYSTEMS FOR PORTABLE & MODULAR BUILDINGS

SUBSTRATE – EXTERIOR EXPOSURE

BUILDING COMPONENT	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Sign Posts, Light Poles, Columns, Railings,	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	**DTM:** Imron® 2.1 HG-D™ **+** (4-5)	**New** DTM High Gloss Polyurethane
		Best	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (1.5-2) Or Imron® 3.5 HG™ **+** (2-3)	Fast dry smooth epoxy primer Ultra Low VOC High Gloss polyurethane **New** High gloss polyurethane **New** High gloss polyurethane
Overhead Doors, Columns, Railings, Posts	Pre-coated Metal	**Good**	**DTM:** Imron® 1.5 ST-D™ (4-5)	Waterborne urethane copolymer
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Corlar® 2.8 HG™ (2-3)	Fast dry alkyd primer High gloss epoxy topcoat
		Best	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2)	Fast dry alkyd primer **New** High gloss polyurethane
Piping & Equipment, Sprinkler Systems	Carbon Steel	**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:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Corlar® 2.8 HG™ (2-3)	Fast dry alkyd primer High gloss epoxy topcoat
		Best	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry alkyd primer **New** High gloss polyurethane
Doors, Frames & Trim	Carbon Steel	**Good**	**DTM:** Imron® 1.5 ST-D™ (4-5)	Waterborne urethane copolymer
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Corlar® 2.8 HG™ (2-3)	Fast dry alkyd primer High gloss epoxy topcoat
		Best	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry alkyd primer **New** High gloss polyurethane

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TABLE I (CONTINUED)
PAINT SYSTEMS FOR PORTABLE & MODULAR BUILDINGS
SUBSTRATE – EXTERIOR EXPOSURE

BUILDING COMPONENT	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Walls	Concrete Block	**Good**	**Primer:** Imron® 1.5 ST-D™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne urethane copolymer 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® 2.1 HG™ + (1.5-2) Or Imron® 3.5 HG™ + (2-3)	Satin epoxy mastic **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
		Best	**Primer:** Corlar® 2.1 ST™ (4-5) **Topcoat:** Imron® 2.1 HG™ + (1.5-2) Or Imron® 3.5 HG™ + (2-3)	Satin epoxy mastic **New** High gloss polyurethane **New** High gloss polyurethane
Walls	Gypsum Board	**Good**	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne urethane copolymer High gloss acrylic latex
		Better	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne copolymer
		Best	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Corlar® 2.8 HG™ (3-4)	Waterborne urethane copolymer High gloss epoxy topcoat

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TABLE II - PAINT SYSTEMS FOR PORTABLE & MODULAR BUILDINGS

SUBSTRATE – EXTERIOR EXPOSURE

BUILDING COMPONENT	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Overhead Doors, Columns, Railings, Posts	Pre-coated Metal	**Good**	**DTM:** Imron® 1.5 ST-D™ (4-5)	Waterborne urethane copolymer
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Tufcote® 3.5 HG-D™ (2-3)	Fast dry alkyd primer Alkyd DTM
		Best	**Primer:** Tufcote® 2.5 PR™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ + (1.5-2) Or Imron® 3.5 HG™ + (2-3)	Fast dry alkyd primer Ultra Low VOC High Gloss Polyurethane topcoat **New** high gloss polyurethane **New** high gloss polyurethane
Piping & Equipment, Sprinkler Systems	Carbon Steel	**Good**	**Primer:** Imron® 1.5 PR™ (2-3) **Topcoat:** Imron® 1.2 HG™(2-3)	Copolymer primer Copolymer topcoat
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Tufcote® 3.5 HG-D™ (2-3)	Fast dry alkyd primer Alkyd DTM
		Best	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ + (1.5-2) Or Imron® 3.5 HG™ + (2-3)	Fast dry alkyd primer Ultra Low VOC High Gloss Polyurethane topcoat **New** high gloss polyurethane **New** high gloss polyurethane
Doors, Frames & Trim	Carbon Steel	**Good**	**DTM:** Imron® 1.5 ST-D™ (4-5)	Waterborne urethane copolymer
		Better	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ + (2-3)	Fast dry alkyd primer **New** high gloss polyurethane
		Best	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ + (1.5-2) Or Imron® 3.5 HG™ + (2-3)	Productive Epoxy primer Ultra Low VOC High Gloss Polyurethane topcoat **New** high gloss polyurethane **New** high gloss polyurethane
Roof, Walls, Support steel	Carbon Steel	**Good**	**Primer:** Tufcote® 2.5 PR™ (2-3) **Topcoat:** Or 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
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ + (1.5-2)	Fast dry smooth 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™ + (1.5-2) **Clearcoat:** Imron® EZ-3460S™ (2)	Satin epoxy mastic Ultra Low VOC High Gloss Polyurethane topcoat **New** high gloss polyurethane High gloss easy clean clearcoat
		Best	**Primer:** Corlar® 2.1 ST™ (to fill) **Topcoat:** Imron® Ind. Strength (2.0) Or Imron® 2.1 HG™ + (1.5-2) Or Imron® 3.5 HG™ + (2-3)	Latex satin epoxy mastic Ultra Low VOC High Gloss Polyurethane topcoat **New** high gloss polyurethane **New** high gloss polyurethane

TABLE II (Continued)
PAINT SYSTEMS FOR PORTABLE & MODULAR BUILDINGS
SUBSTRATE – INTERIOR EXPOSURE

BUILDING COMPONENT	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Walls	Concrete Block	**Good**	**Primer:** Imron® 1.5 ST-D™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne urethane copolymer High gloss acrylic
		Better	**Primer:** Corlar® 2.1 ST™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™(2-3)	Satin epoxy mastic High gloss acrylic latex
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
		Best	**Primer:** Corlar® 2.1 ST™ (4-5) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron® 2.1 HG™ **+** (1.5-2)	Satin epoxy mastic Ultra Low VOC High Gloss Polyurethane topcoat **New** high gloss polyurethane
Walls	Gypsum Board	**Good**	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	Waterborne urethane copolymer High gloss acrylic latex
		Better	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Copolymer topcoat
		Best	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Corlar® 2.8 HG™ (3-4)	Waterborne urethane copolymer High gloss epoxy topcoat

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® 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 min 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.

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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 as well as 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 RTS 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.
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 RTS 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® 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.

TABLE III
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Corlar® 2.1 PR-P™ Epoxy modified polyamide	A two package smooth epoxy primer easily applied without dry overspray. Mix 2:1 with your choice of 5 activators. No induction time and long pot life.	Corlar® 2.1 PR-P™ FG-040 Activator 525-882 Buff 525-885 ANSI 61 Grey 525-971 ANSI 70 Grey Thinners T-1025 or T-1021... 5% max	2 Part 1 Part	Apply by spray only 6 mils wet 3 mils dry No reduction is necessary	Dust free 1 hours Tack free 2-3 hours To touch 1 hours To recoat 2-3 hours Hand dry 4 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
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 mil dry	Dry to touch 2-3 hours Dry to handle 4 hours Dry to recoat 3 hours
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 (colors will chalk/fade in UV)	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

TABLE III
PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
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 hours 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 hours

PAINTING

Surface Preparation

As part of Axalta's simplified approach to painting of Portable & Modular Building components, we have analyzed the various types of surface preparation most likely needed in this industry. If you follow the recommendations presented below for each of the different types of surfaces you will be painting, you will get the best results from your painting investment.

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

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

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

STEEL (except galvanized)	Good- Detergent/Solvent Clean (SSPC-SP 1) Better, Hand and power tool clean (SSPC-SP2/3) Best, Abrasive blast clean (SSPC-SP6)
GALVANIZED STEEL	Good- Detergent/Solvent Clean (SSPC-SP 1) Better, Hand and power tool clean (SSPC-SP2/3) Best, Abrasive blast clean (SSPC-SP7 or SP 11)
ALUMINUM*	Good*- Detergent/Solvent Clean, (SSPC-SP 1) or use Axalta Wash Primer Better*- Hand and power tool clean (SSPC-SP2/3) Best- Abrasive blast clean, or etched (SSPC-SP7 or SP11) * Must be anodized or alodized aluminum

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 cans sometimes double your painting productivity as compared with air spraying. There are several types of spray equipment; all designed to do particular jobs. Be sure your spray equipment is in good operating condition; fluid lines and pressure pots clean; pressure gauges and diaphragm valves operating; spray guns clean and properly adjusted. See that effective traps for water and oil are in the air feed side of each pressure pot and are bled before use. Properly adjusted spray equipment can save you money, for every stroke of the gun uses up paint and labor; wrong settings can double your spraying costs. Follow the correct spraying techniques for the job you are doing. Hold the spray gun at the right angle, keep the gun the right distance from the surface and move it correctly across the surface.

APPLICATION (Continued)

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

Roller → An economical way to apply coatings but usually not used to repaint equipment

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