AXALTA

Specification Guide

# Ski Resorts

SPECIFICATION GUIDE
**Ski Resorts**

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# Introduction

We have prepared this specification guide for Ski Resorts based on our analysis of your 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 Ski Resorts 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. Custom designed systems; in addition to that mentioned in this specification guide, are also available that meet and/or exceed your local air regulatory agency requirements. Detailed information may be obtained by contacting your authorized Axalta Coating Systems distributor for evaluation. Your Axalta Coating Systems distributor stands ready to work with you 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:

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

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# Paint Selection - The "Paint System" Approach

A basic feature of the simplified approach to painting Axalta has developed for Ski Resorts 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 Axalta Coating Systems 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
# EXTERIOR EXPOSURE

| AREA TO BE PAINTED | SURFACE | RATING | COATING SYSTEMS PRODUCTS (DFT) | COMMENTS |
|---|---|---|---|---|
| Ski Lifts<br>A) Towers<br>B) Chairs | Carbon Steel | **Good** | **DTM:** Corlar® 2.1 HTA™ (4-5)<br>Or Corlar® 2.1 ST™ (4-5) | Aluminum Epoxy Mastic<br>Satin epoxy |
| | | **Better** | **Primer:** Corlar® 2.1 PR-P™ (3-5)<br>**Topcoat:** Imron® 2.1 HG™ **+** (2-3) | High solids productive epoxy primer<br>**New** High gloss polyurethane |
| | | **Best** | **Primer:** Corlar 2.1 ST™ (4-5)<br>**Topcoat:** Imron® Industrial Strength(2-3)<br>or Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br>Ultra Low VOC High Gloss<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| Snow Making<br><u>Equipment</u><br>A) Spray Guns<br>B) Groomers<br>Snow Removal<br><u>Equipment</u><br>A) Salt Trucks<br>B) Loaders<br>C) Dump Trucks<br><u>Transportation</u><br>A) Bus<br>B) Trolley Cars<br>Buildings, Hotels, Restaurants,Bench, Doors, Railings, Gates,Fences,Roof, Trash Containers, Signs, Posts, Mail Bx, Concessions | Carbon Steel | **Good** | **Primer:** Tufcote® 2.5 PR™ (2-3)<br>**Topcoat:** Imron® 2.1 HG™ **+** (2-3)<br>or Imron® 3.5 HG™ **+** (2-3) | Fast dry alkyd primer<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| | | **Better** | **Primer:** Corlar® 2.1 PR-P™ (3-5)<br>**Topcoat:** Imron® 2.1 HG™ **+** (2-3)<br>or Imron® 3.5 HG™ **+** (2-3) | High solids productive epoxy primer<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| | | **Best** | **Primer:** Corlar® 2.1 ST™ (4-5)<br>**Topcoat:** Imron® Industrial Strength (2-3)<br>or<br>Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br>Ultra Low VOC High Gloss Polyurethane topcoat<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| Buildings,<br>Walls,<br>Rest Rooms,<br>Storage Areas,<br>Garages | Concrete Block | **Good** | **Primer:** Tufcote® 1.9 HG-D™ (to fill)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Better** | **Primer:** Corlar® 2.1 ST™ (to fill) | Satin epoxy mastic |
| | | **Best** | **Primer:** Corlar® 2.1 ST™ **+** (to fill)<br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>Or Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br>Ultra Low VOC High Gloss Polyurethane topcoat<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| Buildings, Walls | Concrete, Masonry, Stone | **Good** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Best** | **Primer:** Corlar® 2.1 ST™ (3-5)<br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>or<br>Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br>Ultra Low VOC High Gloss Polyurethane topcoat<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |

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## TABLE I (Continued)
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| AREA TO BE PAINTED | SURFACE | RATING | COATING SYSTEMS PRODUCTS (DFT) | COMMENTS |
|---|---|---|---|---|
| Signs, Sign Posts, Railings, Roof Deck, Supports, Vents, Ducts | Galvanized Steel | **Good** | **Primer:** Corlar® 2.8 HG-D™ (2-3)<br>**Topcoat:** Imron® 3.5 HG™ **+** (2-3) | High gloss, high build epoxy DTM<br>**New** High gloss polyurethane |
| | | **Better** | **Primer:** Corlar® 2.1 PR-P™ (3-4)<br>**Topcoat:** Imron® 2.1 HG™ **+** (2-3)<br>or Imron® 3.5 HG™ **+** (2-3) | Fast dry productive epoxy primer<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| | | **Best** | **Primer:** Corlar® 2.1 ST™ (3-4)<br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>or<br>Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br><br>Ultra Low VOC High Gloss Polyurethane topcoat<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| Sign, Sign Posts, Trash Containers, Railings, Storage Containers | Aluminum | **Good** | **Primer:** Tufcote® 1.9 HG-D™ **+** (2-3)<br>**Topcoat:** Tufcote® 1.9 HG-D™ **+** (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Better** | **Primer:** Imron® 1.5 ST-D™ (3-4)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | Waterborne urethane copolymer<br>Waterborne urethane copolymer topcoat |
| | | **Best** | **Primer:** Corlar® 2.1 ST™ (2-4)<br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>or<br>Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br><br>Ultra Low VOC High Gloss Polyurethane topcoat<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| Snow Making Equipment<br>A) Spray Guns<br>B) Groomers Ducts, Siding, Pipes, Screens | Fiberglass | **Good** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic waterborne DTM |
| | | **Better** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | High gloss acrylic latex<br>High gloss waterborne copolymer |
| | | **Best** | **Primer:** Imron® Industrial Strength Primer 9P01™ (2-3)<br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>or<br>Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Ultra Low VOC Polyurethane Primer<br><br>Ultra Low VOC High Gloss Polyurethane topcoat<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| Line marking | Asphalt, Poured concrete | **Good** | **Primer:** Tufcote® 1.9 HG-D™ (To fill)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Best** | **Primer:** Tufcote® 1.9 HG-D™ (Fill)<br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>Or<br>Imron® 2.1 HG™ **+** (2-3)<br>Imron® 3.5 HG™ **+** (2-3) | High gloss acrylic latex<br><br>Ultra Low VOC High Gloss Polyurethane topcoat<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |

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## TABLE I (Continued)
### PAINT SYSTEMS
# EXTERIOR EXPOSURE

| AREA TO BE PAINTED | SURFACE | RATING | COATING SYSTEMS PRODUCTS (DFT) | COMMENTS |
|---|---|---|---|---|
| Parking & stopping curbs | Concrete | **Good** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Tufcote®1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Better** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Imron® 2.1 HG™ (2-3)<br>or Imron® 3.5 HG™ (2-3) | High gloss acrylic latex<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| | | **Best** | **Primer:** Corlar® 2.1 ST™ (3-5)<br><br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>or<br>Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br><br>Ultra Low VOC High Gloss Polyurethane topcoat<br><br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| Transportation Trolley Cars Buildings, Doors, Gates, Benches | Wood | **Good** | **Primer:** Imron® 1.5 ST-D™ (3-4)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | Waterborne urethane copolymer<br>High gloss waterborne copolymer |
| | | **Better** | **Primer:** Corlar® 2.1 PR-P™ (3-4)<br>**Topcoat:** Imron® 2.1 HG™ **+** (2-3)<br>or Imron® 3.5 HG™ **+** (2-3) | Fast dry productive epoxy primer<br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |
| | | **Best** | **Primer:** Corlar® 2.1 ST™ (3-4)<br><br>**Topcoat:**<br>Imron® Industrial Strength (2-3)<br>or<br>Imron® 2.1 HG™ **+** (2-3) or<br>Imron® 3.5 HG™ **+** (2-3) | Satin epoxy mastic<br><br>Ultra Low VOC High Gloss Polyurethane topcoat<br><br>**New** High gloss polyurethane<br>**New** High gloss polyurethane |

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## TABLE II
### PAINT SYSTEMS
# INTERIOR EXPOSURE

| AREA TO BE PAINTED | SURFACE | RATING | COATING SYSTEMS PRODUCTS (DFT) | COMMENTS |
|---|---|---|---|---|
| Buildings, Hotels, Restaurants, Benches, Doors, Door Frames, Fences, Ceilings, Railings, Light Posts, Sign Posts, Storage Racks, Lockers, Containers | Carbon Steel | **Good** | **Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex |
| | | **Better** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Best** | **Primer:** Imron® 1.5 ST-D™ (2-3)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | Waterborne urethane copolymer<br>Waterborne urethane copolymer |
| Sign Posts, Signs, Railings, Roof Deck, Vents, Ducts, Pipes | Galvanized Steel | **Good** | **Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex |
| | | **Better** | **Topcoat:** Imron® 1.5 ST-D™ (2-3) | Waterborne urethane copolymer |
| | | **Best** | **Primer:** Imron® 1.5 ST-D™ (2-3)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | Waterborne urethane copolymer<br>Waterborne urethane copolymer |
| Walls, Buildings, Rest Rooms, Storage Areas, Warehouses, Garages | Concrete Block | **Good** | **Primer:** Tufcote® 1.9 HG-D™ (to fill)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Better** | **Primer:** Tufcote® 1.9 HG-D™ (to fill)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | High gloss acrylic latex<br>Waterborne urethane copolymer |
| | | **Best** | **Primer:** Corlar® 2.1 PR™ (to fill)<br>**Topcoat:** Corlar® 2.8 HG™ (2-3) | Satin epoxy mastic<br>High gloss epoxy |
| Walls | Dry Wall Plaster | **Better** | **Primer:** Tufcote®1.9 HG-D™ (to fill)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Best** | **Primer:** Tufcote® 1.9 HG-D™ (to fill)<br>**Topcoat:** Imron® 1.5 ST-D™ (2-3) | High gloss acrylic latex<br>Waterborne urethane copolymer |
| Signs, Sign Posts, Trash Containers, Railings, Storage Containers | Aluminum | **Good** | **Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex |
| | | **Better** | **Topcoat:** Imron® 1.5 ST-D™ (2-3) | Waterborne urethane copolymer |
| | | **Best** | **Primer:** Imron® 1.5 ST-D™ (2-3)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | Waterborne urethane copolymer<br>Waterborne urethane copolymer |

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## TABLE II (Continued)
### PAINT SYSTEMS
# INTERIOR EXPOSURE

| AREA TO BE PAINTED | SURFACE | RATING | COATING SYSTEMS PRODUCTS (DFT) | COMMENTS |
|---|---|---|---|---|
| Walls, Buildings | Concrete | **Good** | **Primer:** Tufcote® 1.9 HG-D™ (2 or to fill)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Better** | **Primer:** Imron® 1.5 ST-D™ (2 or to fill)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | Waterborne urethane copolymer<br>Waterborne urethane copolymer |
| | | **Best** | **Primer:** Corlar® 2.8 HG-D™ (2 or fill)<br>**Topcoat:** Corlar® 2.8 HG™ (2-3) | High gloss epoxy<br>High gloss epoxy |
| Ducts, Siding, Screens, Pipe | Fiberglass | **Good** | **Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex |
| | | **Better** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss acrylic latex<br>High gloss acrylic latex |
| | | **Best** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Imron® 1.2 HG™ (2-3) | High gloss acrylic latex<br>Waterborne urethane copolymer |
| Buildings, Frames, Benches, Gates | Wood | **Good** | **Topcoat:** Tufcote® 1.9 HG-D™ (2-3 or to fill) | High gloss acrylic latex |
| | | **Better** | **Topcoat:** Imron® 1.5 ST-D™ (2-3 or to fill) | Waterborne urethane copolymer |
| | | **Best** | **Topcoat:** Corlar® 2.8 HG-D™ (3-4 or to fill) | High gloss epoxy |
| Line marking | Poured concrete | **Best** | **Primer:** Tufcote® 1.9 HG-D™ (2-3)<br>**Topcoat:** Tufcote® 1.9 HG-D™ (2-3) | High gloss waterborne acrylic DTM<br>High gloss waterborne acrylic DTM |
| Special Applications | High temperature surfaces up to 450°F continuous/ 500°F intermittent | **Best** | Corlar® 2.1 HTA™ (4-5) | High temperature aluminum epoxy mastic |

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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. *Note: If full gloss is not required, use Imron® Industrial Strength available in various gloss levels | Imron 9TXX 9T00-A™ Activator<br><br>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 2.1 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<br><br>See PDS for application thinner details.<br><br>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.<br><br>Brush & roll optional.<br><br>Film Build: 2 - 3 mils wet<br><br>1.5 - 2.0 mils dry | Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours<br><br>May be accelerated with VG-805™ *See product data sheet. |
| **Imron® 2.1 +** Reduced Gloss Polyurethane<br><br>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<br><br>See PDS for application thinner details.<br><br>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.<br><br>Brush & roll optional.<br><br>Film Build: 2 - 3 mils wet<br><br>1.5 - 2.0 mils dry | Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours<br><br>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 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<br><br>9T00-A™ Activator<br><br>See PDS for application thinner details.<br><br>Brush & Roll Additive: 9M05™ | 4 Parts Color<br>1 Part Activator<br><br>0 to 5% Reducer<br><br>Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon | Apply by spray for Maximum Appearance.<br><br>Brush & roll optional.<br><br>Film Build:<br>3 - 5 mils wet<br><br>2 - 3 mils dry | Dry to touch: 3 hours<br>Dry to handle: 7 hours<br>Dry to recoat: 5 hours<br>May be accelerated with VG-805.<br><br>*See product data sheet. |
| **Imron® 3.5 +** Reduced Gloss Polyurethane<br><br>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<br><br>9T00-A™ Activator<br><br>9T20™ Flattener<br><br>See PDS for application thinner details.<br><br>Brush & Roll Additive: 9M05™ | 8 Parts Color<br>1 Part Activator<br><br>0 to 5% Reducer<br><br>Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon | Apply by spray for Maximum Appearance.<br><br>Brush & roll optional.<br><br>Film Build:<br>3 - 5 mils wet<br><br>2 - 3 mils dry | Dry to touch: 3 hours<br>Dry to handle: 7 hours<br>Dry to recoat: 5 hours<br>May be accelerated with VG-805.<br><br>*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<br>VF-525 activator<br>Y-32035 for spray, 5% | 1 Part<br>1 Part | Brush, roll or spray<br>**Primer:** 3-8 mils dry<br>Mid-coat: 4-6 mils dry | Dry to touch 2-3 hours<br>Dry to handle 4 hours<br>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 Activators<br>FG-040 Reducers<br>Brush, Roll & Hot weather<br>T-1025<br>Cold Weather<br>T-1021 | 2 Part<br>1 Part | Apply by spray only<br>6 mils wet<br>3 mils dry<br>No reduction is necessary | Dust free 30 minutes<br>To touch 1 hour<br>To recoat 45 minutes<br>Hard dry 2 hours |

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## TABLE III
## PRODUCT DESCRIPTIONS (Continued)

| Product | Description | Components | Mix Ratio | Application | Dry Times @ 70°F |
|---|---|---|---|---|---|
| **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<br>1 Part | Brush, roll/spray<br>Single coat:<br>5-8 mils dry non-corrosive. 10-12 mils corrosive<br>Primer: 3-8 mils<br>Mid coat: 4-6 mils<br>Immersion:10-12 | Dry to touch 2-3 hours<br>Dry to handle 4 hours<br>Dry to recoat 3 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<br>1 Part<br>1 hour induction | Brush, roll or spray<br>8 mils wet<br>5 mils dry | Dry to touch 3 hours<br>Dry to handle 16 hours<br>Dry to recoat 16 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<br>1 Part<br>1 hour induction | Brush, roll or spray<br>3 mils wet<br>2 mils dry | Dry to touch 3 hours<br>Dry to handle 16 hours<br>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<br>5.5 mils wet<br>2 mils dry | Dry to touch 1 hour<br>Dry to handle 3 hours<br>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<br>2 mils dry | Dry to touch 30 minutes<br>Dry to handle 2 hours<br>Dry to recoat 1 hour |

SPECIFICATION GUIDE
**Ski Resorts**

# Surface Preparation

As part of Axalta's simplified approach to painting for Ski Resort, 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 to 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 areas that are protected from the wind.

## Application Methods

The method you select for painting depends on the type of surface being painted, 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. Conventional air spray is most commonly used, but for very large flat surfaces, you should consider using airless spraying. Airless spraying will be able to double your painting productivity as compared to conventional 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 method 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 (C) 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 or Authorized Distributor.

SPECIFICATION GUIDE
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# Material Selection & Color

## Putting Color & Material Selection to Work for You

Many of our customers believe that keeping their Ski Resorts looking clean and freshly painted is vital to their success. Color selection can help you in many ways. Maintaining corporate identity is key in today's economy to differentiate one Ski Resort from another. Painting has proven to be the most valuable, yet inexpensive method of satisfying your customer's expectations of your Ski Resort. Many of our customers have surveyed their guests and found that their customer base has been developed from people that visit their facility and see a well-maintained, clean Ski Resort, and based on this positive experience return again and again. This leads to the fundamental question "*How can I Best (A) maintain my Ski Resorts and do this economically?*" The answer is Material Selection.

Axalta has a heritage for being a recognized leader in long-term performance. The long-term durability of Axalta Coating Systems products has been proven through our customer base, many independent studies, and Axalta owned assets. Axalta features a variety of coatings providing long-term gloss retention, long-term color retention, coatings to resist the wear and tear of your guests, and easy to clean products resulting in reduced maintenance cost over the lifetime of the coating.

To increase the life cycle of coatings and to reduce maintenance costs, many Ski Resorts today are using an Imron® Polyurethane clear topcoat to further protect their painted surfaces from strong UV exposure, and the wear and tear of guests. Your Axalta Representative or Authorized Distributor is trained to evaluate your facility, recommend coatings systems and coating application methods to meet your long-term needs as well as local regulatory agency's.

Contact your authorized Axalta Coating Systems Distributor. For a representative near you, call us toll-free at 1 855 6 AXALTA.

SPECIFICATION GUIDE
**Ski Resorts**

# 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 | 1162 Safety Orange | Oil lines, grease fittings, inside cover of electrical switch boxes |
| Red | 1664 Safety Red | Fire protection equipment, high-pressure sprinkler valves and lines |
| Aluminum | 1HTA25P | Steam and condensate lines, hot surfaces, boilers, stacks, cooling fins on air compressors, hot equipment to 500°F |
| Black | 1640 Black | Drain lines, waste water |
| White | 1632 White | Electrical conduit, beams and hanger rods |
| Light Brown | 1635 Tan | Low pressure air line 40 psi or less |
| Dark Brown | 1288 Brown | High-pressure air lines over 40 psi |
| Light Green | 1062 Spotlight Green | Chilled water lines |
| Medium Green | 1666 Safety Green | City water lines |
| Light Blue | 1638 Falls Blue | Cooling water lines |
| Safety Blue | 1665 Safety Blue | Electrical switch boxes, controls breakers |
| Light Gray | 1637 Cirrus Gray | Machinery-compressors, pumps, motors |

**In the United States:**
**1.855.6.AXALTA**
**axalta.us**

**In Canada:**
**1.800.668.6945**
**axalta.ca**