



# Tufcote™ CE 609C

## High-Gloss Centerband Polyurethane

(Formerly CenturyExtreme™ 609C)



### GENERAL

#### DESCRIPTION

The Tufcote™ CE 609C is a high gloss polyurethane coating specially formulated for application onto the centerband area of tank cars to provide additional chemical protection from splash and spillage of a wide variety of commonly transported chemicals. The Tufcote™ 609C has excellent adhesion, hardness, impact resistance and exterior UV stability

#### SUGGESTED USES

The Tufcote™ CE 609C is intended for use over properly coated steel substrates and is designed to provide a durable, high gloss, chemical resistant exterior finish.

- Tank Car Centerband
- Railcar Manufacturing and Refurbishment
- Steel Storage tanks
- Marine/OEM/Industrial Maintenance

#### RECOMMENDED SYSTEMS

1 CT, Tufcote™ CE 181 applied at 4-10 mil DFT  
1 CT, Tufcote™ CE 609C applied at 2-4 mil DFT (Applied to Centerband Area Only)

1 CT, Tufcote™ CE 602 applied at 4-8 mil DFT  
1 CT, Tufcote™ CE 609C applied at 2-4 mil DFT (Applied to Centerband Area Only)

1 CT, Tufcote™ CE 184 applied at 5-10 mil DFT  
1 CT, Tufcote™ CE 609 applied at 2-4 mil DFT  
1 CT, Tufcote™ CE 609C applied at 2-4 mil DFT (Applied to Centerband Area Only)

#### PERFORMANCE PROPERTIES

Chemical	Excellent
Humidity	Excellent
Weather	Excellent
Impact	Excellent

#### COLORS AVAILABLE

Black  
White  
Custom Colors Available



### MIXING

#### MIXING RATIO

3:1 BY VOLUME  
3 PART BASE / 1 PART ACTIVATOR

#### COMPONENTS

Base:  
Black, 609C-B300-101  
White, 609C-W300-102

Activator:  
609C-V-102



### REDUCTION

No thinning/reduction required for airless application. If thinning is desired, consult your Axalta Industrial Coatings representative for thinning amounts for specific VOC requirements.

### POT LIFE

Temperature	
104° (40°C)	45 Min.
77°F (25°C)	2 Hr.
60°F (15°C)	2.5 Hr.



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## APPLICATION

### SURFACE PREPARATION

This product is intended for application over the Tufcote CE™ 181, Tufcote™ CE 609 or Tufcote™ CE 602. Contact your Axalta representative for additional recommendations. Poor surface preparation will reduce the overall performance and service life of the coating. For best results, surfaces should be clean, dry and free of loose rust, dust, dirt, oil, grease, salt deposits or other contaminants. Test an inconspicuous area for lifting or softening of existing coating prior to full application.

### APPLICATION CONDITIONS

Substrate and air temperatures must be at least 5°F (3°C) above the dew point and rising. Water condensation on the new film may cause surface imperfections and poor cure. Do not apply when Relative Humidity exceeds 85%. Avoid placing freshly painted components outdoors under wet, rainy conditions. Lower temperatures (< 60°F) will increase dry times. Do not use this product when temperatures fall below 50°F. Substrate temperatures above 120°F may cause the product to sag, curtain, or run.

### APPLICATION DATA

Coating Thickness:	2-4 Mil DFT
Coverage:	358 Sq. Ft/Gal @ 3 Mil DFT
Full Cure:	10 Days @ 77°F
Re-coat:	3 Hr. @ 77°F

### SPRAY APPLICATION

#### Airless Spray

Pressure:	2,000 – 2,500 psi
Tips:	0.015” – 0.019”

#### Spray

Spray Gun:	DeVilbiss MBC-510
Fluid Nozzle:	E
Atomizing Pressure	60-65 psi
Air Cap:	704

### BRUSH & ROLL APPLICATION

These products may be applied by brush or roller for touch-up. Use nylon or other brushes designed for solvent based paints. Use ¼” rosin core roller covers designed for solvent-based paints. See application Guidelines for detailed instructions.

### CLEAN UP THINNERS

Flush all paint supply lines immediately after application. Clean equipment Axalta thinners 10-T-101 or 10-T-120. Use soap and water to remove any material from hands or skin.



## DRY SCHEDULE

Cure time at 3 mil DFT

Temperature	Dry Touch	Dry-Handle	Dry-Decal
104° (40°C)	1 Hr.	2 Hr.	3 Hr.
77°F (25°C)	4 Hr.	5 Hr.	6 Hr.
60°F (15°C)	7 Hr.	10 Hr.	12 Hr.
50°F (10°C)	11 Hr.	15 Hr.	17 Hr.



## PHYSICAL PROPERTIES

Finish	High-Gloss
Mixed VOC	2.06 lbs./gal
Volume Solids	67% +/- 1%
Weight Solids	73% +/- 1%
Theoretical Coverage Per Gallon	1074 ft <sup>2</sup> @ 1 mil DFT 358 ft <sup>2</sup> @ 3 mils DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Package Size:

Base: 1-gallon Pail, 5-gallon pail (3-gallon fill)

Base: 1-quart Pail, 1-gallon pail (.75-gallon fill)

## RECOMMENDED STORAGE CONDITIONS

Store components between 55°F and 100°F. Store in dry shaded/covered conditions away from sources of heat and ignition.

Shelf-Life, Part A, 24 Months-Unopened, 77°F

Part B, 24 Months-Unopened, 77°F

## SAFETY AND HANDLING

Please contact your Axalta representative for acceptable alternatives to the thinners listed above. Use soap and water to remove any material from hands or skin. Cleanup solvents or thinners are recommended to be used in accordance with each facilities Environmental, Health and Safety standards, regulations and procedures. Please read and understand the Safety Data Sheet before using this product.