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RENOVATION

121 E 22nd Ave, Coal Valley, IL

ADDENDUM #1 03/01/2023

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STREAMLINE ARCHITECTS, P.L.C. ANDREW DASSO, AIA 575 12TH AVENUE EAST MOLINE, IL 61244 (563) 345-2724 Streamline www.streamlinearchitects.com

R	~~	

OWNER SHALL ACCEPT ALTERNATES IN ANY ORDER OR COMBINATION. PRICING FOR EACH ALTERNATE AND THE BASE BID SHOULD BE PROVIDED ON BID FORM (INCLUDED IN BID PACKAGE). **BIDDING ALTERNATES**

ADDENDUM 1

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ALT 1A.-PANILION WI ROOF OPTION 1:
PROVIDE ALTERNATE PRICING FOR THE PAVILION WITH ROOF
CONSTRUCTION OF WHITE TOO MEMBRANE ON COVER BOARD ON
METAL ROOF DECKING, (A301.15)

ALT 18 - PANILION W/ ROOF OPTION 2: PROVIDE ALTERNATE PRICING FOR THE PAVILION WITH ROOF CONSTRUCTION OF VINITE TPO MEMBRANE ON COVER BOARD ON WOOD DECKING, (ADDITA)

ALT 10: PAYILION SIDE PANELS: PROVIDE PRICING OF THE GEDAR PANELS ON THE PAVILION ELEVATIONS AND THE RESTROOM, (AZBO, AZBO) ALT 1C: PANLION WI RODF OPTION 1:
PROVIDE ALTERNATE PRICING FOR THE PAVILION WITH ROOF
CONSTRUCTION OF POLYGAL PC). 10MM @ 48" O.C. SCREWED INTO
STRUCTURE AND 276 CEDAR SUSPENDED FROM STRUCTURE.

ALT TAK PURMITURE AND LIGHTING OPPION 1:
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PEDESTRAM LIGHTING, FORMAS-SURFACES CORDIA BENCH, AND
DERO ROLLING BIRET PACK. ANT Z. VETERAN'S AREA.
PROVIDE ALTERNATE PREINIS FOR THE VETERAN'S AREA
FOUNDATION, FLAGFOLGE CONCRETE, CONCRETE BENCH &
FOUNDATION, FLAGFOLGE, AND ELECTRICITY, MEMORAL IS NOT
INCLUDED IN THIS SET.

ALT 19: FURNITUEE AND LOCHTMC OPTION 2:
PROVIDE PROGNO STEE FURNITUEE AND LOCHTMC AMARKED AS 38
ON SHEET FAMOR BALLUDING AND LOCHTMC ALUMRUMALIGHT
COLLIMA KEYSTOME BROGE DESIGNAS EXTERS BENCH, AND
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KEYSTOME RUDGE DESIGNAS EXTERS BENCH, AND

ACT DE L'EMETTRE AND L'ONTRO DE PROVINCE PRICE PACES AND CONTROL PRICE PACES A ALT 4: CONCRETE BENCH WALLS AT PLAYGROUND PROVIDE PRICING FOR WAUSAU PRECAST BENCH WALL AND ASSOCIATED FOUNDATIONS AT PLAYGROUND,

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GENERAL NOTES

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VILLAGE OF COAL VALLEY

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ALL WORK TO BE COMPLETED IN ACCORDANCE TO THESE SPECIFICATIONS.

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5 days prior to final inspection. This copy will be reviewed comments. Revise content of all document sets as required

NOAH STRAUSSER (563) 219-0568 noah@streamlinearchite

STREAMLINE ARCHITECTS, P.L.C. ANDREW DASSO, AIA 575 12TH AVENUE EAST MOLINE, IL 61244 (563) 345-2724 Streamine www.streamlinearchitects.com

VILLAGE OF COAL VALLEY

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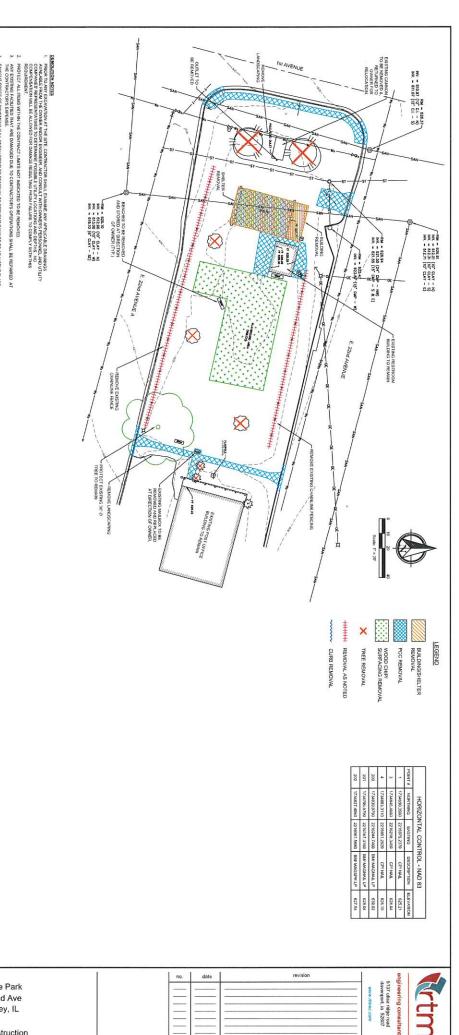
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SPECIFICATIONS A003





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I hereby certify that this engineering document was prepared by me or under my direct porsonal supportision and that I am a duly licensed Phylessional Engineer under the Laws of the State of Minois.

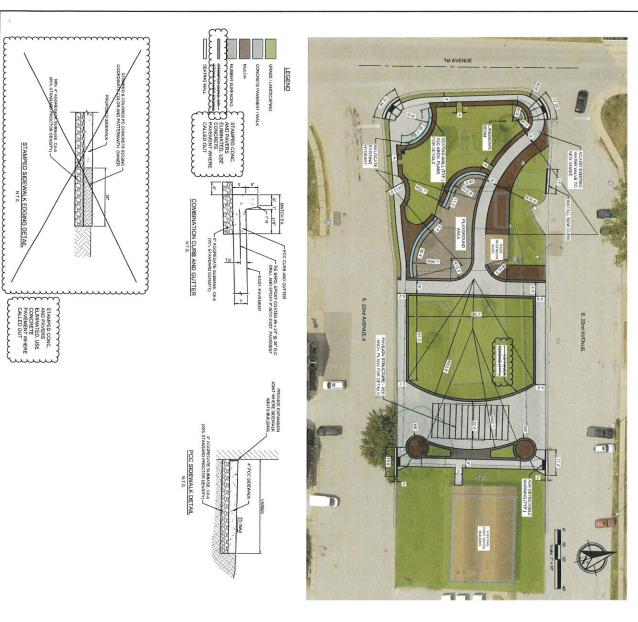
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PCC FOR PAVENENT AND DRIVEWAYS SHALL BE CLASS BY AND FOR SIDEWALKS SHALL BE CLASS SI IN COMPLIANCE WITH FIDOT SECTION 1020. PROVIDE FROM AN IDOT CERTIFIED SOURCE, MEETING ALL OF THE FOLLOWING CHARACTERISTICS.

INE FINISH. 4" MAXIMUM FOR HAND FINISH

AIR ENTRAINMENT: 5-8 PERCENT.

B. DOWEL BARS. EPOXY COATED COMPLYING WITH IDOT SECTION 1096,11.

JONET SEALER (FOR PAVEMENT AND DRIVEWAYS). COLD-POURED OR HOT-POURED JOINT SEALER COMI 102901 AND 1050.02.

PROTECTIVE ANTI-SPALLING AGENT: PROTECTIVE COATING IN COMPLIANCE (DOT SECTION 102), SEALANT SHALL BE A NON-'GLOSSY' TYPE THAT DOES NOT AFFECT SURFACE TEXTURE. CUT PERMETER OF REMOVALAREAS FULL DEPTH, REMOVED EXSTINCE PAREMENT AND EXCAVATE TO SOUND SUBBASE MATERIAL OLD REMOVE, LIMITS SHOWN IN THE PROFESSE AND REMOVAL L

CUT AND REMOVE SIDEWALK TO THE NEAREST JOINT BEYOND REMOVAL LIMITS SHOWN IN THE DRAWINGS. FRADING NOTES FOR SUBGRADE PREPARATION AND AGGREGATE SUBBASE REQUIREMENTS.

PROCEED WITH CONCRETE PURCEMENT WHEN AIR TEMPERATURE IS AT LEAST 34" F AND RISING. DISCONTINUE CONCRETE
PLACEMENT WHEN THE AIR TEMPERATURE IS 38" F AND FALLING, OR IF THE TEMPERATURE STOPS RISING AND DOES NOT REACH 38
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PLACEMENT AIR THE PLACEMENT AIR THE TEMPERATURE STOPS RISING NG AND MANAGEMENT OF FRESH CONCRETE, INCLUDING TRANSPORTATION TIME, SHALL BE PER IDOT SECTION 420. URE THAT THE TOP 1 INCH OF THE AGGREGATE SUBBASE IS UNIFORMLY MOIST PRIOR TO PAVING.

DO NOT PLACE CONCRETE WHEN STORMY OR INCLEMENT WEATHER OR TEMPERATURE PREVENTS GOOD WORKMANSHIP DO NOT PLACE CONCRETE ON A FROZEN SUBGRADE OR SUBBASE.

CURBS AND GUTTERS, DRIVEWAYS, AND PCC PATCHING SHALL HAVE ARTIFICIAL TURF FINISH MATCHING ADJACENT PAVEMENT SIDEWALKS SHALL HAVE STRAIGHT BROOM FINISH, SMOOTH CORNERS, AND TROWELED JOINT EDGES.

PROVIDE EXPANSION JOHTS AT BUILDING.
MARK JOINT LOCATIONS WITH A STRING LINE BEFORE SAWING

C. PROVIDE TED JOINTS BETWEEN ADJACENT POURS.

TRANSVERSE JOINTS, 46 X 30" @ 12" ON CENTER, EPOXY COATED,
LONGITUDINAL JOINTS, KEYNAY WITH \$4 X 30" @ 30" ON CENTER, EPOXY COATED,

BEGIN ALL TRANSVERSE JOINT SAWING AS SOON AS THE CONCRETE HAS HARDENED SUFFICIENTLY TO ALLOW SAWING WITHOUT RAVELING OR MOVING OF AGGREGATE. SAW JOINTS BEFORE UNCONTROLLED CRACKING TAKES PLACE.

JOINTS WITHIN 24 HOURS OF CONCRETE BEING PLACED.

JOINTS SHALL BE FILLED WITH HOT-POURED JOINT COMPOUND FOR ALL PAVED SURFACES EXCEPT SIDEWALKS OR PATIOS. MINIMUM AMBIENT TEMPERATURE IN THE SHADE FOR APPLICATION OF HOT-POURED JOINT SEALER IS SO'F AND RISING. MENT SHALL HAVE THE FOLLOWING MAXIMUM JOINT SPACING SURB AND GUTTER: MATCH EXISTING SPACING, 15 MAXIMUM.

, APPLY WHITE PIGMENTED LIQUID CURING COMPOUND ON THE SURFACE AND VERTICAL EDGES OF CONCRETE AS SOON AS THE FREE WATER HAS APPRECIABLY DISAPPEARED, BUT NO LATER THAN 30 MINUTES AFTER FRUSHIND. ENTRANCE DRIVE: 15' MAXIMUM.
SIDEWALK: 5' OR EQUAL TO THE WIDTH OF THE WALK UNLESS OTHERWISE

C. PROTECT CONCRETE DURING HOT WASTNER CONCINOUS TO PRESENT PREMATURE LOSS OF MOISTURE.

FAMOUR ON THE TOTAL CONCRETE SURVIVOR THE MOISTURE WASTNER AND SALLED ACCRET TO ALL CONCRETE APPROXIMATION ACCORDING TO THE MOISTURE AND ACCRETATION AND CONCRETE WASTNERS AND ACCRETATION ACCORDING THE MOISTURE AND ACCRETATION ACCORDING THE MOISTURE AND ACCRETATION ACCRETATION.

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POST OFFICE PARK COAL VALLEY, IL

STREAMLINE ARCHITECTS

C-2

LAYOUT



- A PRISTALL ERGISION CONTROL AS MECESSARY.

 B. REMOVE TOPSOIL FROM AREAS TO BE FURTHER EXCAVATED OR AREAS TO RECEIVE PAVEMENT. STOCKPILE FOR LATER RESPREADING. AREAS WITHIN THE INFLUENCE LIVE OF BUILDING FOUNDATIONS, WALKS AND OTHER HADD TEATURES WILL REQUIRE A 45%. STANDARD PROCTOR DESISTY WITH COMESYIE SOLE, HOW-COMESTIVE SOLES IN THESE, AREAS WILL REQUIRE A 59%, STANDARD PROCTOR DESISTY FER ASTAN DASS, MARYTAN MOSTURE WITHIN 8 TO 4%, ABOVE OFTIMAM MOSTURE CONTENT.

engineering consultants 5137 ulica ridge road davenport, la 52807

- SLOPE GRANES SO AS TO PROMOTE POSITIVE DIRVIANCE AS MICH AS POSSIBLE. REMOVE LARGE STOKES, BOLLDERS AND DEBRIS FROM THE SITE. ROUTE GRADING SHALL BE FINISHED BY BLADING TO REASONABLY SMOOTH CONTOURS WITH UNFORM TRANSITIONS AND SLOPES.
- E. SLOPES 3.1 OR GREATER SHALL BE SEEDED AND COVERED WITH MULCH, EHOSION CONTROL BLANKETS, OR OTHER METHOD APPROVED BY ENGINEER.
- A. BEFORE PUACING ANY FILL, THE SITE SHALL BE STRIPPED AND SCARIFIED TO A DEPTH OF 9 INCHES AND RECOMPACTED TO DENSITIES INDITED HEREIN, IF REDUIRED COMPACTION CANNOT BE ACCOMPLISHED, REMOVAL OF MATERIAL MAY BE REQUIRED.
- REMOTE SOFT AREAS OF SUBSACE EXCANDE EXCANDED IN PACES AND RECYCL, WITH SUTFALE EXCETTE SOFT-SITE AND THE SOFT AREAS OF A SOFT AND THE SOFT AND A SOFT AND

- A. SPREAD A MINIMUM OF 6" OF TOP SOIL OVER BITTRE PORTION OF SITE TO BE SEEDED.

 S. TOP SOIL STALL BE MITHOUT DEBRIS, ROCKS LARGER THAN ½", SOIL CLUMPS LARGER.

 S. TEEDING AND FERTILLIZHO.

- PARSEAURANCE CONTINUED. ACE, ED REMED UNCCEPTABLE, CONTROP SHALL REMOVE BUSITABLE MATERIAL WAS REPLACED FOR THE PARKET BUSINESS. THE PARSEAURANCE CONTROL THE PARKET BUSINESS. THE PARSEAURANCE CONTROL THE PARKET BUSINESS. THE PARSEAURANCE CONTROL THE PARSEAURANCE CONTROL
- CONSTRUCT GRANALAR BASE URBNO CRUSHED STONE OR GRAVEL COMPLYING WITH DOT SECTION YOM, GRADATION CAR.
 ESTIGNO CRANALAR BASE URBNO CRUSHED OF PANEMER YOT JANTING BULTING, SECWAL, OR EXCENDE AVABERIT.
 MARTING PRIMAL MOSTERIE.
 MARTING PRIMAL MOSTERIE.
 ESSIGE THAN MOSTERIE.
 ESSIGE THAT TOP YO SE MUSICAST CARROLL MOST PRICE TO CAMPLETED SWIBSTER
 DO NOT ALLOW HALLING EQUIPMENT AND OTHER TRAFFOC ON COMPLETED SWIBSTE.

EROSION AND SEDIMENT CONTROL NOTES:

- AN MAPEES GREEAU, PERMIT ILRIO CONSTRUCTION ACTIVITIES IS REQUIRED FOR THIS PROJECT, IT IS THE CONTRACTORS RESPONSBULTY TO MONITOR, INSPECT AND MARTIAN IT HE SITE AS REQUIRED BY THE PERMIT. A SWAPP BRIGHER WILL BE PROJED AND COMP "SAULL BE KERT OIL BE AT ILL TIMES. SEE EROSION CONTROL PLAY FOR EROSION AND SEDIMENT CONTROL REQUIREMENTS. CONTRACTOR SHALL DIFFERE TO ALL TOPS COAL YNLEY EROSION AND SEDIMENT CONTROL REGULATIONS, ILLINOIS URBAN INAMAL, AND ALL IEFA RILLES AND REGULATIONS.
- CONTRACTOR SHALL PROVIDE POSITIVE DRAINAGE AT ALL TIMES WITH NO PONDING.
- REGISIAN CONTROL JULIST EE INSTALED REIGHTO ANY EARTH MOVING OPERATIONS (OR AS SOON AS PRACTICAL) IT IS THE CONTRACTORS RESPONSEULTY ON INSTALL EDGISION CONTROL DEASSURES INCLUDING SILT FENCE, SEDIMENT TRAPS, CHECK DAMS, DIVERSION SWALES, ETC. AS REQUIRED UNTIL VEGETATION IS ESTABLISHED.
- LOCATION OF EROSION AND SEDIMENT CONTROL DEVICES ON PLANS IS THE PRODUKINET A CONTROL PLACEMENT TO BE DETERMINED BY CONTRACTOR AND DOCUMENTED AS NECESSARY DURING PROGRESSION OF CONSTRUCTION ACTIVITIES.
- CONTRACTOR SHALL PREVENT OFF-SITE TRACKING OF SEDIMENT, ANY SEDIMENT DEPOSITED ON PUBLIC ROADWAYS SHALL BE REMOVED IMMEDIATELY.
- ALL DISTURBED AREAS SHALL BE COVERED WITH TOP SOIL, FINE GRADED, SEEDED, AND FERTILIZED, AREAS SHALL BE COVERED WITH EROSION CONTROL BLANKETS, FLEXIBLE GROWN MEDIUM, OR OTHER METHOD APPROVED BY ENGINEER
- IF NO ACTIVITY OCCURS OR IS ANTICIPATED FOR 14 DAYS, THE AREA SHALL BE STABLICZED WITHIN 7 DAYS OF LAST ACTIVITY WITH TEMPORARY SEED COVERED BY MALCH OR EROSION CONTROL BLANKETS.

 RROR TO SUBMITTING A NOTICE OF TERMINATION, A VEGETATIVE DENSITY OF 70% MUST BE ACHEVED OVER THE ENTIRE SITE.

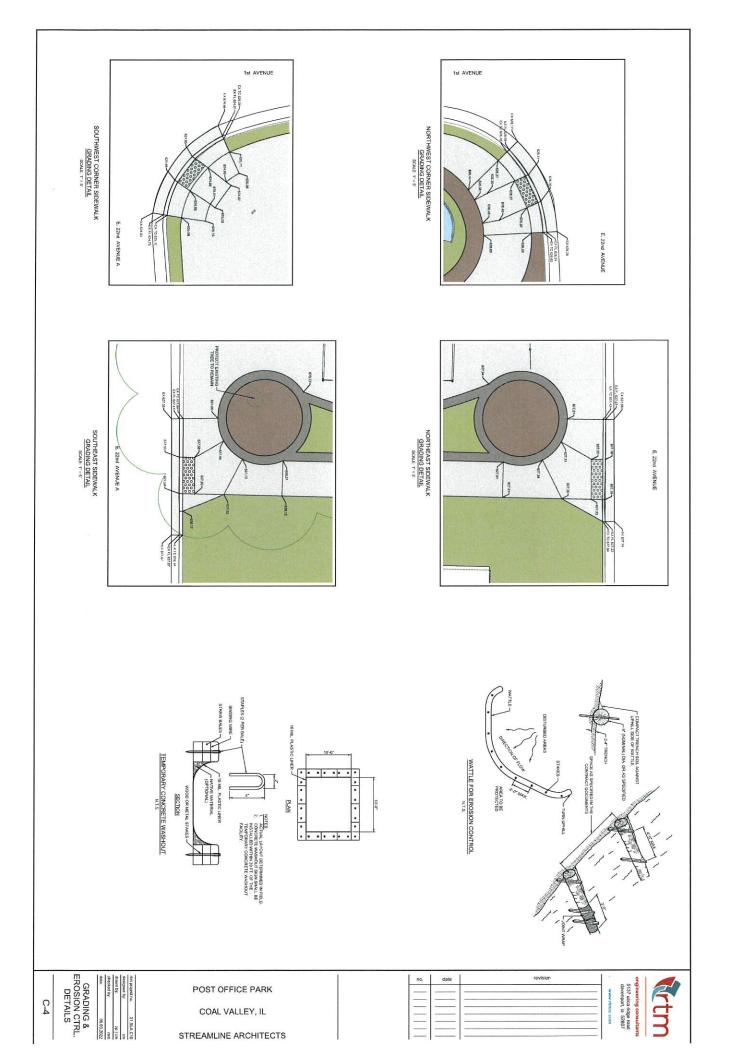
GRADING & EROSION CTRL

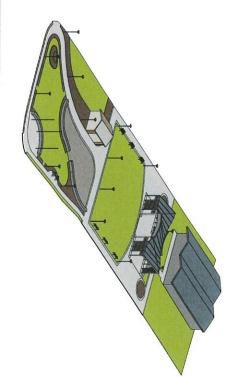
PLAN C-3

POST OFFICE PARK

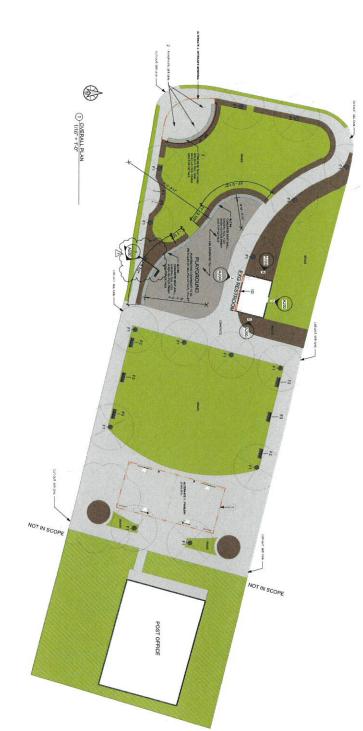
COAL VALLEY, IL

STREAMLINE ARCHITECTS





FLOOR PLAN GENERAL NOTES



(a) conc	SC FURN	3B FURN	JA FURN	O VETE	(D) PAVIL	1C PAVIL	18 PAVIL	1A PAVIL	BASE BASE DID TO SITEMORK. VETERAN'S	ALT DES	ALTER
CONCRETE SEAT WALL AT PLAYGROUND	FURNITURE AND LIGHTING OPT 3 (SEE A500)	FURNITURE AND LIGHTING OPT 2 (SEE A500)	FURNITURE AND LIGHTING OPT 1 (SEE ACOD)	VETERAN'S AREA (NOT INCLUDING MEMORIAL SEE AT	PAVILION SIDE PANELS (SEE A300)	PAVILION W/ ROOF OPT 3 (SEE A301)	PAVILION W/ HOOF OPT 2 (SEE A301)	PAVILION W/ ROOF OPT 1 (SEE A301)	BASE BID TO INCLUDE RESTROOM UPDATES, SITEWORK, ALL CONCRETE APART FROM VETERAN'S AREA	DESCRIPTION	ALTERNATES LEGEND

OVERALL PLAN

A101

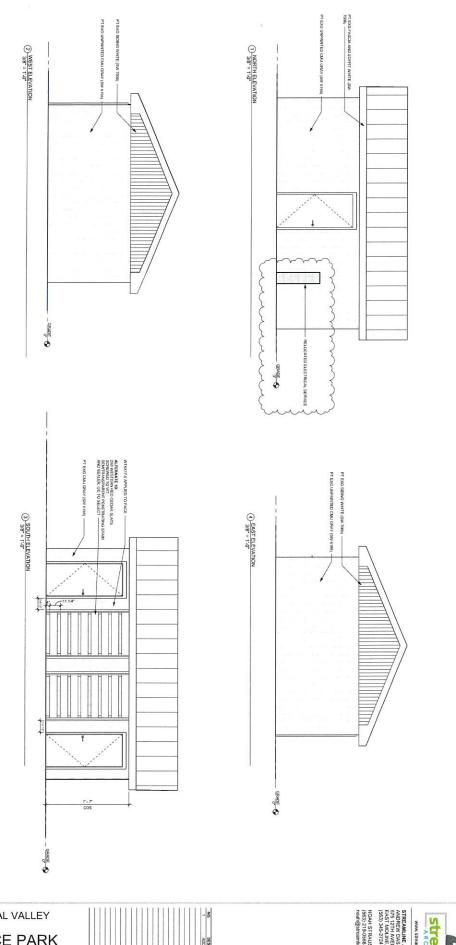
VILLAGE OF COAL VALLEY

POST OFFICE PARK







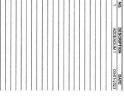




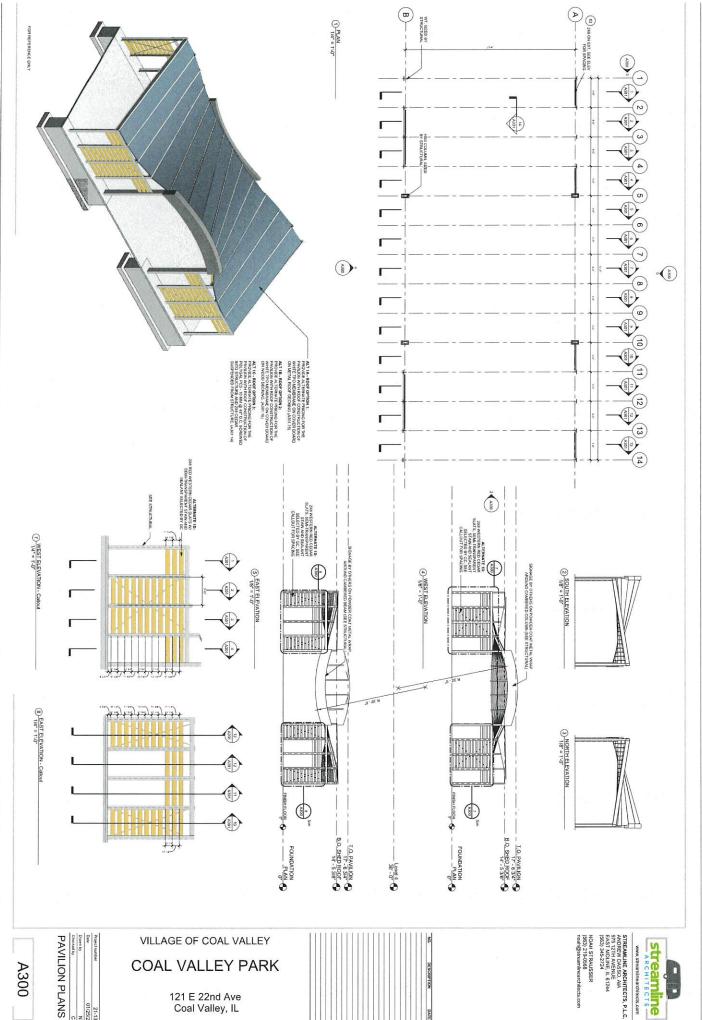
A200

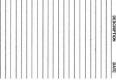
VILLAGE OF COAL VALLEY

POST OFFICE PARK

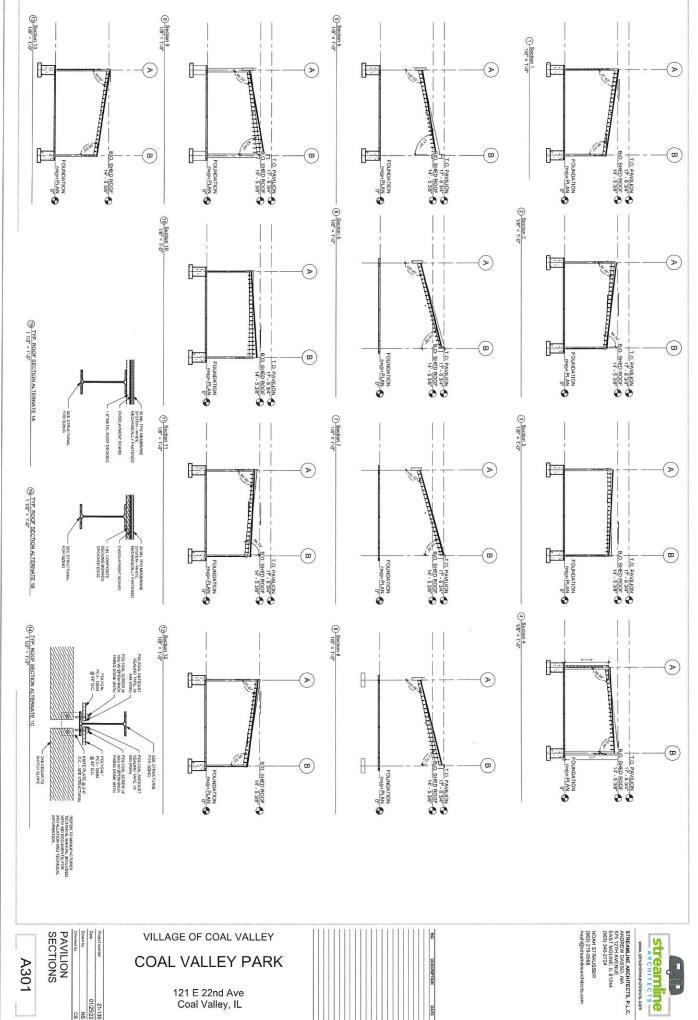








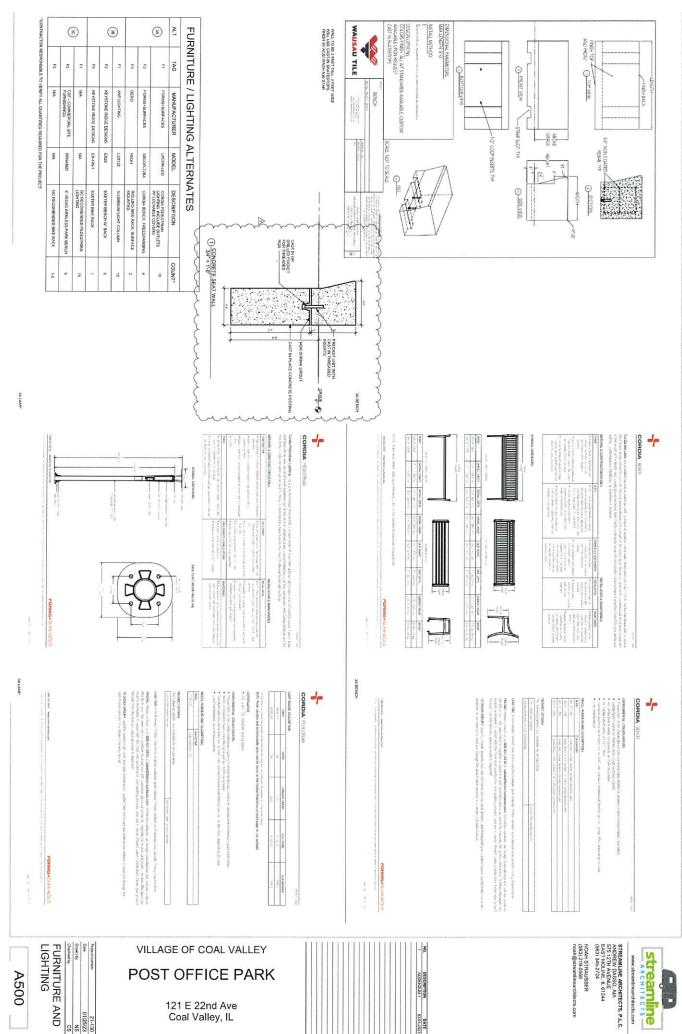




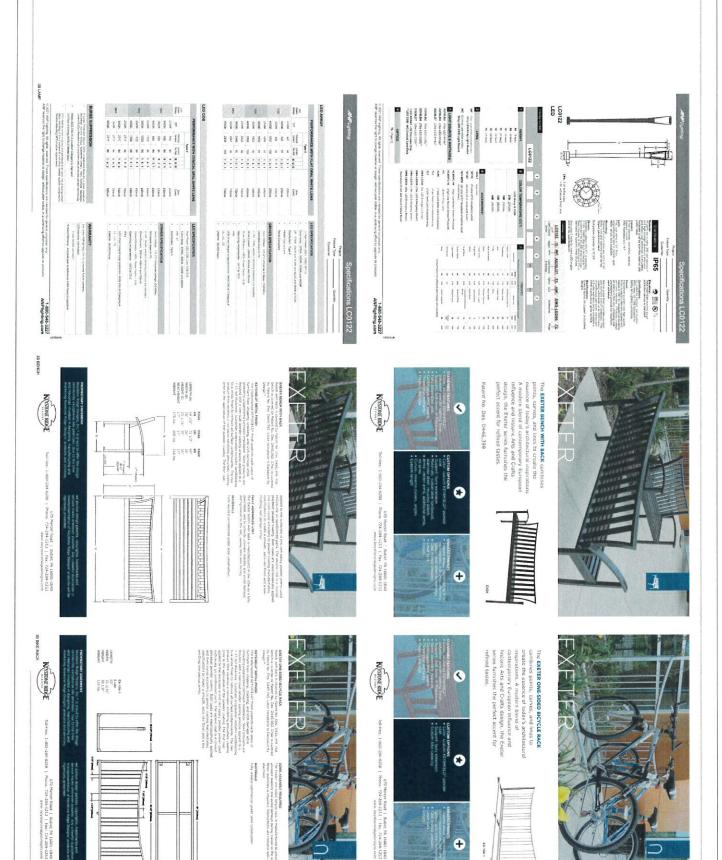
A301







Streamline



Date 0125/3

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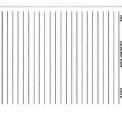
PURNITURE AND

LIGHTING

A501

VILLAGE OF COAL VALLEY

POST OFFICE PARK



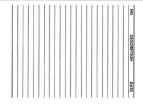


1/16" = 1:-0"

VILLAGE OF COAL VALLEY

POST OFFICE PARK

121 E 22nd Ave Coal Valley, IL





ELECTRICAL PLAN

AS REQUIRED BY THE CITY OF COAL VALLEY, IL, ACCORDANCE WITH THE FOLLOWING CODE(5): SNOW LOAD: 1) GROUND SNOW LOAD [Pg] 2) SNOW EXPOSURE FACTOR [Cf] 3) SNOW IMPORTANCE FACTOR 4) THERMAL FACTOR [Cf) WIND LOAD J BASE WIND SPEED (3 SEC GUST) WIND INFORTANCE FACTOR J WIND INFORTANCE FACTOR J WIND EXPOSURE J WIND EXPOSURE SJINTERNAL PRESSURE COEFFICIENT INTERNATIONAL BUILDING CODE - 2015 RESPONSE MODIFICATION FACTOR (R) USED. SITE CLASS. BASIC SEISMIC FORCE RESISTING SYSTEMS DESCRIPTION: STEEL SYSTEMS NOT SPECIFICALLY DETAILED FOR SEISMIC MIC USE GROUP MIC IMPORTANCE FACTOR CTRAL RESPONSE COEFFICIENTS

- ENGINEER REFERENCES OF THE STRUCTURAL DRAWNINGS TO ENGINEER MEAN THE STRUCTURAL ENGINEER OF RECORD OTHER ENTITIES ARE SPECIFICALLY NOTED AS TONTRACTORS ENGINEER, MECHANICAL ENGINEER, ETC.
- UNDERGROUND UTILITIES LOCATE EXISTING UTILITIES, AND NOTIFY ENGINEER OF EXISTING UTILITIES OR SUBGRADE CONDITIONS WHICH INTERFERE WITH WORK.
- CONTRACT DOCUMENTS HAVE BEEN PREPARED USING AVAILABLE DRAWINGS AND SITE OBSERVATION AS PERMITTED BY ACCESS RESTRICTIONS DURING DESIGN.
- JURISHO CORRINATING I HE CORMACTOR MAY RECOUNTER EXSTRAC CONDITIONS WHICH ARE RECOVERED EXPENDED TO THE CONTROL OF THE THAT HOST SET HOW.

 DEASON OF THE CONTROL OF THE C
- CONTRACTOR SHALL FIELD VERIFY ALL EXISTING STRUCTURAL CONDITIONS PRIOR TO SUBMITTING SHOP DRAWINGS.
- CONTRACTOR SHALL MAKE ALLOWANCE FOR THE RESOLUTION OF SUCH DISCOVERIES IN THE CONSTRUCTION SCHEDULE.

- B. WHERE ISCREPANCES OCCUP RETWEEN FAMS, DEFAUS AND CREMEN AND IS, HE MORE STRUGERY RECORDERABITISTS WAY, DOEAN DEFAUS ON PROMYRONS FAR PRECEDENTS OFFR GREENA, MOTES AND "PHICAL DEFAUS, DEFAUS NOTED TYPICAL, APPLY TO ALL SMALLAR CONDITIONS WHERE HO SPECIFIC DEFAUS. ARE SHOWN, CONSTRUCTION SHALL CONFIDENT TO SMALLAR WORK ELECTROPIEC OF THE PRODUCT;
- THE STRUCTURE IS DESIGNED TO FUNCTION AS A URIT UPON COMMETION. THE CONTRACTOR IS RESPONSIBLE FOR FUNKINSHED AND THE STRUCTURE TO A THE RESULT OF THE CONTRACTOR'S CONSTRUCTION METHODS AND/OR SEQUENCES.

CONTRACTOR'S CONSTRUCTION AND/OR ERECTION SEQUENCES SHALL REGOGNAZE AND CONSIDER THE EFFECTS OF THERMAL MOVENIENTS OF STRUCTURAL ELEMENTS DURING THE CONSTRUCTION PERIOD.

- DEMINANCE CONTRACTOR REQUESTS A CHANGE FROM THE STRUCTURAL DRAWINGS, IT SHALL BE APPROVED AND DESIGNED BY THE ENGINEER OF RECORD PRICES TO SUBJECTIVE SHOP DRAWINGS. VARIATION SHALL, REMOCRETION THE SHOP DRAWINGS. THE CONTRACTOR SHALL COMPENSATE CARR ENGINEERING, ILLE FOR CHANGES.
- CONSTRUCTION DOCUMENTS SHALL NOT BE REPRODUCED FOR USE IN SUBMITTALS.
- - SUBSTITUTIONS: ENGINEER'S APPROVAL SHALL BE SECURED FOR ALL SUBSTITUTIONS
- NON-CONFORMANCE, NOTIFY ENGINEER OF CONDITIONS NOT CONSTRUCTED PER CONTRACT OCCUMENTS PROBE TO PROCEEDING WITH CORRECTING WORK, SUBJUIT PROPOSED REPAIR TO THE ENDINGER FOR ACCEPTANCE CONTRACTOR SHALL COMPRISANTE CARRED/ORDERIGNO, LLC FOR DESIGN.

 OF THE REPAIR.
- THE STRUCTURE IS DESIGNED TO FANCIDIA AS AURIT UPON COMPETION NOTHING SHOWN ON THE STRUCTURAL PRIMINGS SHALL IE CONSTRUCTOR SHALL THE MEED FOR THE CORPITATION TO COMPY WITH ALL OSHA REQUIREMENTS. THE CONTINUE OR SHALL ADD ALL NECESSARY HOLTS, WASHO BOLTS, STHE-HEIR PUNTES, STRUKER PLYTES, BRIGGING, BEACHING, BEARNIS SEATS, COLUMN SPLICES ETC., AN WELL AS CLOSHINES FOR POPEMINGS.
- WASHERS OR RINGS SHALL BE WELDED TO STEEL COLUMNS TO PROVIDE FOR SAFETY CABLES, DO NOT PLACE HOLES IN COLUMNS WITHOUT APPROVAL OF THE STRUCTURAL BNGINEER.
- WHERE THE STRUCTURAL DRAWNICS APPEAR TO CONFLICT WITH OSHA REOLINBEMENTS, THE STRUCTURAL DRAWNICS REPRESENT FINAL CONDITIONS ONLY; THE CONTRACTOR SHALL ADD ALL ERECTION FRAMING THAT MAY BE NECESSARY TO COMEY, WITH OSHA.
- E SENUCIUME DEPINEDINI THE CONTRACTI DOCUMENTS HAS BEEN DESIGNED ONLY FOR LOADS ANTIQENTES I I THE STRUCTURE DURINGITIS SERVICE HER, PROVICE ALL REQUIREDE LOGICIMETRIN AND OTHER MANSAURES TO THE MEANS, METHODS AND SEQUENCES OF WORK, SUCH ENQINEERING MAY MALLICE, BUT IS NOT LIMITE
- CENSION OF FORMATOR, SUPERIO AND RESHORMA.

 SECTION PROCEDURES WHEN ANDERS STAMLITY OF THE FRAME DURING CONSTRUCTION OF STEEL.

 RECTION PROCEDURES.

 FRAME PROCEDURES

- SHUCHUAN, DAMRIGSHE NOT STANDANGHE DODJARITS AND AME INTENDIOT ONE USERD NO CONJUNCTION WITH CHUN, ARCHTECTURAL, HECHMOLAL, ELECTROLAL, HED DAMANDS FROM OTHER DISCIPLINES THE CONTRACTOR SHALL COORDINATE ALL REQUIREMENTS OF THE CONTRACT DOCUMENTS NTO SHOP DEVANESS, AND WORK.
- A. SPECIAL INSPECTION SHALL BE PROVIDED PER IBC 2015 CHAPTER 17, SEE SHEET S102 FOR INSPECTION SCHEDULE.

- REFER TO ARCHITECTURAL DRAWINGS FOR BUILDING LOCATION ON THE SITE, FLOOR ELEVATION AND OTHER PERTINENT SITE AND BUILDING INFORMATION.

- UNLESS NOTED OTHERWISE, NEW FOOTINGS SHALL CENTER UNDER THE WALLS, PIERS OR COLUMNS,
- WATER SHALL NOT BE ALLOWED TO ACCUMULATE IN THE EXCAVATION, PROVIDE PUMPS, IF NECESSARY, AND OPERATE NIGHT AND DAY, WHENEYER REQUIRED.
- THE BASE OF ALL FOOTING EXCAVATIONS SHALL BE OBSERVED BY THE SOILS ENGINEER PRIOR TO PLACEMENT OF CONCRETE.
- THE GEOTECHANCAL ENGREERS SWALL DETERMINE SUTABILITY OF EXSTING SOIL FOR SUPPORT OF NEW FOOTINGS AND SLABS, WHERE REQUIRED BY THE SOILS ENGRABER, REMOVE AND REPLACE EXISTING SOIL WITH CONTROLLED, COMPACTED FIL.
- CHELL DALED WHITH THE RELIGIOLANES SMALL RE WITH COR, THAT IS APPROOD BY THE GESTIONES, MEGNESSE, CER BLIFES NO COMPACT IN STREET COMPANIES BETHER ECOMMENDATIONS OF THE GESTIONES CHESSED CER BLOOSE FIFTS OF BROWN, STREET COMPANIES BETHER ECOMMENDATIONS OF THE GESTIONES AND COMPANIES SOFT, BETHER DATE OLASSIPATIONS OL. O. O. H. H. OF THE PROZERWANTERS. WHILE GESTIONES AND RESERVATIONS OF THE STREET ALTERS. CHESSED, TO SAMMAN SAMD STOKES THAT INTESTED RETHER OF THE COMPANIES THE STREET ALTERS. CHESSED, AT LESST TW.
- TAL SHOULD BE PACED OR SHAREL DIFFORDER BURFACES MORNIFEREN MORROWERLE UTTE INTO THE PROCESSES.

 THAT ARE COMMAINE, WITH THE COMMATINE LOCUMENT USED, OF CORRELAY MOR COMPRIGHT MORE AND THE TOWN OF T

- CONCRETE WORK SHALL CONFORM TO ALL REQUIREMENTS OF ACT 201-59, SPECIFICATIONS FOR STRUCTURAL CONFIGER FOR BUILDINGS, EXCEPT AS MODIFIED BY SUPPLEMENTAL REQUIREMENTS CONTAINED IN THE FOLLOWING MOTES.
- UNLESS OTHERVISE DETAILED OR NOTED, REINFORGING SHALL BE IN ACCORDANCE WITH "THE ACIDETAILING MANUAL SP-06."
- ALL CORORER TESTING SHALL BE PERFONNED WIDER THE DIRECT SUPERVISION OF A QUALIFIED ENGINEER WHO IS ULERISED TO PROCIFICE BLITHE STATE OF LILLOUS. HET TESTING AGENCY SHALL MEET REQUIREMENTS CONTANED IN ASTIM EZQ. SEE SPECIFICATIONS FOR TESTING REQUIREMENTS.

- FIELD EXPERIENCE METHOD: IF THE FIELD EXPERIENCE METHOD IS SELECTED, THE PROPOSED MIX DESIGN MUST BE ACCOMPANIED BY THE COMPLETE STANDARD DEVIATION ANALYSIS.
- COMPRESSIVE STRENGTH STRENGTH RECUIREMENTS AT 28 DAYS AND THE LOCATION OF EACH TYPE OF CONCRETE HEDUNED FOR THIS PROJECT SHALL BE AS FALLOWS:
- USE STRENGTH 4 KSI 4 KSI 0,50 0.50 529 LB/CU, YD X AGGREGATE SIZE ž 3/4 2/ CEMENT TYPE ORE ORI

- COORDINATE DIMENSIONS OF ALL OPENINGS, BLOCKOUTS, DEPRESSIONS, ETC, WITH DRAWINGS FROM OTHER DISCIPLINES. PROJECT SHOP DRAWINGS, AND FIELD CONDITIONS PROR TO SHOP DRAWINGS SUBMITTAL

EARTHWORK NOTES:

- ELEVATIONS GIVEN THUS ARE TO THE TOP OF FOOTINGS, SLABS, BEAMS, JOISTS, ETC. WITH REFERENCE TO THE FINISHED FLOOR ELEVATION = $(\sigma \cdot \sigma')$.
- COTECHNICAL INVESTIGATION HAS BEEN CONDUCTED FOR THIS SITE, ALLOWABLE SOLI BEKING HAS BEEN INBRIED BY THE GOWNER TO PROBBITABINE BY THE BY HEAD BY THE OWNER TO PROBBITABINE PROBBITATION FACILITIES AND THE OWNER TO PROBBITATION EXCANATIONS TO DETERMINE IF THE DESIGN BEARWIG PRESSURE HAS BEEN ACHIEVED.
- EXCAVATE CAR STRUCTURE TO ELEVATIONS AND CIMENSIONS SHOWN, EXTENDING EXCAVATION A SUFFICIENT DISTANCE. TO PENNIT PALADIA AND REMOVIAL, OF OTHER WORK FOR INSPECTION. TRIM BOTTOM TO REQUIRED LINES AND GRADES TO PROVIDE SOLID BASE TO RECEIVE CONCRETE. SOIL BEARING PRESSURE FOR FOOTING
- NEW FOOTINGS SHALL REST ON FIRM, UNDISTURBED SOIL OR CONTROLLED

- SIMMET SHOP DOMANICAS FOR FARRICATION AND FACEMENT OF CONDICTIES REPROGRAGIO, SHOWN PALAN REVORMED SOCIALIZATION OF SALE HIGHLIGHTS SOCIALIZATION OF SALE HIGHLIGHTS STORMED AND SHOP AND SALE HIGHLIGHTS STORMED AND SHOP AND SHOP AND SHOP AND SHOP AND SHOP DAMANICAS WILL HE FOR COMPLIANCE WITH PESSON HEIGHTS HE CONTRACTOR SHALL HE RESPONSIBLE FOR VERPING CHRISTIAN AND DAMANICAS HAND THE SIGNAL REPROGRAMMENT OF THE CONTRACTOR SHALL HE RESPONSIBLE FOR
- PREPARE DESIGN MIXES FOR EACH TYPE AND STRENGTH OF CONCRETE BY EITHER LABORATORY TRAL BATCH OR FIELD EXPERIENCE METHODS AS SPECIFIED IN ACL 301.
- TRUL EN THE HETHOUR THAL HATCHES ARE USED, AND INDEPENDENT TESTING LANDGATORY, APPROVED BY THE ARCHITECT, STALL REPEARE, MAKESGRISK THE MAKE DESIGN STAME, LIE PROPORTIONED TO ACHEVE AN AVERAGE STRENGTH OF 1200 PSI HUNHER THAN THE SPECIFIED STRENGTH IP'C).
- SLUMP SHALL BE 4" MAXIMUM, 2" MINIMUM FOR STRUCTURAL SLABS.

 MIX CONCRETE SHALL BE IN COMPLIANCE WITH REQUIREMENTS OF ASTIX CB4, AND AS HEREIN SPECIFIED.
- SLUMP LMITS

- STRUCTURAL STEEL WORK SHALL COMPORM TO REQUIREMENTS CONTAMED IN "SPECIFICATIONS FOR STRUCTURAL STEEL BUILDINGS. A LOUVABLE STREES SEGIEN AND PLASTIC DESIGN," INCLUDING COMMENTARY AND SUPPLEMENTS. BY THE AMERICAN INSTITUTE OF STEEL CONSTRUCTION (ASC).
- ALL WELDING PROCEDURES, WELDING EDIDPHENT AND WERD CHARGEST OVALIFICATION SHALL BE IN COMPLIANCE WITH CHRREN AMERICAN WELDING SOCIETY ANSI, COCES, PRODUCE CERTIFICATION THAT WELDERS TO BE EMPLOYED IN THE WORK HAVE SATISFACTORILY PASSED ANS QUALIFICATION TESTS.
- CONCRETE AT MAIN FLOOR LEVEL FINISHED
- ROUR TO ERECTING STEEL, EXAMINE THE EXISTING WORK OF OTHER CONTRACTORS ON WHICH THIS WORK IS IN ANY ANY DEPENDENT AND REPORT ANY ERRORS OR DISCREPANCIES, WHICH WILL AFFECT THIS WORK, TO THE GENERAL ONTRACTOR,

STREAMLINE ARCHITECTS, P.L.C. ANDREW DASSO, AIA 575 12TH AVENUE EAST MOLINE, IL 61244 (563) 345-2724

Streamine www.streamlinearchitects.com

NOAH STRAUSSER (563) 219-0568 name@streamlinearchit

CONTRACTOR SHALL VERBY ALL DIMENSIONS AND CONDITIONS PRICIE TO FARRICATION OF THE STEEL MEMBERS, CEMBREER, MACHEET, OF ANY CONDITIONS THAT CONFLICT WITH BEFORMATION CONTANED IN CONSTRUCTION CLIMBREER, MACHEET, OF ANY CONDITIONS THAT CONFLICT WITH BEFORMATION CONTANED IN CONSTRUCTION

MATERIAL SPECIFICATIONS:

- STRUCTURAL STEEL WIDE FLANGE AND TEE SECTIONS SQUARE, ROUND OR RECTANGULAR TUBING STRUCTURAL STEEL CHANNELS, ANGLES, PLATES, ETC. TANDARD MACHINE BOLTS ... ASTM 500-GR-B (46 KSI)
- ANCHOR RODS HIGH STRENGTH BOLTS... ASTM A307 (WOOD TO STEEL CONN) ASTM F1554 GR.36 THREADED
- ALL A25, AND AND BOLTS LISED IN CONNECTIONS OF BEAMS AND GIRDERS TO COLUMNS SMALL BE TENSIONED TO THE VALUES OF TABLE A, OF "SPECIFICATION FOR STRUCTURAL STEEL BUILDINGS, ASD"AISC 1989. DTHER HIGH STRENGTH BOLTS MY BE INSTALLED SINJG TIOHT AS GETWED BY AISC.

WIRE ROPE END FITINGS

- STRUCTURAL STEEL CONVECTIONS NOT OTHERWISE DETALED OR NOTED SHALL BE FARBICATED AND ERECTED AS STANDARD CONNECTIONS IN ACCROMANCE WITH HOSE SHOWN IN THE LATEST EDITION OF THE AISC MANUAL OF STEEL CONSTRUCTION AND STRUCTURAL STEEL DETAILING MANUAL.
- ATION TOLERANCES SHALL BE IN CONFORMANCE WITH THE AISC
- ALL STEEL TO RECEIVE ONE COAT OF PRIMER, FINISHED COAT TO BE APPLIED IN FIELD, REFERENCE ARCHITECTURAL DRAWINGS FOR PAINT REQUIREMENTS.
- ERECTION INCLUDES THE INSTALLATION OF ALL ITEMS COVERED BY THIS SECTION INCLUDING ALL REQUIRED CONNECTIONS AND FASTENINGS.
- INSTALL ADHESIVE ANCHORS IN STRICT CONFORMANCE WITH THE MANUFACTURER'S RECOMMENDATIONS
- DO NOT USE GAS-CUTTING TORCHES IN THE FIELD FOR CORRECTION OF FABRICATION ERRORS IN THE STRUCTURAL FRAMING
- NON-SHRINK GROUT CONFORM TO ASTMICTIDT, GRADES BIOR C, ACHIEVE 5000 PS) COMPRESSIVE STRENGTH AT 28 DAYS.

3294 Fields Drive Bettendorf, IA 52722 563,503,6100

STRUCTURAL SERVICES CARR ENGINEERING, L.L.C.

DESCRIPTION

COAL VALLEY PARK

PAVILION

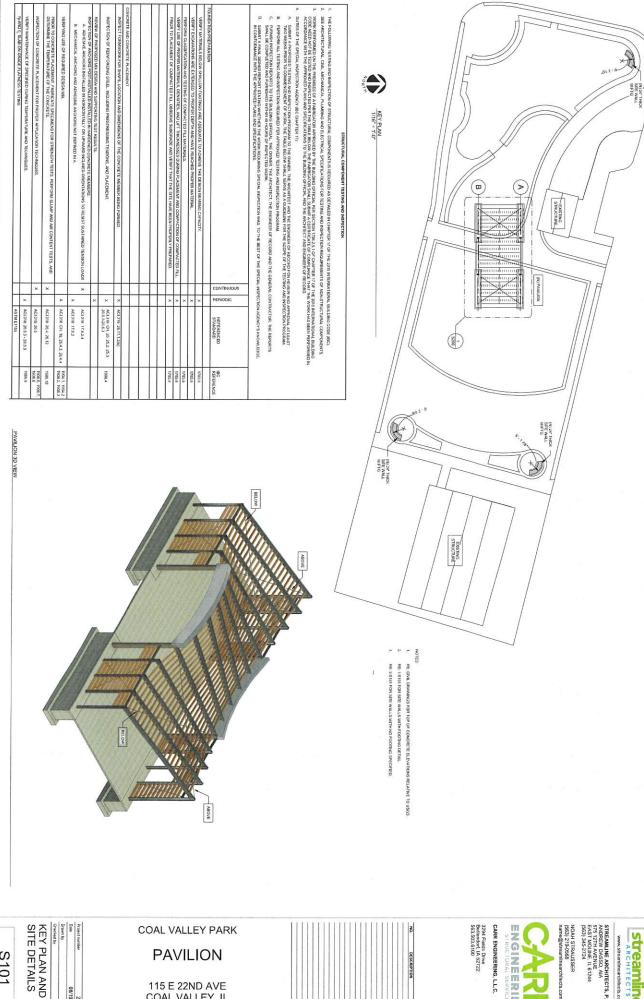
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GENERAL NOTES

S100

FOOTING STEP =



S101

22-053 08/19/2022 WDH CMC

PAVILION

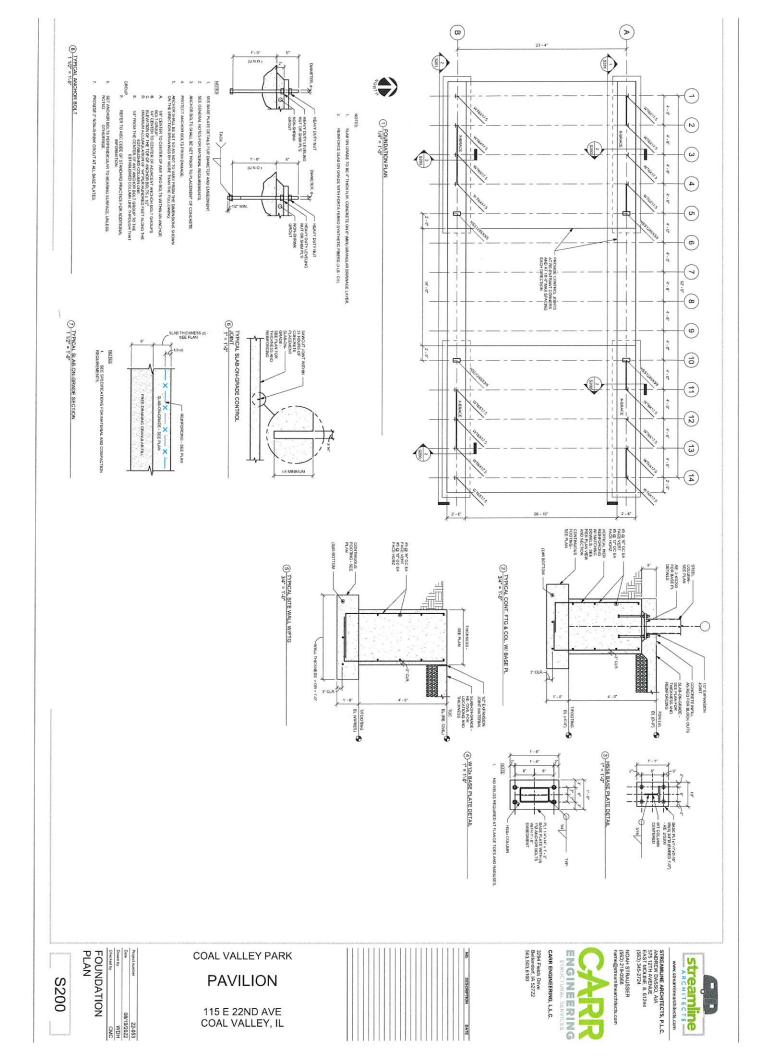
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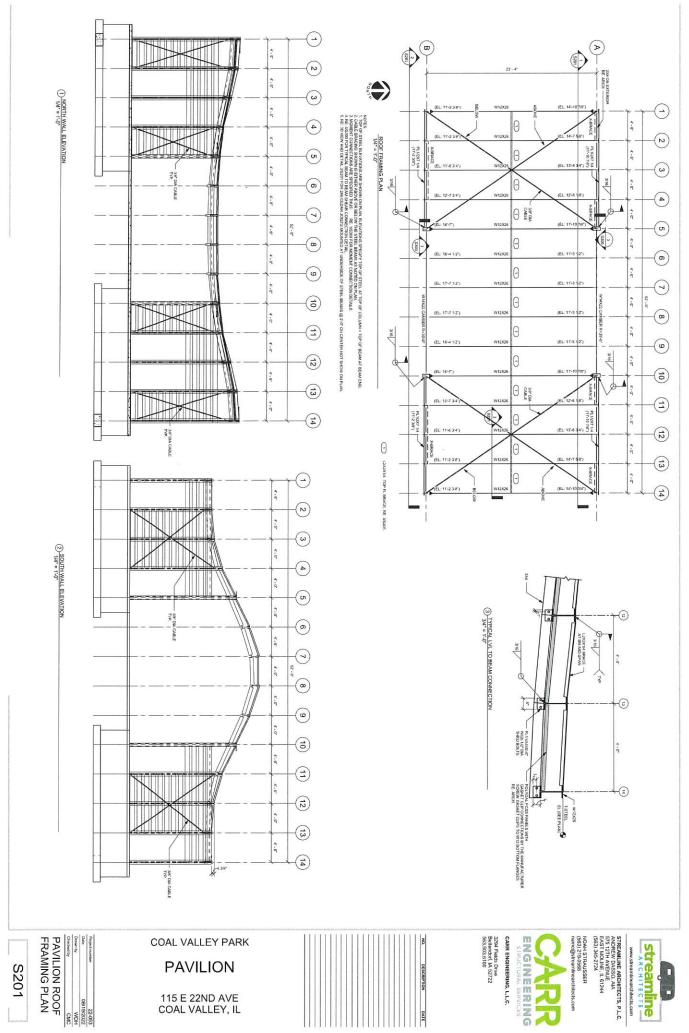
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STREAMLINE ARCHITECTS, P.L.C. ANDREW DASSO, AIA 575 12TH AVENUE EAST MOLINE, IL 61244 (563) 345-2724 NOAH STRAUSSER (563) 219-0568 name@streamlinearchitects.com



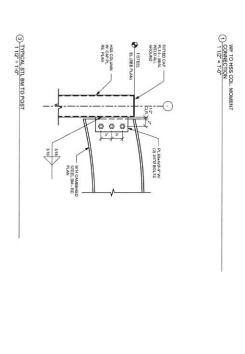


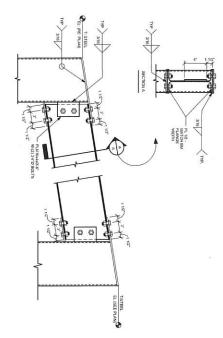












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COMPLETED BY THE PARTITION OF BEAM

ADDRESS OF BEAM

AD

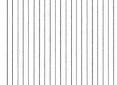
2) BRACE FRAME DETAIL (TOP VIEW)

COAL VALLEY PARK

(4) TYPICAL SHEAR CONNECTION 1 1/2" = 1'.0"

PAVILION

115 E 22ND AVE COAL VALLEY, IL



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575 T2TH AVENUE
575 T3TH AVEN



575 12th Ave East Moline, IL 61244 (563) 345-2724

Coal Valley Park Addendum 1

March 3rd, 2023

Questions

- 1. What is the base of the seat wall?
 - a. Concrete Seat wall has been revised to be Alternate 4. See additional details on A500. See attached Manufacturer specifications.
- 2. Is the seat wall included in the memorial portion or the base bid?
 - a. Seat wall at Memorial to be part of Alternate 2.
- 3. Drainage from the playground?
 - a. 4" Drainage Fill as noted
- 4. Where is electrical coming from on the site?
 - Existing Meter and electrical service located on existing park shelter to be relocated to North Elevation of existing restroom shelter.
- 5. What is the pattern of the stamped concrete and the color?
 - a. Stamped Concrete has be replaced with standard concrete per C-2
- 6. What is the paint scope on the steel at the pavilion for the alternate?
 - a. Primer: Sherwin-Williams B69A00008- zinc clad IV organic zinc-rich epoxy primer binder. Note: to be applied at steel shop
 - b. Intermediate coat: B58W00610- Macropoxy 646 fast cure epoxy part A
 - c. Finish: B65W00651 Acronlon 218 hs polyurethane- semi-gloss (part a) black Follow all prep and application instructions in attached Sherwin-Williams specification.
- 7. Are the steel rails that hold wood slats also part of Alternate 1d?
 - a. Yes
- 8. Also I see the overhead slats at the pavilion are shown with Alternate 1C are they to be stained?
 - a. Yes, Stain and Sealant to match wall panels

Announcements

- 1. Send all future questions to <u>andrew@streamlinearchitects.com</u>, and cc <u>noah@streamlinearchitects.com</u>.
- 2. Bid Date is revised to March 10th, 2023 at 1pm.



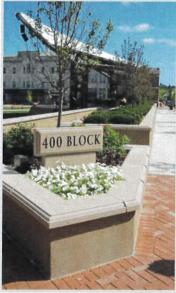
CUSTOM PRECAST CONCRETE

ARCHITECTURAL DETAILS & SPECIFICATION



















DIRECT: 715.359.3121 | MAIN: 800.388.8728 MAILING: P.O. Box 1520, Wausau, WI 54402-1520 SHIPPING: 9001 Business Hwy 51, Rothschild, WI 54474



PRECAST CONCRETE ARCHITECTURAL DETAILS SPECIFICATIONS

WAUSAU TILE PRECAST CONCRETE SPECIFICATION	1-5		
DETAILS TREADS			
FULLY SUPPORTED			
C30 C31 C36 C40 C51	6 7 8 9 10		
LANDSCAPE TREAD	11		
SELF SUPPORTING C60 (WELD) C60 (BOLT) C70 (WELD) C70 (BOLT) TEARDROP	12 13 14 15 16		
POOL COPING	47		
SAFETY EDGE SQUARE EDGE FULL BULLNOSE TYPICAL CORNERS	17 18 19 20		
CURB			
RECTANGULAR CHAMFERED TYPICAL CORNERS COLUMN CAP BENCH PLANTER WALL	21 22 23 24 25 26		
INSTALL METHODS			
FULLY SUPPORTED (TREADS) SELF SUPPORTING (TREADS) MISC	27 28 29-30		
DESIGN OPTIONS			
DESIGN OPTIONS ABRASIVE STRIPS MISC			



Custom Precast Concrete

Section 03 04 00

Part 1 - General

1.01 SUMMARY

- A. Perform all work required to furnish and complete the proper installation of precast concrete.
- B. Types of Precast Concrete work include:
 - 1. Precast Concrete Stairs
 - 2. Precast Concrete Caps
 - 3. Precast Concrete Benches
 - 4. Precast Concrete Copings
 - 5. Precast Concrete Veneer
 - 6. Precast Concrete Planters
 - 7. Precast Concrete
- C. Setting material, grouts, sealants and caulks
- D. Installation of precast concrete
- E. Related work not specified under this section
 - 1. Installation of steel units to receive precast concrete
 - 2. Installation of Concrete substrate to receive precast

1.02 REFERENCES

- A. American Society for Testing and Materials (ASTM)
 - 1. ASTM C-150
 - 2. ASTM C-128
 - 3. ASTM C-260
 - 4. ASTM C-31
 - 5. ASTM C-494
 - 6. ASTM C-39
- B. Precast Concrete Institute (PCI)

1.03 SUBMITTALS

- A. Shop Drawings
 - 1. Submit fabrication drawings of all precast concrete items showing detailed sections and profile for all precast items. Details shall show all reinforcing and cast in hardware.
- B. Samples
 - 1. Submit 1 sample for color and texture approval.
 - a. Color to be selected from manufacturer's standard offerings.
 - b. Match existing or architect's sample
 - c. Custom Sample Number
- C. Submit a copy of manufacturer's Quality Assurance and Procedure Manual
- D. Performance Requirements
 - 1. Compressive Strength 5,000 p.s.i. minimum
 - 2. Air Content 6-8%



- 3. Water-Cement Ration .45
- 4. Deflection Max: L/720

E. Test Results

1. Manufacturer shall furnish test results attesting that materials meet specification requirements.

1.04 QUALITY ASSURANCE

- A. Qualifications: Precast Concrete Manufacturer and Trade Contractor must have a minimum of 5 years of successful experience on projects of similar magnitude and complexity to the indicated project.
- B. Manufacturer and contractor to be prequalified by Architect prior to bidding and failure to do so will void bid.

1.05 DELIVERY, STORAGE, AND HANDLING

- A. Packaging and Shipping: precast concrete to be palletized, shrink wrapped and marked with legible manufacturer identification, including piece number and quantities.
- B. Storage and Protection precast concrete to be stored in secure area in original packaging.
- C. Protect from damage by other trades.
- D. Report all damage due to shipment immediately. Customer is required to sign the Bill of Lading slip detailing the damaged product. Picture proof is required.

1.06 WARRANTY

A. For a period of two (2) years from delivery of precast concrete, manufacturer warrants the precast concrete products against defects in workmanship and materials per industry standards. This warranty does not cover the above products for cracking and faulting caused by settling due to improper or faulty substrates or improper installation; nor does it cover damage caused by impact, vandalism or natural disaster.

PART 2 - PRODUCTS

2.01 MANUFACTURERS

- A. Acceptable Manufacturer:
 - 1. Wausau Tile, Inc. | 1.800.388.8728 | info@wausautile.com | www.wausautile.com
- B. Clarification Note: Drawings and specifications are based on manufacturer's proprietary literature from Wausau Tile, Inc. Other manufacturers shall comply with minimum levels of material specifications and detailing indicated on the drawings of specified herein.

2.02 MATERIAL REQUIREMENTS

- A. Portland Cement: ASTM C-150 Specifications for Portland Cement.
- B. Aggregates: Aggregate shall be blended to meet individual project requirements.
- C. Coloring; Pigments used shall be inorganic, resistant to alkalinity and used per manufacturer's recommendations.
- D. Reinforcement and Hardware:
 - 1. Reinforce precast with deformed rods as recommended by precast concrete manufacturer.
- E. Abrasive Inserts: Shall consist of silica sand and epoxy.



- Abrasive Color: _____
- 2. Specify one to three lines.
- F. Setting Materials, Caulks & Sealants
 - 1. Color(s) to be selected by Architect.
 - 2. Sealer: Colorless, pure acrylic water repellent sealer. Sealer to maintain natural look of concrete surface with no glaze or gloss, darkening or color change.
 - Precast manufacturer is not a reseller for any of the above products. Please contact the following supplier for information and recommendations on job specific installation materials:
 - a. Acceptable Supplier:

Custom Building Products/Aqua Mix, 800-272-878

E-mail: info@cbpmail.net Website: www.custombuildingproducts.com

2.03 MANUFACTURED UNITS

- A. Sizing Tolerances
 - 1. All units to conform to shop drawings with a (+/-) 1/8" tolerance in dimension.
- B. Precast Surfaces and Edges:
 - 1. All exposed edges to have minimum of 1/8" radius to prevent chipping.
 - 2. All finished surfaces to match approved control sample.
 - 3. All precast concrete finished surfaces to be factory sealed.

PART 3 - EXECUTION

3.01 INSPECTION

- A. Examine substrates for the following:
 - 1. Defects or cracks in existing work or substrate.
 - 2. Deviations beyond allowable tolerances for the substrate.
- B. Continue with installation of precast units only when all defects have been corrected.

3.02 Project Conditions

A. Do not install products under environmental conditions outside setting material manufacturer's absolute limits.

3.3 INSTALLATION

- A. Precast Tread setting methods include
 - 1. Thin Set Application
 - a. Substrate of concrete or steel (steel at interior application only). Must be within a tolerance of 1/8"in all dimensions.
 - b. Latex modified thin set mortar used over concrete substrate.
 - Setting bed must be continuous under the entire length of the tread and behind the entire riser. Setting materials utilized per manufacture's recommended instruction.
 - c. Epoxy thin set is used over steel substrate.
 - 1. Setting bed must be continuous under the entire length of the tread and behind the entire riser. Setting materials utilized per manufacture's recommended instruction.



- d. Set treads level and plumb to meet finished nosing layout.
- 2. Mortar Set Application
 - a. Substrate of concrete or steel (steel at interior application only). Must be within a tolerance of 1/8" in all dimensions.
 - b. The height of the mortar bed is established based on tread nosing layout marks and precast thickness. The mortar bed is then placed or screeded over primed substrate.
 - 1. Setting bed must be continuous under the entire length of the tread and behind the entire riser. Setting materials utilized per manufacture's recommended instruction.
 - c. Set treads level and plumb to meet finished nosing layout.
- 3. Tab Set Application
 - a. Substrate of concrete or steel (steel at interior application only) must be within a tolerance of 1/8"in all dimensions.
 - b. Tabs to be set at front and back of tread every 12" O.C. minimum.
 - c. Set treads level and plumb to established nosing layout.
- B. Joints
 - 1. Joints between adjacent precast should be a minimum of 1/8"-1/4".
- C. Caulking of Precast
 - 1. Clean all joints thoroughly, removing all debris.
 - 2. Wipe all joints with caulk manufacturer's recommended cleaner prior to application.
 - 3. Use urethane caulk. (Color match caulk to precast per architect selection.)
 - 4. Clean up after caulking as per caulk manufacturer's recommendations.
- D. Precast Concrete products setting or installation methods are to be reviewed by the manufacturer and setting materials supplier.
- E. Final Cleaning of Precast Concrete
 - 1. Check all surfaces and caulking, make repairs as necessary.
 - 2. Clean treads with a pH balanced soap.
- F. Protection:
 - 1. Upon completion, the work shall be ready for final inspection and acceptance by owner or owner's agent.
 - 2. General Contractor shall protect the finished work from the time the installing contractor completes the work.
- G. Finish:
 - 1. Overall match to approved sample and per industry standards.
 - 2. All products to be factory sealed.

PART 4 - CARE AND MAINTENANCE

4.1

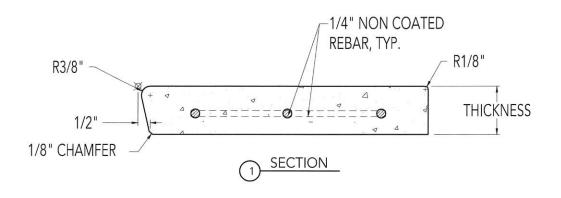
- A. Cleaning
 - To preserve the appearance and extend the life of the Precast Concrete cleaning and maintenance processes must be in place. When using the following procedures, please follow the product manufacturer's instructions regarding the use of any equipment or cleaning materials described here.
 - a. Power sweep, then pressure wash precast surface. Spot clean any stained areas.

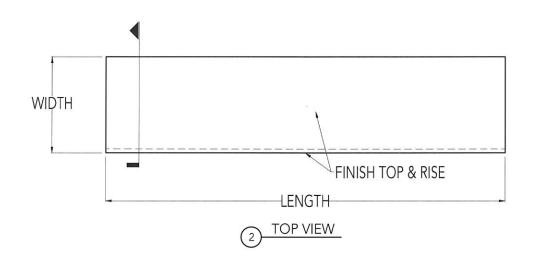


- b. Spot clean any stained areas by using a neutral, non-aggressive cleaner. This may require effort to remove some of the tougher marks or stains.
 - 1. Example of off-the-shelf cleaners: Citrus cleaner, Simple Green
- c. Always start with the most neutral cleaner and work your way toward the more aggressive cleaners.
- d. In extreme cases, contact Wausau Tile to discuss options
- e. Be sure to use plastic, rubber or nylon tip equipment; this will help prevent scratches on the concrete.
- 2. Precast Concrete is built to withstand aggressive cleaning; however, the more aggressive the cleaner, the more risk is involved. Strict adherence to all product warnings is suggested.
- 3. In all cases after cleaning and/or patching, it is recommended that the Precast be sealed. This will help protect the product from environmental effects. Contact manufacturer to obtain sealer and stain information based on specific job.

B. Maintenance

- Annual maintenance is recommended; however, incases of extreme use, the best time for application is when the appearance of the product is showing wear or is appearing dull.
- 2. Check the precast for broken and chipped pieces. If damaged, contact manufacturer before repairing to order a patch kit and obtain patching procedures.
- 3. De-icing salts can damage concrete, causing them to scale or break apart. If necessary, these chemicals should be used sparingly and with caution on our concrete products.
 - Salt based products are not recommended
- 4. De-icers should be used only when necessary to help loosen snow and ice, and make removal easier. Never over-apply de-icing products. Mix the de-icers with sand to increase their effectiveness and reduce overall use.
 - a. Always read and follow label directions when applying de-icing materials.
 - b. Calcium magnesium acetate chloride tends to cause the least amount of damage to Precast Concrete
- 5. Other manufacturer's products used in conjunction with the Precast Concrete may require additional maintenance. Including but not limited to: Wood, Metals, Plastics, etc. Contact product specific manufacturers for their maintenance requirements.





DIMENSIONAL PARAMETERS:

UP TO 4'-0": 2" MINIMUM THICKNESS

4'-0" T0 6'-0": 2 1/2" MINIMUM THICKNESS

6'-0" TO 8'-0": 3" MINIMUM THICKNESS

MAX LENGTH 8'-0"

INSTALL METHOD:

A OR B

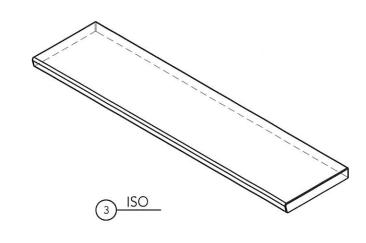
DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM

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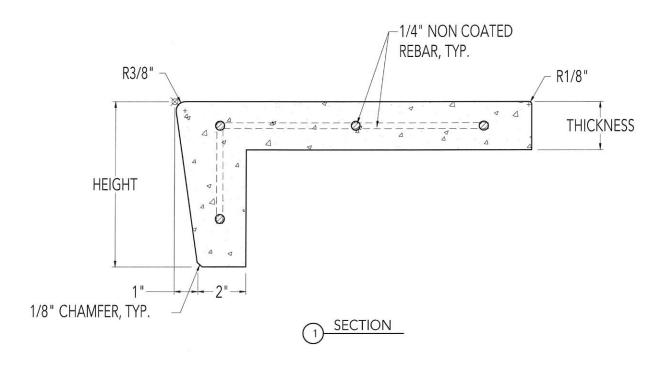
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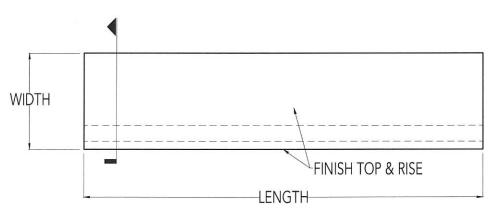


PRODUCT: C30 FLAT TREAD

TOLL FREE: 800-388-8728 F-MAIL: WTII F@WAUSAUTII F COM WEBSITE: WWW.WAUSAUTILE.COM DRAWN BY: SKD REV DATE: 01.04.21

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TOP VIEW

DIMENSIONAL PARAMETERS:

UP TO 6'-0": 2" MINIMUM THICKNESS 6'-0" T0 8'-0": 2 1/4" MINIMUM THICKNESS

MAX LENGTH 8'-0"

INSTALL METHOD:

A OR B

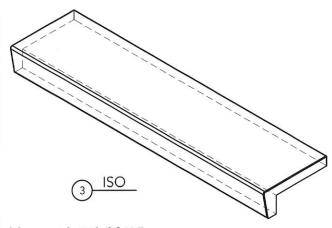
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AVAILABLE UPON REQUEST

ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST



SCALE: NOT TO SCALE



C31 TREAD & RISER

MATERIAL: PRECAST CONCRETE

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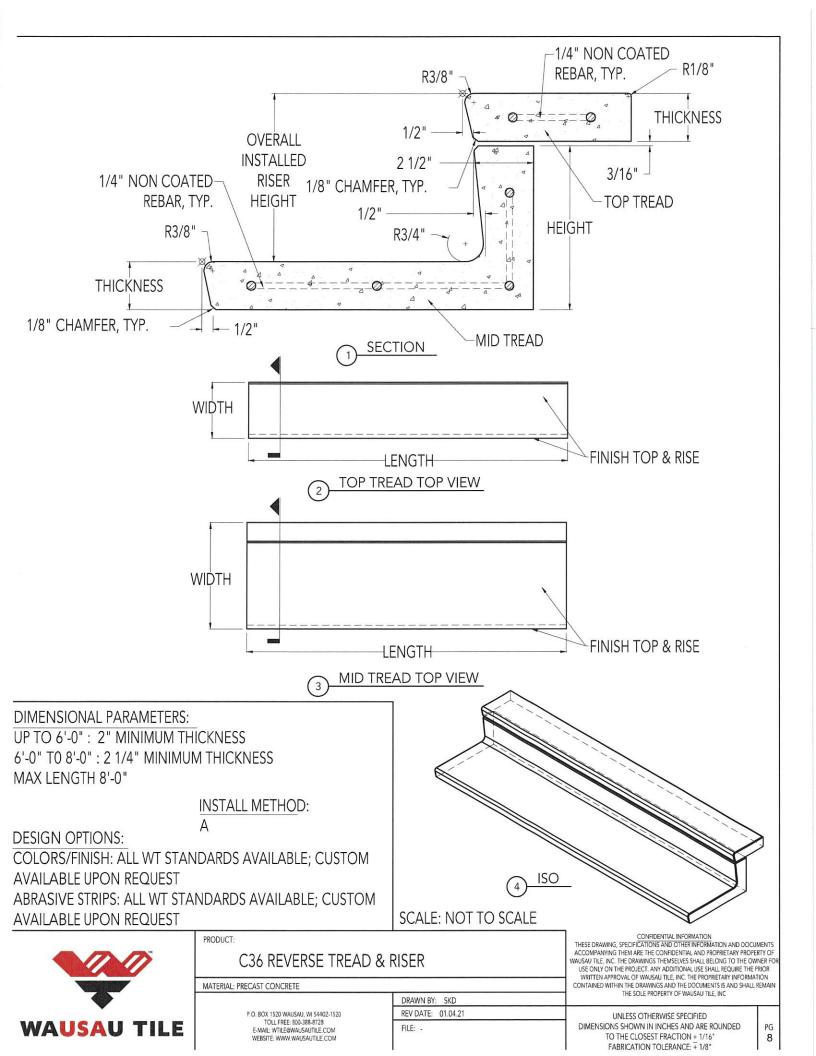
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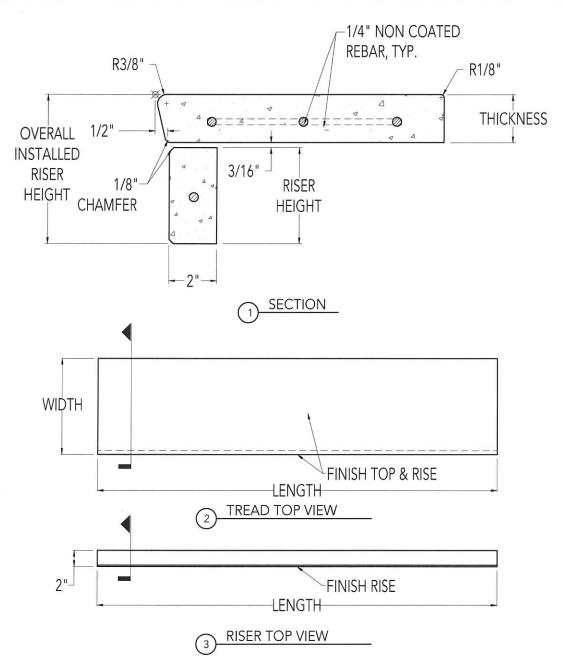
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DIMENSIONAL PARAMETERS:

UP TO 4'-0": 2" MINIMUM THICKNESS

4'-0" TO 6'-0": 2 1/2" MINIMUM THICKNESS

6'-0" TO 8'-0": 3" MINIMUM THICKNESS

MAX LENGTH 8'-0"

INSTALL METHOD:

DESIGN OPTIONS:

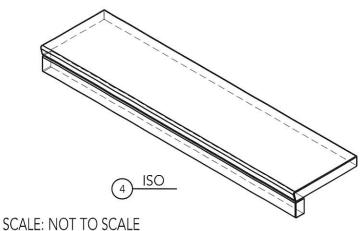
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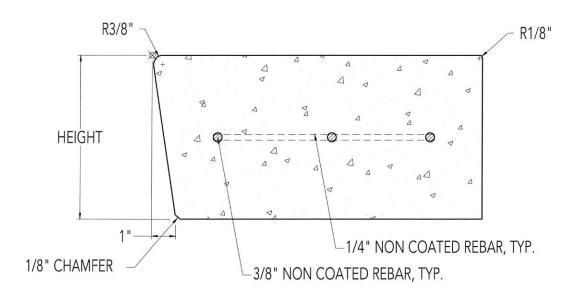
C40 SEPARATE TREAD & RISER

MATERIAL: PRECAST CONCRETE

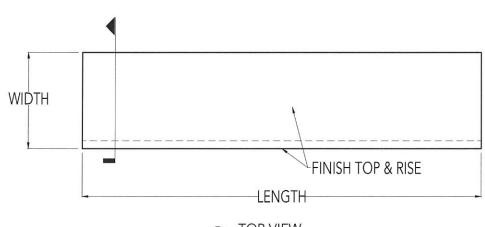
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(1) SECTION



(2) TOP VIEW

DIMENSIONAL PARAMETERS:

MAX LENGTH 8'-0"

INSTALL METHOD:

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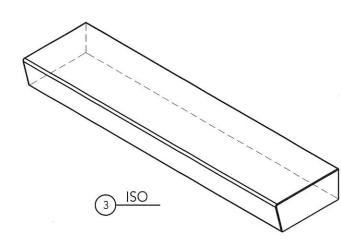
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SCALE: NOT TO SCALE



PRODUCT:

C51 BLOCK TREAD

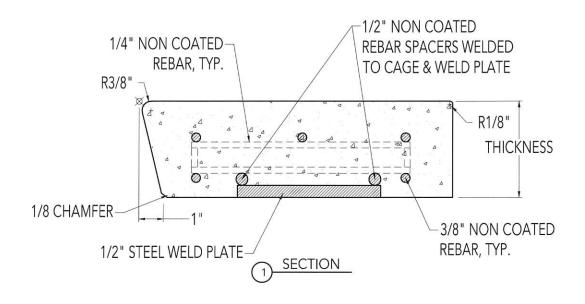
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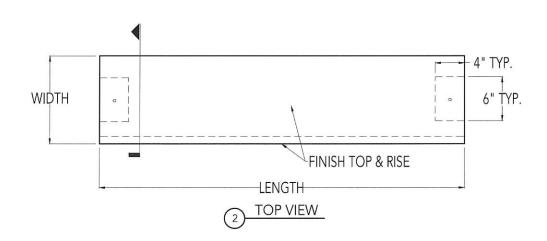
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DIMENSIONAL PARAMETERS:

UP TO 6'-0": 4" MINIMUM THICKNESS 6'-0" TO 8'-0": 5" MINIMUM THICKNESS

MAX LENGTH 8'-0"

INSTALL METHOD:

D (PREFERRED)

DESIGN OPTIONS:

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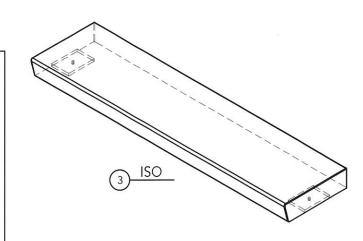
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ADDITIONAL SIDES FINISHED BY REQUEST



SCALE: NOT TO SCALE



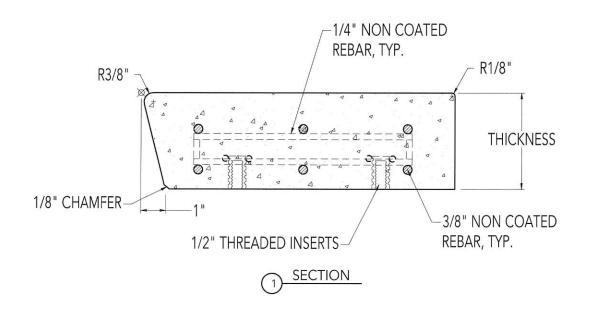
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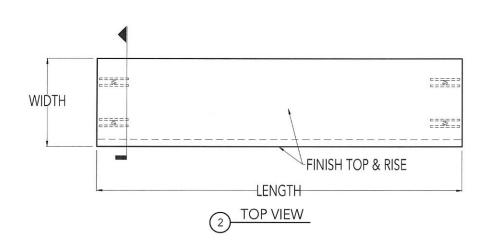
C60 SELF SUPPORTING FLAT TREAD (WELD)

MATERIAL: PRECAST CONCRETE

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DIMENSIONAL PARAMETERS:

UP TO 6'-0": 4" MINIMUM THICKNESS 6'-0" TO 8'-0": 5" MINIMUM THICKNESS

MAX LENGTH 8'-0"

INSTALL METHOD:

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

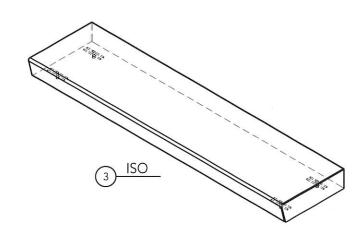
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AVAILABLE UPON REQUEST

ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ADDITIONAL SIDES FINISHED BY REQUEST



SCALE: NOT TO SCALE



PRODUCT:

C60 SELF SUPPORTING FLAT TREAD (BOLT)

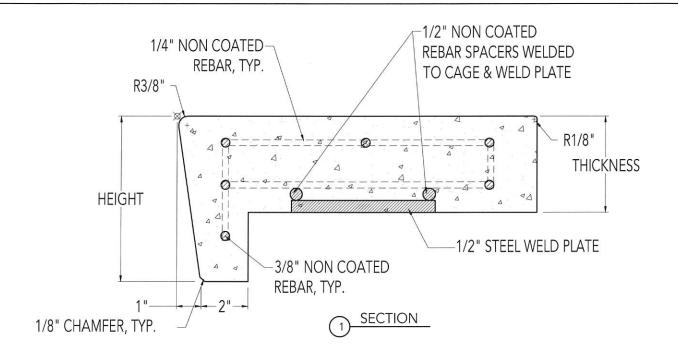
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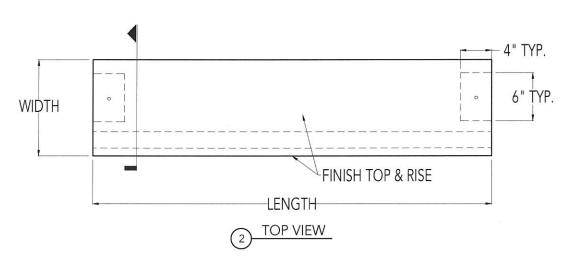
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4" MINIMUM THICKNESS MAX LENGTH 8'-0"

> INSTALL METHOD: D (PREFERRED)

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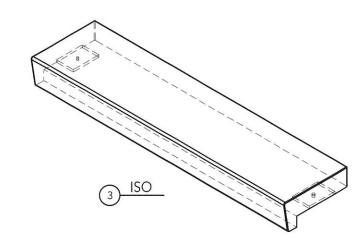
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ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ADDITIONAL SIDES FINISHED BY REQUEST



SCALE: NOT TO SCALE



RODUCT:

C70 SELF SUPPORTING TREAD & RISER (WELD)

MATERIAL: PRECAST CONCRETE

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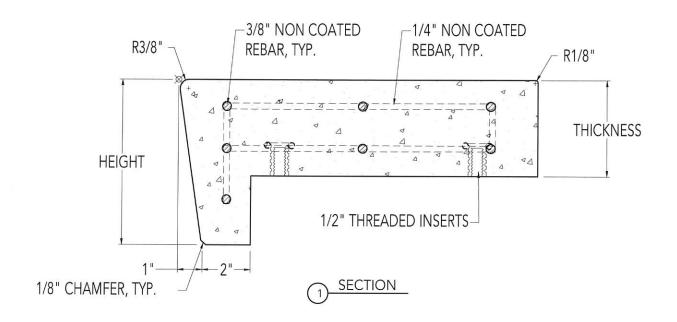
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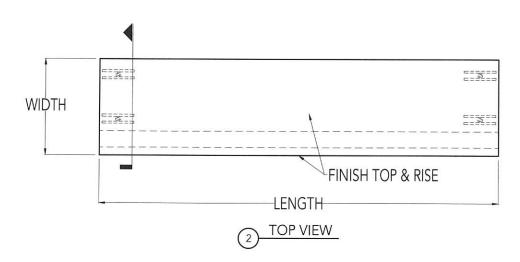
UNLESS OTHERWISE SPECIFIED

DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED

TO THE CLOSEST FRACTION + 1/16*

FABRICATION TOLERANCE: + 1/8*





4" MINIMUM THICKNESS MAX LENGTH 8'-0"

INSTALL METHOD:

C

DESIGN OPTIONS:

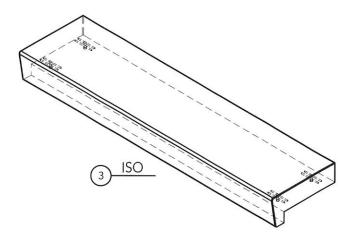
COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ADDITIONAL SIDES FINISHED BY REQUEST



SCALE: NOT TO SCALE



PRODUCT:

C70 SELF SUPPORTING TREAD & RISER (BOLT)

MATERIAL: PRECAST CONCRETE

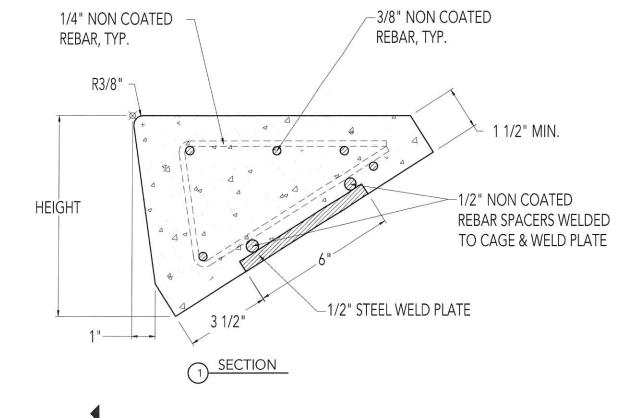
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM DRAWN BY: SKD

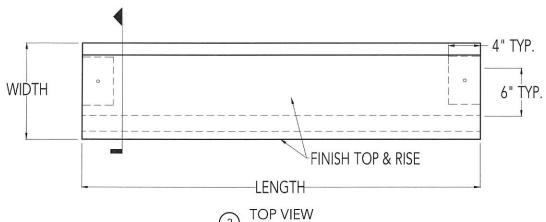
REV DATE: 01.04.21

FILE: -

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TO THE CLOSEST FRACTION + 1/16*
FABRICATION TOLERANCE: + 1/8*





MAX LENGTH 8'-0"

INSTALL METHOD:

DESIGN OPTIONS:

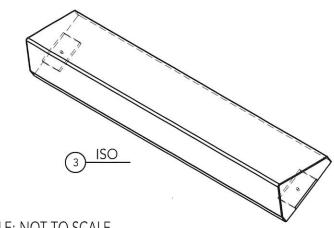
COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ADDITIONAL SIDES FINISHED BY REQUEST



SCALE: NOT TO SCALE

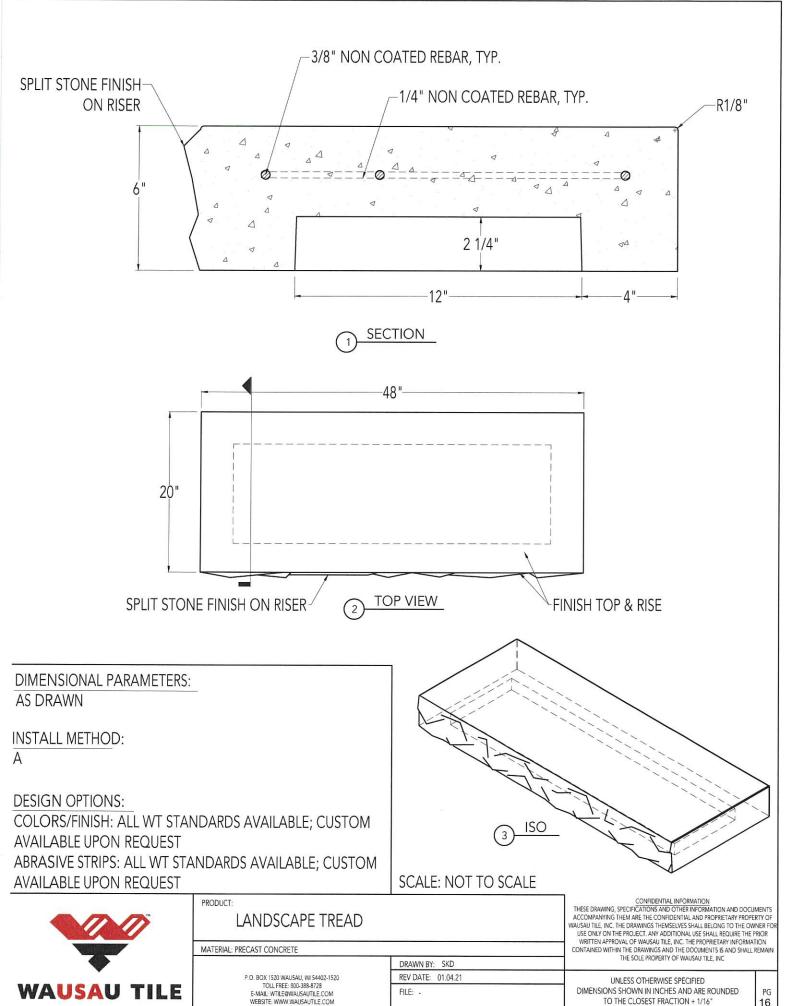


TEARDROP SELF SUPPORTING

MATERIAL: PRECAST CONCRETE

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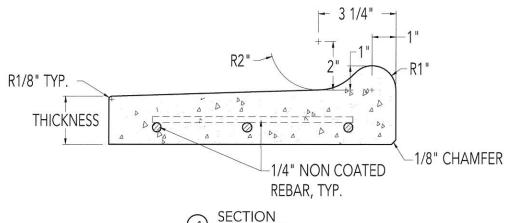
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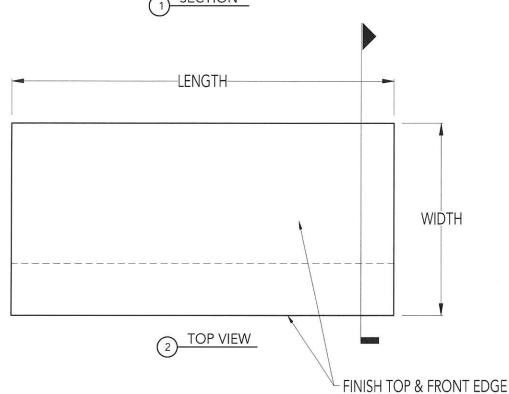


16

TO THE CLOSEST FRACTION + 1/16"

FABRICATION TOLERANCE: + 1/8"





UP TO 4'-0": 2" MINIMUM THICKNESS

4'-0" T0 6'-0" : 2 1/2" MINIMUM THICKNESS

6'-0" T0 8'-0" : 3" MINIMUM THICKNESS

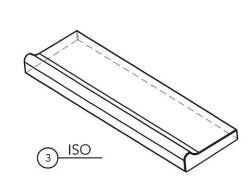
MAX LENGTH 8'-0"

INSTALL METHOD:

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST



SCALE: NOT TO SCALE



RODUCT:

POOL COPING: SAFETY EDGE

MATERIAL: PRECAST CONCRETE

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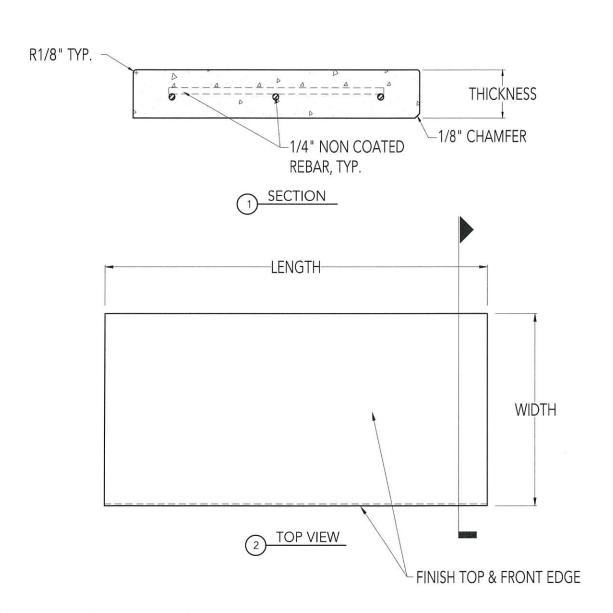
USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR

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DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED
TO THE CLOSEST FRACTION + 1/16"
FABRICATION TOLERANCE: + 1/8"



UP TO 4'-0": 2" MINIMUM THICKNESS

4'-0" T0 6'-0" : 2 1/2" MINIMUM THICKNESS

6'-0" TO 8'-0": 3" MINIMUM THICKNESS

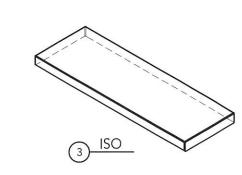
MAX LENGTH 8'-0"

INSTALL METHOD:

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST



SCALE: NOT TO SCALE



PRODUCT:

POOL COPING: SQUARE EDGE

MATERIAL: PRECAST CONCRETE

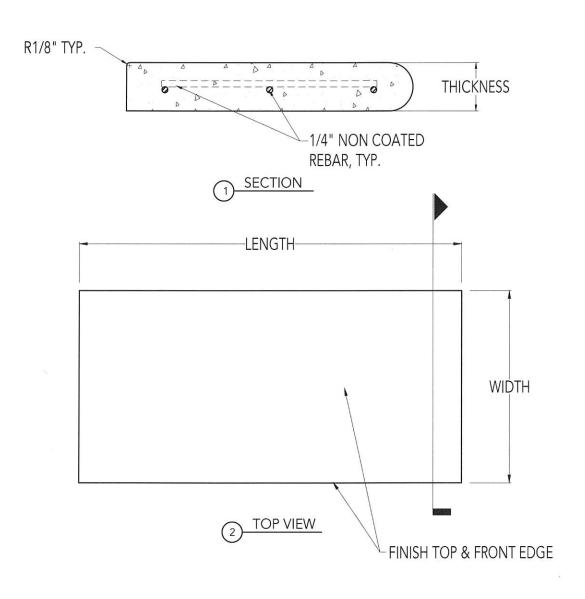
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DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED
TO THE CLOSEST FRACTION + 1/16"
FABRICATION TOLERANCE: 7 1/8"

PG 18



UP TO 4'-0": 2" MINIMUM THICKNESS

4'-0" TO 6'-0": 2 1/2" MINIMUM THICKNESS

6'-0" TO 8'-0": 3" MINIMUM THICKNESS

MAX LENGTH 8'-0"

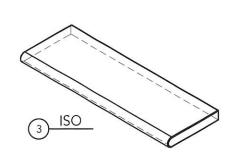
INSTALL METHOD:

٢

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST



SCALE: NOT TO SCALE



PRODUCT:

POOL COPING: BULLNOSE

MATERIAL: PRECAST CONCRETE

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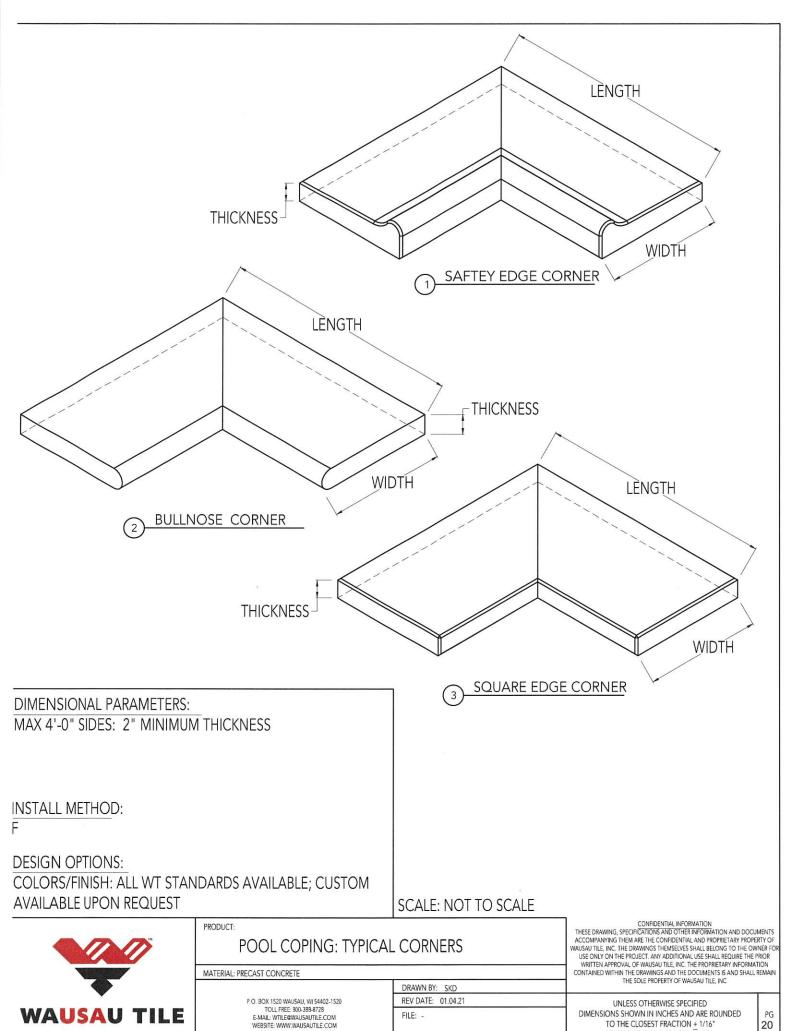
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UNLESS OTHERWISE SPECIFIED

DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED

TO THE CLOSEST FRACTION + 1/16*

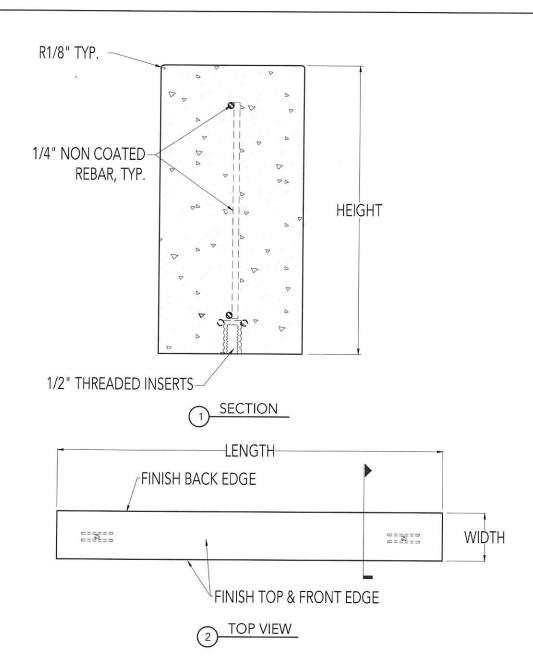
FABRICATION TOLERANCE: + 1/8*



20

TO THE CLOSEST FRACTION + 1/16"

FABRICATION TOLERANCE: + 1/8"



DIMENSIONAL PARAMETERS: MAX LENGTH 8'-0"

INSTALL METHOD:

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST
ADDITIONAL SIDES FINISHED BY REQUEST

3 <u>ISO</u>

SCALE: NOT TO SCALE

WAUSAU TILE

PRODUCT: CURB

MATERIAL: PRECAST CONCRETE

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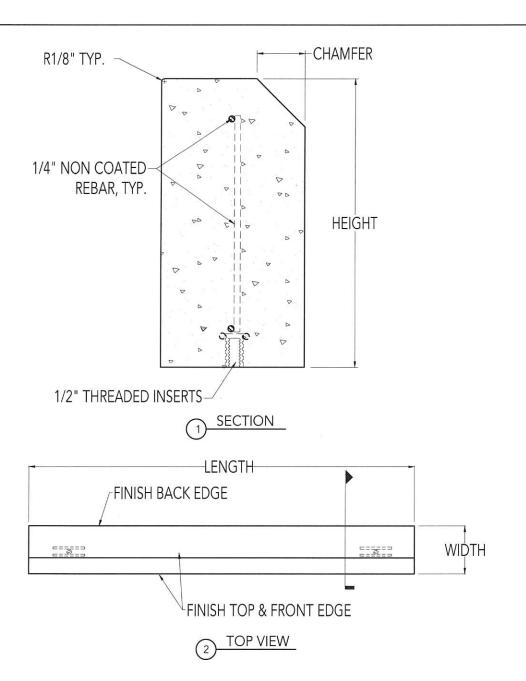
THE SOLE PROPERTY OF WAUSAU TILE, INC.

UNLESS OTHERWISE SPECIFIED

DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED

TO THE CLOSEST FRACTION + 1/16*

FABRICATION TOLERANCE: + 1/8"



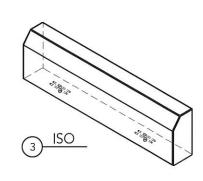
DIMENSIONAL PARAMETERS: MAX LENGTH 8'-0"

INSTALL METHOD:

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST

ADDITIONAL SIDES FINISHED BY REQUEST



SCALE: NOT TO SCALE



CHAMFERED CURB

MATERIAL: PRECAST CONCRETE

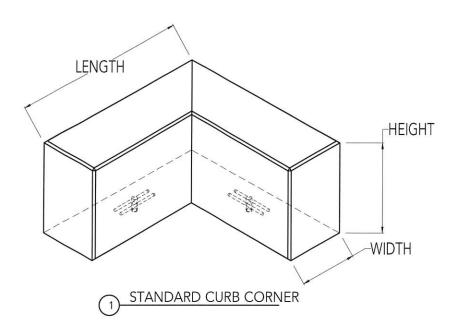
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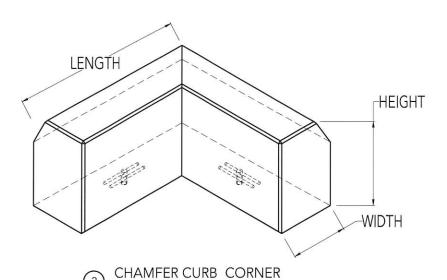
REV DATE: 01.04.21

FILE: -

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UNLESS OTHERWISE SPECIFIED
DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED
TO THE CLOSEST FRACTION + 1/16*
FABRICATION TOLERANCE: + 1/8"





MAX 4'-0" SIDES:

INSTALL METHOD:

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

SCALE: NOT TO SCALE



PRODUCT:

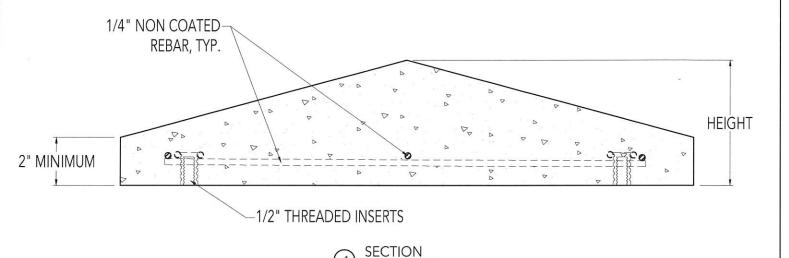
CURB: TYPICAL CORNERS

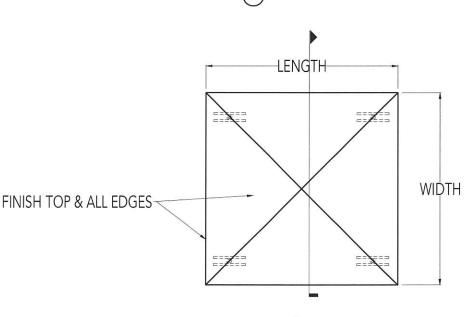
MATERIAL: PRECAST CONCRETE

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FILE: -

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UNLESS OTHERWISE SPECIFIED
DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED
TO THE CLOSEST FRACTION + 1/16"
FABRICATION TOLERANCE: + 1/8"





(2) TOP VIEW

DIMENSIONAL PARAMETERS:

MAX SIZE: 4' WIDTH / 8' LENGTH

INSTALL METHOD:

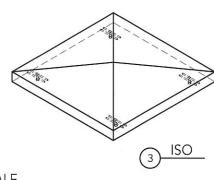
_

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

1/4" DRIP EDGE



SCALE: NOT TO SCALE



PRODUCT:

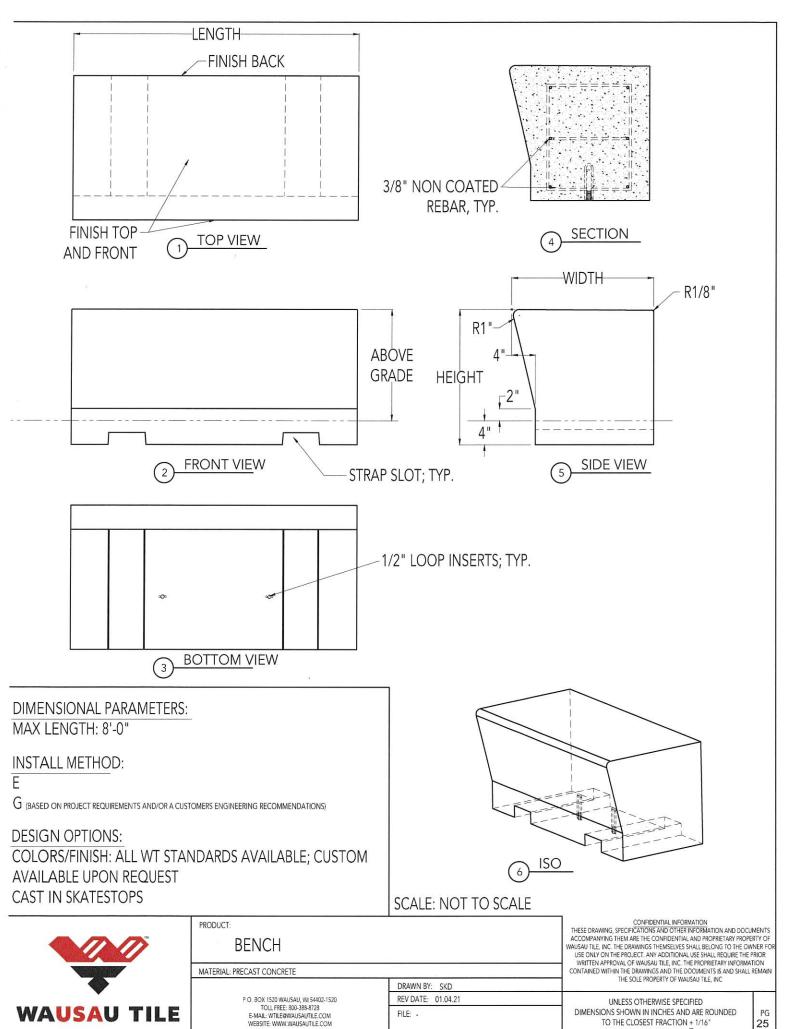
COLUMN CAP

MATERIAL: PRECAST CONCRETE

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REV DATE: 01.04.21
FILE: -

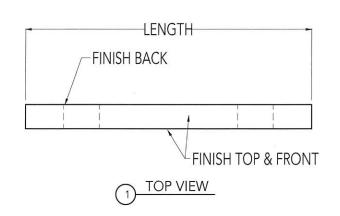
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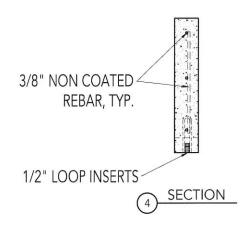
UNLESS OTHERWISE SPECIFIED
DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED
TO THE CLOSEST FRACTION + 1/16*
FABRICATION TOLERANCE: + 1/8*

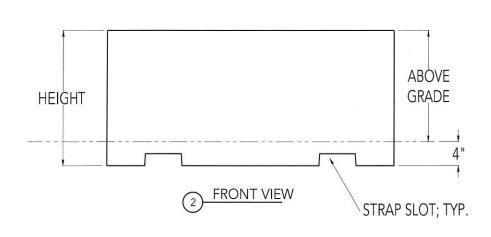


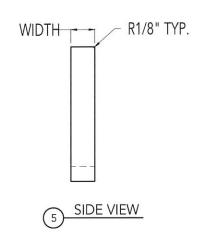
25

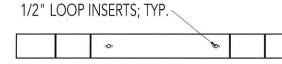
FABRICATION TOLERANCE: + 1/8"











BOTTOM VIEW

DIMENSIONAL PARAMETERS:

MAX LENGTH: 8'-0"

INSTALL METHOD:

F

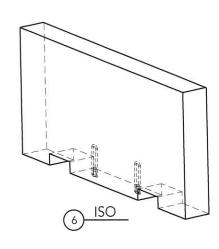
 ${\sf G}$ (based on project requirements and/or a customers engineering recommendations)

DESIGN OPTIONS:

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

CAST IN SKATESTOPS



SCALE: NOT TO SCALE



PRODUCT: PLANTER WALL

MATERIAL: PRECAST CONCRETE

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REV DATE: 01.04.21
FILE: -

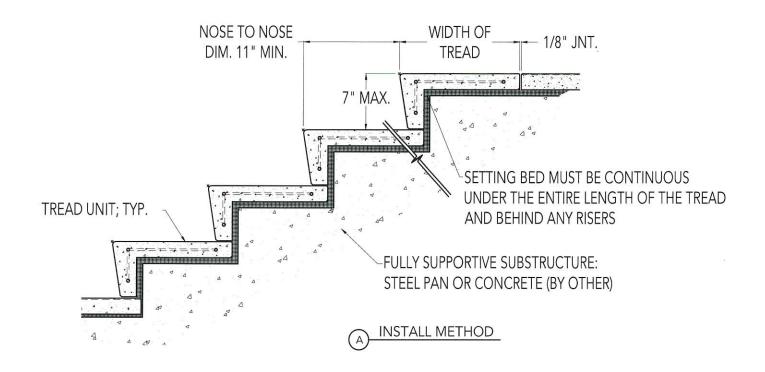
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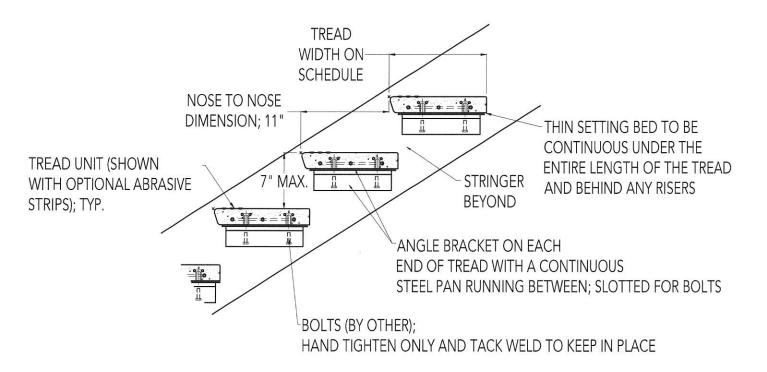
UNLESS OTHERWISE SPECIFIED

DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED

TO THE CLOSEST FRACTION + 1/16*

FABRICATION TOLERANCE: + 1/8"





SCALE: NOT TO SCALE



INSTALL METHOD



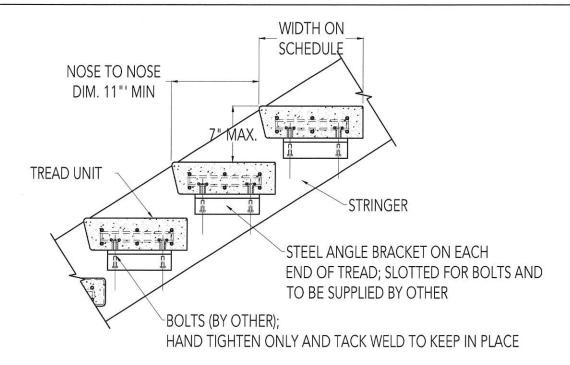
FULLY SUPPORTED INSTALL STYLES

MATERIAL: PRECAST CONCRETE

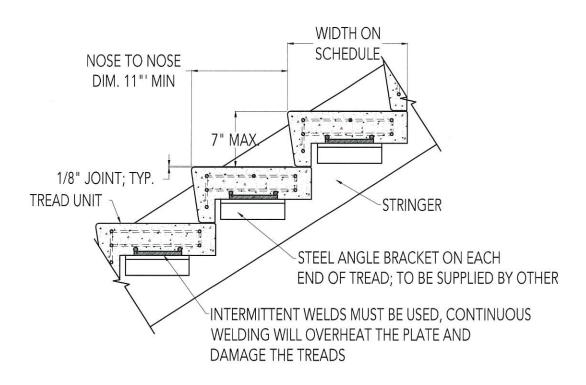
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DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED
TO THE CLOSEST FRACTION + 1/16'
FABRICATION TOLERANCE: + 1/8"



INSTALL METHOD



INSTALL METHOD

SCALE: NOT TO SCALE



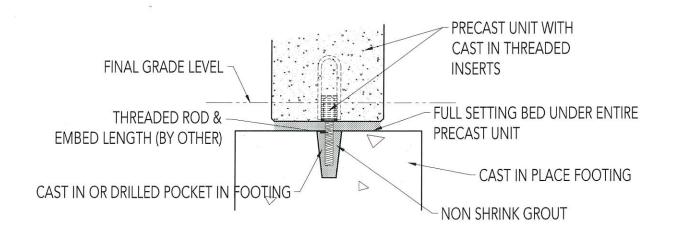
SELF SUPPORTING INSTALL STYLES MATERIAL: PRECAST CONCRETE

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E-MAIL: WTILE@WAUSAUTILE.COM
WEBSITE: WWW.WAUSAUTILE.COM

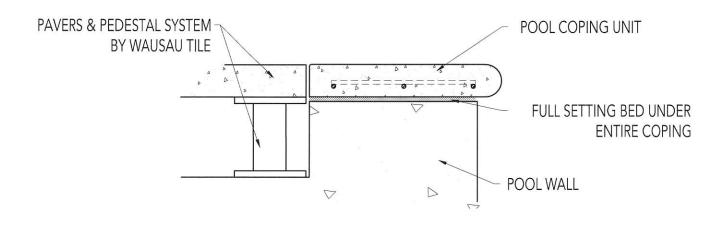
DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

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UNLESS OTHERWISE SPECIFIED DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED TO THE CLOSEST FRACTION + 1/16" FABRICATION TOLERANCE: + 1/8"



(E) INSTALL METHOD





SCALE: NOT TO SCALE



MISC PRODUCT INSTALL STYLES

MATERIAL: PRECAST CONCRETE

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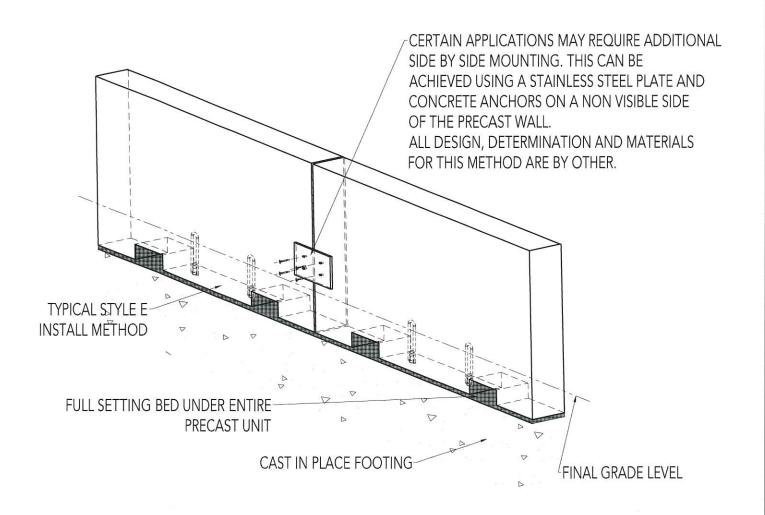
WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION

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DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED
TO THE CLOSEST FRACTION + 1/16"
FABRICATION TOLERANCE: + 1/8"

PG 29



INSTALL METHOD

SCALE: NOT TO SCALE



PRODUCT:

MISC PRODUCT INSTALL STYLES

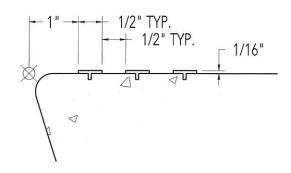
MATERIAL: PRECAST CONCRETE

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DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

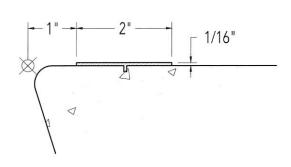
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UNLESS OTHERWISE SPECIFIED DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED TO THE CLOSEST FRACTION + 1/16" FABRICATION TOLERANCE: + 1/8"



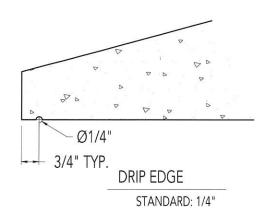
3-LINE EPOXY ABRASIVE

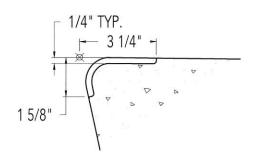
STANDARD: BLACK CUSTOM: AVAILABLE



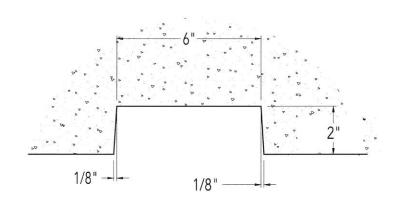
2 INCH EPOXY ABRASIVE

STANDARD: BLACK CUSTOM: AVAILABLE





CAST IN SKATE STOP



STRAP SLOT DETAIL

SCALE: NOT TO SCALE



PRODUCT:

DESIGN OPTIONS

MATERIAL: PRECAST CONCRETE

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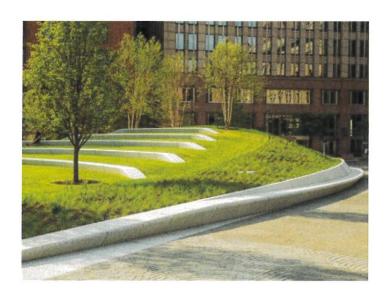
DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED

TO THE CLOSEST FRACTION + 1/16*

FABRICATION TOLERANCE: ∓ 1/8"



SEAT WALLS



Custom precast concrete seat walls add a touch of sophistication while serving as both continuous bench space and abstract works of art. Create a seat wall with undulating heights and widths, radial or straight. Choose from different profiles like block or tapered and add recesses or reveals for lighting. With so many options for seat walls, your custom design is just steps away.

Standard color options include Weatherstone, Light Grind, Ground & Polished and Acid Wash and can be viewed at WausauTile.com.

PROPERTY	ADVANCED TESTING VALUE	TEST METHOD
Compression Strength	Wausau Tile standard is 5000 PSI at 28 days.	ASTM C39
Water Absorption	Wausau Tile standard is less than 6%.	ASTM C642
Flexural Strength	Non-Standard	ASTM C78 (3rd party test: American Engineering)
C373 Water Absorption	Not-Applicable	
C482 Bond Strength	Not-Applicable	
C485 Warpage Edge	Not-Applicable	
C485 Warpage Diagonal	Not-Applicable	
C499 Nominal Size	Tolerance of +/- 1/8"	100% Inspection, Measurements verified against fabrication drawings.
C499 Thickness	Tolerance of +/- 1/8"	100% Inspection, Measurements verified against fabrication drawings.
Dynamic DCOF	Not-Applicable	
ANSI A173.1 Section 9.6.1	Not-Applicable (Tile only)	
Avg. Polished Finish	100% Visual Inspection	Visually compare product to control sample
Avg. Honed Finish	100% Visual Inspection	Visually compare product to control sample
Freeze/Thaw	Non-Standard	ASTM C666 (3rd Party, American Engineering)
Center Load	Not-Applicable (Pavers only)	



Exterior Finishes High Performance

Steel/Ferrous Metal

Primer: B69A00008 - Zinc Clad® IV Organic Zinc-Rich Epoxy Primer Binder Binder

Notes: To be applied at steel shop

Intermediate Coat: B58W00610 - Macropoxy® 646 Fast Cure Epoxy Part A Mill White Finish: B65W00651 - Acrolon® 218 HS Polyurethane - Semi-Gloss (Part A) Extra White



Basic Surface Preparation

Coating performance is directly affected by surface preparation. Coating integrity and service life will be reduced because of improperly prepared surfaces. As high as 80% of all coating failures can be directly attributed to inadequate surface preparation that affects coating adhesion. Proper product selection, surface preparation, and application affect coating performance. Coating integrity and service life will be reduced because of improperly prepared surfaces. Selection and implementation of proper surface preparation ensures coating adhesion to the substrate and prolongs the service life of the coating system.

The majority of paintable surfaces are concrete, ferrous metal, galvanizing, wood and aluminum. They all require protection to keep them from deteriorating in aggressive environments. Selection of the proper method for surface preparation depends on the substrate, the environment, the coating selected, and the expected service life of the coating system. Economics, surface contamination, and the effect on the substrate will also influence the selection of surface preparation methods. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system.

Verify the existence of lead based paints on the project. Buildings constructed after 1978 are less likely to contain lead based paints. If lead based paints are suspected on the project, all removal must be done in accordance with the EPA Renovation, Repair and Painting and all applicable state and local regulations. State and local regulations may be more strict than those set under the federal regulations. Verify that Owner has completed a Hazardous Material Assessment Report for the project prior to issuing of Drawings. Concluding that no lead based paints were found on project site, delete paragraph regarding lead based paints.

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority. Removal must be done in accordance with EPA Renovation, Repair and Painting Rule and all related state and local regulations. Care should be taken to follow all state and local regulations which may be more strict than those set under the federal RRP Rule.

No exterior painting should be done immediately after a rain, during foggy weather, when rain is predicted, or when the temperature is below 50°F, unless the products to be used are designed to be used in those environments.

Aluminum – S-W 1: Remove all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP1, Solvent Cleaning.

Block (Cinder and Concrete) – S-W 3: Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement, and hardeners. Concrete and mortar must be cured at least 28 days at 75°F. The pH of the surface should be between 6 and 9. On tilt-up and poured-in-place concrete, commercial detergents and abrasive blasting may be necessary to prepare the surface. Fill bug holes, air pockets, and other voids with a cement patching compound (per ASTMD4261).

Brick – **S-W 4:** Must be free of dirt, loose and excess mortar, and foreign material. All brick should be allowed to weather for at least one year followed by wire brushing to remove efflorescence. Treat the bare brick with one coat of Loxon Conditioner.

Concrete and Masonry – Concrete, Poured – Exterior or Interior – S-W 5: The preparation of new concrete surfaces is as important as the surface preparation of steel. The following precautions will help assure maximum performance of the coating system and satisfactory coating adhesion:

- 1. Cure Concrete must be cured prior to coating. Cured is generally defined as concrete poured and aged at a material temperature of at least 75°F for at least 28 days unless specified products are designed for earlier application.
- 2. Moisture Reference ASTM F1869-98 Moisture Test by use of Calcium Chloride or ASTM D4263 Plastic Sheet Method Concrete must be free from moisture as much as possible (it seldom falls below 15%). Vapor pressures, temperature, humidity, differentials, and hydrostatic pressures can cause coatings to prematurely fail. The source of moisture, if present, must be located, and the cause corrected prior to coating.
- 3. Temperature Air, surface and material temperatures must be in keeping with requirements for the selected product during and after coating application, until coating is cured.

- **4. Contamination** Remove all grease, dirt, paint, oil, laitance, efflorescence, loose mortar, and cement by the recommendations listed in the surface preparation section.
- 5. Surface Condition Hollow areas, bug holes, voids, honeycombs, fin form marks, and all protrusions or rough edges are to be ground or stoned to provide a continuous surface of suitable texture for proper adhesion of the coating. Imperfections may require filling, as specified, with a recommended Sherwin-Williams product.
- **6.** Concrete Treatment Hardeners, sealers, form release agents, curing compounds, and other concrete treatments should be removed to ensure adequate coating adhesion and performance.

Methods of Surface Preparation on Concrete per SSPC-SP13/NACE 6 or ICRI 03732 Surface Cleaning Methods: Vacuum cleaning, air blast cleaning, and water cleaning per ASTM D4258.

Used to remove dirt, loose material, and/or dust from concrete.

Detergent water cleaning and steam cleaning per ASTM D4258.

Used to remove oils and grease from concrete. Prior to abrasive cleaning, and after abrasive cleaning, surfaces should be cleaned by one of the methods described above.

Mechanical Surface Preparation Methods:

Dry abrasive blasting, wet abrasive blasting, vacuum assisted abrasive blasting, and centrifugal shot abrasive blasting per ASTM D4259. Used to remove contaminants, laitance, and weak concrete, to expose subsurface voids, and to produce a sound concrete surface with adequate profile and surface porosity.

High-pressure water cleaning or water jetting per SSPC-SP12-NACE5.

Used to remove contaminants, laitance, and weak concrete, to expose subsurface voids, and to produce a sound concrete surface with adequate profile and surface porosity.

Impact tool methods per ASTM D4259.

Used to remove existing coatings, laitance, and weak concrete. Methods include scarifying, planing, scabbling, and rotary peening. Impact tools may fracture concrete surfaces or cause microcracking requiring surface repair.

Power tool methods per ASTM D4259.

Used to remove existing coatings, laitance, weak concrete, and protrusions in concrete. Methods include circular grinding, sanding, and wire brushing. These methods may not produce the required surface profile to ensure adequate adhesion of subsequent coatings.

Chemical Surface Preparation Methods:

Acid etching per ASTM D4260. Use to remove some surface contaminants, laitance, and weak concrete, and to provide a surface profile on horizontal concrete surfaces. This method requires complete removal of all reaction products and pH testing to ensure neutralization of the acid. Not recommended for vertical surfaces. Etching with hydrochloric acid shall not be used where corrosion of metal in the concrete is likely to occur. Adequate ventilation and safety equipment required.

- 1. Clean surface per ASTM D4268
- 2. Wet surface with clean water
- 3. Etch with 10-15% muriatic acid solution at the rate of 1 gallon per 75 square feet
- 4. Scrub with stiff brush
- 5. Allow sufficient time for scrubbing and until bubbling stops
- 6. If no bubbling occurs, surface is contaminated. Refer to ASTM D4258 or ASTM D4259
- 7. Rinse surface two or three times. Remove acid/water each time.
- 8. Surface should a texture similar to medium grit sandpaper.
- 9. Neutralize surface with a 3% solution of tri-sodium phosphate and flush with clean water.
- 10. Allow to dry and check for excess moisture.

Cement Composition Siding/Panels – S-W 6: Remove all surface contamination by washing with an appropriate cleaner, rinse thoroughly and allow to dry. Existing peeled or checked paint should be scraped and sanded to a sound surface. Glossy surfaces should be sanded dull. Pressure clean, if needed, with a minimum of 2100 psi pressure to remove all dirt, dust, grease, oil, loose particles, laitance, foreign material, and peeling or defective coatings. Allow the surface to dry thoroughly. If the surface is new, test it for pH, many times the pH may be 10 or higher.

Composition Board (Hardboard) – S-W 9: Some composition boards may exude a waxy material that must be removed with a solvent prior to coating. Whether factory primed or unprimed, exterior composition board siding (hardboard) must be cleaned thoroughly and primed with an alkyd primer.

Copper – S-W 7: Remove all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP2, Hand Tool Cleaning.

Drywall—Interior and Exterior – S-W 8: Must be clean and dry. All nail heads must be set and spackled. Joints must be taped and covered with a joint compound. Spackled nail heads and tape joints must be sanded smooth and all dust removed prior to painting. Exterior surfaces must be spackled with exterior grade compounds.

Galvanized Metal – S-W 10: Allow to weather a minimum of 6 months prior to coating. Clean per SSPC-SP1 using detergent and water or a degreasing cleaner, then prime as required. When weathering is not possible or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test area, priming as required. Allow the coating to dry at least one week before testing. If adhesion is poor, Brush Blast per SSPC-SP16 is necessary to remove these treatments.

Plaster – S-W 11: Must be allowed to dry thoroughly for at least 30 days before painting. Room must be ventilated while drying; in cold, damp weather, rooms must be heated. Damaged areas must be repaired with an appropriate patching material. Bare plaster must be cured and hard. Textured, soft, porous, or powdery plaster should be treated with a solution of 1 pint household vinegar to 1 gallon of water. Repeat until the surface is hard, rinse with clear water and allow to dry.

Steel/Ferrous Metal Substrates

SSPC-SP1- Solvent Cleaning: Solvent cleaning is a method for removing all visible oil, grease, soil, drawing and cutting compounds, and other soluble contaminants. Solvent cleaning does not remove rust or mill scale. Change rags and cleaning solution frequently so that deposits of oil and grease are not spread over additional areas in the cleaning process. Be sure to allow adequate ventilation. Follow manufacturer's safety recommendations when using solvents. For complete instructions, refer to Steel Structures Paint Council Surface Preparation Specification No.1. (Refer to each products cleaning instructions. Many acrylic coatings will state; When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. Do not use hydrocarbon solvents for cleaning.)

SSPC-SP2 - Hand Tool Cleaning: Hand Tool Cleaning removes all loose mill scale, loose rust, and other detrimental foreign matter. It is not intended that adherent mill scale, rust, and paint be removed by this process. Mil scale, rust, and paint are considered adherent if they cannot be removed by lifting with a dull putty knife. Before hand tool cleaning, remove visible oil, grease, soluble welding residues, and salts by the methods outlined in SSPC-SP1. For complete instructions, refer to Steel Structures Paint Council Surface Preparation Specification No.2.

SSPC-SP3 - Power Tool Cleaning: Power Tool Cleaning removes all loose mill scale, loose rust, and other detrimental foreign matter. It is not intended that adherent mill scale, rust, and paint be removed by this process. Mil scale, rust, and paint are considered adherent if they cannot be removed by lifting with a dull putty knife. Before power tool cleaning, remove visible oil, grease, soluble welding residues, and salts by the methods outlined in SSPC-SP1. For complete instructions, refer to Steel Structures Paint Council Surface Preparation Specification No.3.

SSPC-SP5 / NACE 1 - White Metal Blast Cleaning: A White Metal Blast Cleaned surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, mill scale, rust, paint, oxides, corrosion products, and other foreign matter. Before blast cleaning, visible deposits of oil or grease shall be removed by any of the methods specified in SSPC-SP 1 or other agreed upon methods. For complete instructions, refer to Joint Surface Preparation Standard SSPC-SP5/NACE No.1.

SSPC-SP6 / NACE 3 - Commercial Blast Cleaning: A Commercial Blast Cleaned surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, mill scale, rust, paint, oxides, corrosion products, and other foreign matter, except for staining. Staining shall be limited to no more than 33 percent of each square inch of surface area and may consist of light shadows, slight streaks, or minor discoloration caused by stains of rust, stains of mill scale, or stains of previously applied paint. Before blast cleaning, visible deposits of oil or grease shall be removed by any of the methods specified in SSPC-SP 1 or other agreed upon methods. For complete instructions, refer to Joint Surface Preparation Standard SSPC-SP6/NACE No.3.

SSPC-SP7 / NACE 4 - Brush-Off Blast Cleaning: A Brush-Off Blast Cleaned surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, loose mill scale, loose rust, and loose paint. Tightly adherent mill scale, rust, and paint may remain on the surface. Mil scale, rust, and coating are considered adherent if they cannot be removed by lifting with a dull putty knife. Before blast cleaning, visible deposits of oil or grease shall be removed by any of the methods specified in SSPC-SP1 or other agreed upon methods. For complete instructions, refer to Joint Surface Preparation Standard SSPC-SP7/NACE No.4.

SSPC-SP10 / NACE 2 - Near-White Blast Cleaning: A Near White Blast Cleaned surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, mill scale, rust, paint, oxides, corrosion products, and other foreign matter, except for staining. Staining shall be limited to no more than 5 percent of each square inch of surface area and may consist of light shadows, slight streaks, or minor discoloration caused by stains of rust, stains of mill scale, or stains of previously applied paint. Before blast cleaning, visible deposits of oil or grease shall be removed by any of the methods specified in SSPC-SP 1 or other agreed upon methods. For complete instructions, refer to Joint Surface Preparation Standard SSPCSP10/ NACE No.2.

SSPC-SP11 - Power Tool Cleaning to Bare Metal: Metallic surfaces that are prepared according to this specification, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, mill scale, rust, paint, oxide corrosion products, and other foreign matter. Slight residues of rust and paint may be left in the lower portions of pits if the original surface is pitted. Prior to power tool surface preparation, remove visible deposits of oil or grease by any of the methods specified in SSPC -SP 1, Solvent Cleaning, or other agreed upon methods. For complete instructions, refer to Steel Structures Paint Council Surface Preparation Specification No.11.

SSPC-SP12 / NACE 5 - Surface Preparation and Cleaning of Metals by Waterjetting Prior to Recoating: High- and Ultra -High Pressure Water Jetting for Steel and Other Hard Materials This standard provides requirements for the use of high- and ultra-high pressure water jetting to achieve various degrees of surface cleanliness. This standard is limited in scope to the use of water only, without the addition of solid particles in the stream. For complete instructions, refer to Joint Surface Preparation Standard SSPC-SP12/NACE No.5.

SSPC-SP13 / NACE 6 or ICRI 03732 - Surface Preparation of Concrete: This standard gives requirements for surface preparation of concrete by mechanical, chemical, or thermal methods prior to the application of bonded protective coating or lining systems. The requirements of this standard are applicable to all types of cementitious surfaces including cast-in-place concrete floors and walls, precast slabs, masonry walls and shotcrete surfaces. An acceptable prepared concrete surface should be free of contaminants, laitance, loosely adhering concrete, and dust, and should provide a dry, sound, uniform substrate suitable for the application of protective coating or lining systems. Depending upon the desired finish and system, a block filler may be required. For complete instructions, refer to Joint Surface Preparation Standard SSPC-SP13/NACE No.6 or ICRI 03732

SSPC-SP14 / NACE 8 – Industrial Blast Cleaning: This standard gives requirements for industrial blast cleaning of unpainted or painted steel surfaces by the use of abrasives. This joint standard allows defined quantities of mill scale and/or old coating to remain on the surface. An industrial blast cleaned surface, when viewed without magnification, shall be free of all visible oil, grease, dust, and dirt. Traces of tightly adherent mill scale, rust, and coating residue are permitted to remain on 10% of each unit area of the surface. The traces of mill scale, rust, and coating shall be considered tightly adherent if they cannot be lifted with a dull putty knife. Shadows, streaks, and discolorations caused by stains of rust, stains of mill scale, and stains of previously applied coating may be present on the remainder of the surface.

SSPC-SP16 Brush-Off Blast Cleaning of Coated and Uncoated Galvanized Steel, Stainless Steels, and Non-Ferrous Metals: This standard covers the requirements for brush-off blast cleaning of uncoated or coated metal surfaces other than carbon steel by the use of abrasives. These requirements include visual verification of the end condition of the surface and materials and procedures necessary to achieve and verify the end condition. A brush-off blast cleaned non-ferrous metal surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust, metal oxides (corrosion products), and other foreign matter. Intact, tightly adherent coating is permitted to remain. A coating is considered tightly adherent if it cannot be removed by lifting with a dull putty knife.

High- and Ultra-High Pressure Water Jetting for Steel and Other Hard Materials:

SSPC-SP WJ-1/NACE WJ-1: Clean to Bare Substrate (WJ-1) is intended to be similar to the degree of surface cleanliness of SSPC-SP 5/NACE 1, except that stains are permitted to remain on the surface. This standard is used when the objec-tive is to remove every trace of rust and other corrosion products, coating and mill scale.

SSPC-SP WJ-2/NACE WJ-2: Very Thorough Cleaning (WJ-2) is intended to be similar to the degree of surface cleanliness of SSPC-SP 10/NACE 2, except that tightly adherent material, rather than only stains, is permitted to remain on the surface. This standard is used when the objective is to remove almost all rust and other corrosion products, coating, and mill scale.

SSPC-SP WJ-3/NACE WJ-3: Thorough Cleaning (WJ-3) is intended to be similar to the degree of surface cleanliness of SSPC-SP 10/NACE 2, except that tightly adherent material, rather than only stains, is permitted to remain on the surface. This standard is used when the objective is to remove much of the rust and other corrosion products, coating, and mil scale, leaving tightly adherent thin films.

SSPC-SP WJ-4/NACE WJ-4: Light Cleaning (WJ-4) is intended to be similar to the degree of surface cleanli-ness of SSPC-SP 10/NACE 2, except that tightly adherent material, rather than only stains, is permitted to remain on the surface. This standard is used when the objective is to allow as much of the tightly adherent rust and other corro-sion products, coating, and mill scale to remain as possible, Discoloration of the surface may be present.

Water Blasting NACE Standard RP-01-72: Removal of oil grease dirt, loose rust, loose mill scale, and loose paint by water at pressures of 2,000 to 2,500 psi at a flow of 4 to 14 gallons per minute.

Stucco S-W 22: Must be clean and free of any loose stucco. If recommended procedures for applying stucco are followed, and normal drying conditions prevail, the surface may be painted in 30 days. The pH of the surface should be between 6 and 9.

Wood—Exterior – S-W 23: Must be clean and dry. Prime and paint as soon as possible. Knots and pitch streaks must be scraped, sanded, and spot primed before a full priming coat is applied. Patch all nail holes and imperfections with a wood filler or putty and sand smooth. Caulk should be applied after priming.

Wood—Interior – S-W 24: All finishing lumber and flooring must be stored in dry, warm rooms to prevent absorption of moisture, shrinkage, and roughening of the wood. All surfaces must be sanded smooth, with the grain, never across it. Surface blemishes must be corrected and the area cleaned of dust before coating.

Vinyl Siding, Architectural Plastics, PVC & Fiberglass: – S-W 24: Clean the surface thoroughly by scrubbing with warm, soapy water. Rinse thoroughly, prime with appropriate white primer. Do not paint vinyl with any color darker than the original color. Do not paint vinyl with a color having a Light Reflective Value (LRV) of less than 56 unless VinylSafe® Colors are used. If VinylSafe® Colors are not used and darker colors lower than an LRV of 56 are, the vinyl may warp. Follow all painting guidelines of the vinyl manufacturer when painting. Only paint properly installed vinyl siding. Deviating from the manufacturer's painting guidelines may cause the warranty to be voided.

Previously Coated Surfaces – S-W 12: Maintenance painting will frequently not permit or require complete removal of all old coatings prior to repainting. However, all surface contamination such as oil, grease, loose paint, mill scale dirt, foreign matter, rust, mold, mildew, mortar, efflorescence, and sealers must be removed to assure sound bonding to the tightly adhering old paint. Glossy surfaces of old paint films must be clean and dull before repainting. Thorough washing with an abrasive cleanser will clean and dull in one operation, or, wash thoroughly and dull by sanding. Spot prime any bare areas with an appropriate primer. Recognize that any surface preparation short of total removal of the old coating may compromise the service length of the system. Check for compatibility by applying a test patch of the recommended coating system, covering at least 2 to 3 square feet. Allow to dry one week before testing adhesion per ASTM D3359. If the coating system is incompatible, complete removal is required per ASTM D4259.

Touch-Up, Maintenance and Repair

For a protective coating system to provide maximum long-term protection, regularly scheduled maintenance is required. Maintenance includes inspection of painted areas, cleaning of surfaces to remove oils, chemicals, and other contaminants, and touch-up of areas where the coatings have been damaged. Highly corrosive areas, such as those subjected to frequent chemical spillage, corrosive fumes, and/or high abrasion or temperature areas should be inspected frequently – every six months, for example. Areas exposed to less severe conditions, such as interiors and exteriors of potable water tanks, may be inspected annually to assess the condition of the coating system.

The SSPC-VIS 2, Standard Method for Evaluating Degree of Rusting on Painted Steel Surfaces, can be used as a guide to determine appropriate touch-up and repairs maintenance schedules. Touch-up would be suggested when the surface resembles Rust Grade 5-S (Spot Rusting), 6-G (General Rusting), or 6-P (Pinpoint Rusting). Surface preparation would generally consist of SSPC-SP2, SP3, SP11, or SP12. Overcoating a well protected, but aged steel surface showing no evidence of rusting, may be achieved by Low Pressure Water Cleaning per SSPC-SP12/WJ4, and applying an appropriate coating system.

Full removal of the existing coating system by abrasive blasting would be recommended when the surface resembles Rust Grade 3-S (Spot Rusting), 4-G (General Rusting), or 4-P (Pinpoint Rusting). When the coating system has deteriorated to encompass approximately 33% of the surface area, it is always more economical to consider full removal and reapplication of the appropriate protective coating system.

Mildew — Prior to attempting to remove mildew, it is always recommended to test any cleaner on a small, inconspicuous area prior to use. Bleach and bleaching type cleaners may damage or discolor existing paint films. Bleach alternative cleaning solutions may be advised.

Mildew may be removed before painting by washing with a solution of 1 part liquid bleach and 3 parts water. Apply the solution and scrub the mildewed area. Allow the solution to remain on the surface for 10 minutes. Rinse thoroughly with water and allow the surface to dry before painting. Wear protective eyewear, waterproof gloves, and protective clothing. Quickly wash off any of the mixture that comes in contact with your skin. Do not add detergents or ammonia to the bleach/water solution.



Reference Pages

Data Pages



PRODUCT DATA SHEET



ZINC CLAD® IV (85) ORGANIC ZINC RICH COATING

Revised: March 19, 2019

PRODUCT DESCRIPTION

ZINC CLAD IV (85) is a two-component, polyamide epoxy, zinc-rich coating. It contains 85% by weight of zinc dust pigment in the dried film.

- Coating self-heals to resume protection if damaged
- Provides cathodic/sacrificial

INTENDED USES

- For use over properly prepared blasted steel
- Areas exposed to fresh and salt water
- Areas exposed to brackish water
- Areas exposed to chemical fumes
- Topcoating is recommended for maximum protection
- Not recommended for immersion service

PRODUCT DATA

Finish: Flat Colors: Grav-Green **Volume Solids:** 68% ± 2%, ASTM D2697, mixed

VOC (mixed):

<340 g/L; 2.8 lb/gal, unreduced <340 g/L; 2.8 lb/gal, reduced 5%

2 components, premeasured; 8:1 2.25 gallons (8.5L) total Mix Ratio:

Typical Thickness:

Recommended Spreading Rate per coat:

	Min	imum	Maxi	mum
Wet mils (microns)	5.0	(125)	8.0	(200)
Dry mils (microns)	3.0	(75)	5.0	(125)
~Coverage sq ft/gal (m²/L)	218	(5.4)	363	(8.9)
Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft	1090	(26.8)		

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Shelf Life:

18 months, unopened

Store indoors at 40°F (4.5°C) to 100°F (38°C).

Flash Point:

80°F (27°C), PMCC, mixed

Reducer/Clean Up:

Above 80°F (27°C): M.E.K. Below 80°F (27°C): Reducer #58 or M.E.K.

Weight:

26.45 ± 0.2 lb/gal; 3.17 Kg/L, mixed

Average Dryin	ng Times @ 5	.0 mils wet (1	25 microns):
	40°F (4.5°C)	77°F (25°C) 50% RH	110°F (43°C)
Touch:	45 minutes	30 minutes	15 minutes
Handle:	1.5 hours	1 hour	45 minutes
Recoat*:			
minimum:	6 hours	4 hours	2 hours
maximum**:	none	none	none
Cure:	10 days	10 days	7-10 days
Pot Life:	8 hours	6 hours	4 hours
Sweat-in-time:	1 hour	30 minutes	15 minutes

*NOTE: Film must be free of solvent, hard and firm. When rubbed with the face of a coin or knife the film should polish but not flake or chip.

**Maximum Recoat: Unlimited. Must have a clean, dry surface for topcoating."Loose" chalk or salts must be removed in accordance with good painting practice.

Drying time is temperature, humidity, and film thickness dependent.

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Zinc rich coatings require direct contact between the zinc pigment in the coating and the metal substrate for optimum performance.

Minimum recommended surface preparation:

Iron & Steel:

Atmospheric: SSPC-SP6/NACE 3/ ISO8501-1:2007 Sa 2, 2 mil (50 micron) profile

Note: If blast cleaning with steel media is used, an appropriate amount of steel grit may be incorporated into the work mix to render a dense, angular 1.5-3.0 mil (38-75 micron) surface profile.



PRODUCT DATA SHEET



ZINC CLAD® IV (85) ORGANIC ZINC RICH COATING

APPLICATION

Airless Spray (use Teflon packings and continuous agitation)

Pressure......2000-2300 psi (138-158 bar)

Hose.....3/8" ID (9.5 mm) Tip019" (0.48 mm)

Reduction.....As needed, up to 10% by volume

Conventional Spray

(continuous agitation required)

Atomization Pressure.....50 psi (3.4 bar) Fluid Pressure......10-20 psi (0.7-1.4 bar)

Reduction.....As needed, up to 10% by volume

Keep pressure pot at level of applicator to avoid blocking of fluid line due to weight of material. Blow back coating in fluid line at intermittent shutdowns, but continue agitation at pressure pot.

Brush

Brush.....For touch-up only (reduction not recommended)

If specific application equipment is not listed above, equivalent equipment may be substituted.

RECOMMENDED SYSTEMS

Dry Film	Thickness / ct.	<u>Mils</u>	(Microns)
1 Ct.	rganic Zinc/Epoxy Zinc Clad IV (85) Macropoxy 646	3.0-5.0 5.0-10.0	(75-125) (125-250)
1 Ct.	rganic Zinc/Epoxy/Urethane Zinc Clad IV (85) Macropoxy 646 Acrolon 7300	3.0-5.0 5.0-10.0 2.0-4.0	(75-125) (125-250) (50-100)
Steel, O 1 Ct. 1 Ct. 1 Ct.	rganic Zinc/Epoxy/Urethane Zinc Clad IV (85) Macropoxy 267 Acrolon 7300	3.0-5.0 5.0 2.0-4.0	(75-125) (125) (50-100)
1 Ct.	rganic Zinc/Polysiloxane Zinc Clad IV (85) Sher-Loxane 800	3.0-5.0 2.0-4.0	(75-125) (50-100)

The systems listed above are representative of the product's use, other systems may be appropriate.

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures, Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

APPLICATION CONDITIONS

Temperature (air, surface, material):

40°F (4.5°C) minimum, 120°F (49°C)

maximum

At least 5°F (2.8°C) above dew point

Relative humidity:

85% maximum

APPROVALS

- Meets SSPC-Paint 20 Type II, Organic, Level 1
- Meets Class A requirements for Slip Coefficient and Creep Resistance, .49

ADDITIONAL NOTES

Mixing Instructions: Mix contents of each component thoroughly with a low speed power agitator. Make certain no pigment remains on the bottom of the can. Then combine 8 parts by volume of Part U with 1 part by volume of Part V. Thoroughly agitate the mixture with power agitation. After mixing, pour through a 30-60 mesh screen. Allow the material to sweat-in as indicated. Re-stir before using. If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in. Continuous agitation of mixture during application is required, otherwise zinc dust will quickly settle out.

Do not tint.

HEALTH AND SAFETY

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

DISCLAIMER

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PRODUCT DATA SHEET



MACROPOXY® 646

FAST CURE EPOXY

Revised: October 23, 2020

PRODUCT DESCRIPTION

MACROPOXY 646 Fast Cure Epoxy is a high solids, high build, fast drying, polyamide epoxy designed to protect steel and concrete in industrial exposures. Ideal for maintenance painting and fabrication shop applications. The high solids content ensures adequate protection of sharp edges, corners, and welds. This product can be applied directly to marginally prepared steel surfaces.

INTENDED USES

- Recommended for marine applications, refineries, offshore platforms, fabrication shops, chemical plants, tank exteriors, power plants, water treatment plants, and mining and minerals industry
- Mill White and Black are acceptable for immersion use for salt water and fresh water, not acceptable for potable water

PRODUCT DATA

Finish: Semi-Gloss Mill White, Black and a wide range of colors available through tinting Colors: Volume Solids: 72% ± 2%, mixed, Mill White Unreduced: <250 g/L; 2.08 lb/gal Reduced 10%: <300 g/L; 2.50 lb/gal VOC (mixed): Mix Ratio: 1:1 by volume

Typical Thickness:

Recommended Spreading Rate per coat:

	Mini	imum	Maxi	mum
Wet mils (microns) Dry mils (microns) ~Coverage sq ft/gal (m²/L) Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microps dft	7.0	(175)	13.5	(338)
Dry mils (microns)	5.0*	(125)	10.0	(250)
~Coverage sq ft/gal (m²/L)	115	(2.9)	230	(5.8)
Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft	1152	(28.2)		

*May be applied at 3.0-10.0 mils (75-250 microns) dft as an intermediate in a multicoat system.

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Shelf Life: 36 months, unopened

Store indoors at 40°F (4.5°C) to 110°F (43°C).

Flash Point: 91°F (33°C), TCC, mixed

Reducer/Clean Up: Reducer #15, Reducer #58, or MEK (California) Reducer #111 or Oxsol 100

12.9 ± 0.2 lb/gal; 1.55 Kg/L, mixed, may Weight:

vary by color

Average Drying Times @ 7.0 mils (175 microns) wet:

	35°F (1.7°C)	77°F (25°C)	100°F (38°C)
	50% RH	50% RH	50% RH
Touch:	4-5 hours	2 hours	1.5 hours
Handle:	48 hours	8 hours	4.5 hours
Recoat:			
minimum:	48 hours	8 hours	4.5 hours

maximum: 1 year 1 year 1 year Cure to service:

atmospheric: 10 days 7 days 4 days immersion: 14 days 7 days 4 days

Average Drying Times as intermediate @ 5.0 mils (125 microns) wet:

Touch: 3 hours 1 hour 1 hour Handle: 48 hours 4 hours 2 hours Recoat:

> minimum: 16 hours 4 hours 2 hours maximum: 1 year 1 year 1 year

If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent. Paint temperature must be 40°F (4.5°C) minimum.

Pot Life: 10 hours 4 hours 2 hours Sweat-in-time: 30 minutes 30 minutes 15 minutes

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Minimum recommended surface preparation:
Iron & Steel:
Atmospheric: SSPC-SP2/3/ ISO8501-1:2007 St 2 or SSPC-SP WJ-3 / NACE WJ-3L Immersion: SSPC-SP10 / NACE 2/ ISO8501-1:2007 Sa 2.5, 2-3 mil (50-75 micron) profile or SSPC-SP WJ-2/NACE WJ-2L

Atmospheric: SSPC-SP16, 1 mil (25 micron) profile Stainless Steel:

SSPC-SP1. If surface has not be weathered for more than 6 months, follow SSPC-SP1 then SSPC-SP16. For fire proofing projects, consult a Sherwin-Williams representative for surface preparation requirements. Aluminum & Galvanizing:

Concrete & Masonry: Atmospheric: SSPC-SP13/NACE 6, or ICRI No. 310.2R CSP 1-3 Immersion: SSPC-SP13/NACE 6-4.3.1

Ductile Iron Pipe:

Atmospheric: NAPF 500-03-03 Power Tool Cleaning Buried & Immersion: NAPF 500-03-04 Abrasive Blast Cleaning Cast Ductile Iron Fittings: NAPF 500-03-05 Abrasive Blast Cleaning



PRODUCT DATA SHEET



MACROPOXY® 646

FAST CURE EPOXY

APPLICATIO	N		APPLICATION CONDITIONS
Airless Spray* 30:1 Pump	osi (193-206 mm) (0.43-0.58 m		Temperature: Air: 35°F (1.7°C) minimum, 120°F (49°C) maximum Surface*: 35°F (1.7°C) minimum, 250°F (120°C) maximum Material: 40°F (4.5°C) minimum At least 5°F (2.8°C) above dew point Relative humidity: 85% maximum
Conventional Spray* Gun DeVilbiss Miner Fluid Tip E Air Nozzle 704 Atomization Pressure 60-65 psi (4 Fluid Pressure 10-20 psi (0	3C-510 .1-4.5 bar)		*When spraying a surface above 120°F (49°C), reduce material 10% with Reducer #100, R7K100. Spray apply only. Product will produce an orange peel appearance when applied at elevated temperatures. APPROVALS • Suitable for use in USDA inspected facilities
Brush* BrushNylon/Polye Roller* Cover3/8" woven v Plural Component Spray Acceptable *ReductionAs needed u	vith solvent i	resistant core	Acceptable for use in Canadian Food Processing facilities, categories: D1, D2, D3 (Confirm acceptance of specific part numbers/rexes with your SW Sales Representative) Conforms to AWWA D102 OCS #5
If specific application equipment is not lequipment may be substituted. RECOMMENDED S		equivalent	150 microns dft (Mill White only) Approved intermediate for NEPCOAT System B * Nuclear qualifications are NRC license specific to the facility
Dry Film Thickness / ct.	Mils	(Microns)	ADDITIONAL NOTES
Steel & Ductile Iron, Immersion & Atr 2 Cts. Macropoxy 646	nospheric 5.0-10.0	(125-250)	Tint Part A with Maxitoners at 150% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.
Steel, Organic Zinc Primer, Atmospho 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646	eric 3.0-5.0 5.0-10.0	(75-125) (125-250)	Tinting is not recommended for immersion service. Quik-Kick Epoxy Accelerator is acceptable for use. See data page
Steel, Inorganic Zinc Primer, Atmosp 1 Ct. Zinc Clad II (85) 1 Ct. Macropoxy 646	heric 2.0-4.0 5.0-10.0	(50-100) (125-250)	for details. Acceptable for concrete floors.
Steel, Organic Zinc/Epoxy/Urethane 7 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646 1 Ct. Acrolon 7300	3.0-5.0 3.0-10.0 2.0-4.0	(75-125) (75-250) (50-100)	When spraying a surface above 120°F (49°C), reduce material 10% with Reducer #100. Spray apply only. Product will produce an orange peel appearance when applied at elevated temperatures.
Steel, Inorganic Zinc/Epoxy/Urethane 1 Ct. Zinc Clad II (85) 1 Ct. Macropoxy 646 1 Ct. Acrolon 7300	2.0-4.0 3.0-10.0 2.0-4.0	(50-100) (75-250) (50-100)	Topcoating: It is recommended to apply a thinned-down, low wet film thickness mist coat over zinc rich primers to help avoid outgassing. Allow it to tack up and seal the surface. Then apply a full wet film thickness coat as directed.
Steel, Organic Zinc/Epoxy/Polysiloxan 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646 1-2 Cts. Sher-Loxane 800	3.0-5.0 3.0-10.0 2.0-4.0	tmospheric (75-125) (75-250) (50-100)	Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agita-

WARRANTY

Concrete/Masonry, Smooth, Immersion & Atmospheric 2 Cts. Macropoxy 646 5.0-10.0 (125-250)

The systems listed above are representative of the product's use, other systems may be appropriate.

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HEALTH AND SAFETY

agitation. Make certain no pigment remains on the bottom of the can. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agita-

tion. Allow the material to sweat-in as indicated prior to application.

Refer to the SDS sheet before use.

Re-stir before using.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.



ACROLON™ 218 HS ACRYLIC POLYURETHANE

PART A B65-600 GLOSS SERIES PART A B65-650 SEMI-GLOSS SERIES PART B B65V600 HARDENER

Revised: January 11, 2021

PRODUCT INFORMATION

5.22

PRODUCT DESCRIPTION

ACROLON 218 HS is a polyester modified, aliphatic, acrylic polyurethane formulated specifically for in-shop applications. Also suitable for industrial applications. A fast drying, urethane that provides color and gloss retention for exterior exposure.

- Can be used directly over organic zinc rich primers (epoxy zinc primer and moisture cure urethane zinc primer) Color and gloss retention for exterior exposure

Fast dry

Outstanding application properties

PRODUCT CHARACTERISTICS

Finish: Gloss or Semi-Gloss

Color: Wide range of colors available

Volume Solids: 65% ± 2%, mixed, may vary by color Weight Solids: 78% ± 2%, mixed, may vary by color

thod 24): Unreduced: <300 g/L; 2.5 lb/gal Reduced 10% with R7K15: <340 g/L; 2.8 lb/gal Reduced 9% with MEK, R6K10: <340 g/L; 2.8 lb/gal VOC (EPA Method 24): mixed

mixed Mix Ratio:

6:1 by volume, 1 gallon or 5 gallon mixes premeasured components

Recommended Spreading Rate per coat:

	Min	imum	Maxi	mum
Wet mils (microns)	4.5	(112.5)	9.0	(225)
Dry mils (microns)	3.0	(75)	6.0	(150)
~Coverage sq ft/gal (m²/L)	175	(4.3)	346	(8.5)
Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft	1040	(25.5)		25 (6.2)

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 6.0 mils wet (150 microns):

	@ 35°F/1.7°C	@ 77°F/25°C	@ 120°F/49°C
		50% RH	
To touch:	4 hours	1 hour	20 minutes
To handle:	18 hours	9 hours	4 hours
To recoat:			
minimum:	18 hours	8 hours	6 hours
maximum:	3 months	3 months	3 months
To cure:	14 days	7 days	5 days
Pot Life:	4 hours	2 hours	45 minutes
(reduced 5% with F	Reducer R7K15)		
Sweet in Time	and the second of the second o	None	

None Sweat-in-Time: Drying time is temperature, humidity, and film thickness dependent. Paint temperature must be at least 40°F (4.5°C) minimum.

Part A* - 36 months, unopened Part B - 24 months, unopened Shelf Life:

Store indoors at 40°F (4.5°C) to 100°F (38°C).

*Aluminum (Part A, Rex # B65SW655) has a shelf life of 24 months. Flash Point: 55°F (13°C), Seta, mixed

Reducer/Clean Up: Spray:

Reducer R7K15, MEK R6K10,

R7K111, Reducer #58 Brush / Roll: Reducer #132, Reducer #58,

R7K111

RECOMMENDED USES

Specifically formulated for in-shop applications.

For use over prepared metal and masonry surfaces in industrial environments such as:

- Structural steel
- Tank exteriors
- Rail cars and locomotives Conveyors
- **Pipelines** Ships

- Bridges
- Wind Towers onshore and offshore
- Offshore platforms exploration and production Suitable for use in USDA inspected facilities
- Conforms to AWWA D102 Outside Coating Systems #4 (OCS-4), #5 (OCS-5) & #6 (OCS-6) Conforms to MPI# 72 and MPI# 174
- Acceptable for use in high performance architectural applications
- Acceptable for use over and/or under Loxon S1 and Loxon H1 Caulking
- A component of INFINITANK
- Over FIRETEX® hydrocarbon systems
- Suitable for use in the Mining & Minerals Industry Approved topcoat for NEPCOAT System B

Performance Characteristics

Substrate*: Steel

Surface Preparation*: SSPC-SP10/NACE 2

System Tested*:

ct. Macropoxy 646 @ 6.0 mils (150 microns) dft

1 ct. Acrolon 218 HS Gloss @ 4.0 mils (100 microns) dft

*unless otherwise noted below					
Test Name	Test Method	Results			
Abrasion Resistance ¹	ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load	43 mg loss			
Adhesion ³	ASTM D4541	1976 psi			
Corrosion Weathering ³	ASTM D5894, 27 cycles, 9072 hours	Rating 10 per ASTM D610, for rusting; Rating 10 per ASTM D714, for blistering			
Direct Impact Resistance ¹	ASTM D2794	70 in. lb.			
Dry Heat Resistance	ASTM D2485, Method A	200°F (93°C)			
Flexibility ¹	ASTM D522, 180° bend, 1/8" mandrel	Passes			
Humidity Resistance ²	ASTM D4585, 100°F (38°C), 1500 hours	Rating 10 per ASTM D610, for rusting; Rating 10 per ASTM D714, for blistering			
Pencil Hardness	ASTM D3363	3H			
Salt Fog Resistance ³	ASTM B117, 15,000 hours	Rating 10 per ASTM D610, for rusting; Rating 10 per ASTM D714, for blistering			

Meets the requirements of SSPC Paint No. 36, Level 3 for white and light colors. Dark colors may require a clear coat.

Complies with ISO 12944-5 C5I and C5M requirements.

Footnotes:

¹ Finish coat only tested

² Primer Zinc-Clad II Plus Intermediate Macropoxy 646 Acrolon 218 HS Finish ³Primer Zinc-Clad III HS



ACROLON™ 218 HS ACRYLIC POLYURETHANE

PART A B65-600 **GLOSS SERIES** PART A B65-650 **SEMI-GLOSS SERIES** PART B B65V600 HARDENER

Revised: January 11, 2021

PRODUCT INFORMATION

5.22

RECOMMENDED SYSTEMS

	Dry	Film Thick <u>Mils</u>	ness / ct. (<u>(Microns)</u>
Steel: 1 ct. Macropoxy 646 1-2 cts. Acrolon 218 HS Polyurethane		5.0-10.0 3.0-6.0	(125-250) (75-150)
Steel: 1 ct. Zinc Clad II Plus 1 ct. Macropoxy 646 1-2 cts. Acrolon 218 HS Polyurethane		2.0-4.0 3.0-10.0 3.0-6.0	(50-100) (75-250) (75-150)
Steel: 1 ct. Zinc Clad IV or Zinc Clad 4100 1 ct. Macropoxy 646 1-2 cts. Acrolon 218 HS Polyurethane		3.0-5.0 3.0-5.0 3.0-10.0 3.0-6.0	(75-125) (75-125) (75-250) (75-150)
Steel: 1 ct. Zinc Clad IV 1-2 cts. Acrolon 218 HS Polyurethane		3.0-5.0 3.0-6.0	(75-125) (75-150)
Steel: 1 ct. Corothane I-GalvaPac Zinc Pri 1-2 cts. Acrolon 218 HS Polyurethane	mer	3.0-4.0 3.0-6.0	(75-100) (75-150)
Steel: 1 ct. Epoxy Mastic Aluminum II 1-2 cts. Acrolon 218 HS Polyurethane		6.0 3.0-6.0	(150) (75-150)
Steel: 1 ct. Recoatable Epoxy Primer 1-2 cts. Acrolon 218 HS Polyurethane		4.0-6.0 3.0-6.0	(100-150) (75-150)
Concrete/Masonry: 1 ct. Kem Cati-Coat HS Epoxy Filler/Sealer		10.0-20.0	(250-500)
1-2 cts. Acrolon 218 HS Polyurethane		3.0-6.0	(75-150)
Aluminum/Galvanizing: 1 ct. DTM Wash Primer 1-2 cts. Acrolon 218 HS Polyurethane		0.7 - 1.3 3.0 - 6.0	(18-32) (75-150)
FIDETEY ONLY			

FIRETEX ONLY:

Finish Coat for FIRETEX Hydrocarbon Systems:

Acrolon 218 HS Polyurethane*

*Consult FIRETEX PFP Specialist for recommended dft range

The systems listed above are representative of the product's use, other systems may be appropriate.

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SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

* Iron & Steel: SSPC-SP6/NACE 3, 1-2 mil
(25-50 micron) profile
SSPC-SP1
SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3

Primer required

Surface Preparation Standards							
	Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE		
White Metal Near White Metal Commercial Blast Brush-Off Blast		Sa 3 Sa 2.5 Sa 2 Sa 1	Sa 3 Sa 2.5 Sa 2 Sa 1	SP 5 SP 10 SP 6 SP 7	1 2 3 4		
Hand Tool Cleaning	Rusted Pitted & Rusted	C St 2 D St 2	C St 2 D St 2	SP 2 SP 2			
Power Tool Cleaning	Dustad	C St 3 D St 3	C St 3 D St 3	SP 3 SP 3			

TINTING

Tint Part A with Maxitoner Colorants.

Extra white tints at 100% tint strength

Ultradeep base tints at 150% tint strength

Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.

APPLICATION CONDITIONS

35°F (1,7°C) minimum, 120°F (49°C) Temperature: maximum (air and surface) 40°F (4.5°C) minimum, 120°F (49°C)

maximum (material) At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging: 1 gallon (3.78L) mix: 5 gallon (18.9L) mix: .86 gal (3.25L) .14 gal (0.53L) (premeasured components)

 11.2 ± 0.2 lb/gal ; 1.3 Kg/L mixed, may vary with color Weight:

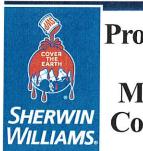
SAFETY PRECAUTIONS

Refer to the SDS sheet before use.

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WARRANTY

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ACROLON™ 218 HS ACRYLIC POLYURETHANE

PART A B65-600
PART A B65-650
PART B B65V600

GLOSS SERIES SEMI-GLOSS SERIES HARDENER

Revised: January 11, 2021

APPLICATION BULLETIN

5 22

SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (1-2 mils / 25-50 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

Aluminum

Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer required.

Galvanized Steel

Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned or before flash rusting occurs. Primer required.

Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 1-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910. Primer required.

Follow the standard methods listed below when applicable:

ASTM D4258 Standard Practice for Cleaning Concrete. ASTM D4259 Standard Practice for Abrading Concrete.

ASTM D4260 Standard Practice for Etching Concrete.

ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.

SSPC-SP 13/Nace 6 Surface Preparation of Concrete.

ICRI No. 310.2R Concrete Surface Preparation.

Surface Preparation Standards					
	Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal Near White Metal Commercial Blast		Sa 3 Sa 2.5 Sa 2	Sa 3 Sa 2.5 Sa 2	SP 5 SP 10 SP 6	1 2 3
Brush-Off Blast Hand Tool Cleaning	Rusted	Sa 1 C St 2	Sa 1 C St 2	SP 7 SP 2	4
Power Tool Cleaning	Pitted & Rusted Rusted Pitted & Rusted	D St 2 C St 3 D St 3	D St 2 C St 3 D St 3	SP 2 SP 3 SP 3	-

APPLICATION CONDITIONS

Temperature: 35°F (1.7°C) minimum, 120°F (49°C)

maximum (air and surface)

40°F (4.5°C) minimum, 120°F (49°C)

maximum (material)

At least 5°F (2.8°C) above dew point

Relative humidity:

85% maximum

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up:

Spray	Reducer R7K15, MEK, Reducer #58, or
	R7K111
Brush/Roll	Reducer #132, R7K132, Reducer #58,
	or R7K111

If reducer is used, reduce at time of catalyzation.

Airless Spray

Pressure	2500 - 2800 psi
Hose	3/8" ID
Tip	013"017"
Filter	60 mesh
Reduction	As needed up to 10% by volume with
	D71/45 D71/444 t- 00/ th

R7K15 or R7K111, or up to 9% with

MEK, R6K10*

Conventional Spray

Gun	Binks 95
Cap	63P
Atomization Pressure.	50 - 70 psi
Fluid Pressure	20 - 25 psi
Reduction	As needed up to 10% by volume with
	R7K15 or R7K111, or up to 9% with

MEK, R6K10*

Brush

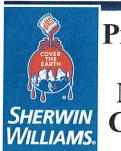
Brush	Natural Bristle	
Reduction	As needed up to	10% by volume*

Roller

Cover	.3/8" woven with solvent resistant core
Reduction	As needed up to 10% by volume*

If specific application equipment is not listed above, equivalent equipment may be substituted.

* Note: Reducing more than maximum recommended level will result in VOC exceeding 340g/L



ACROLON™ 218 HS ACRYLIC POLYURETHANE

PART A B65-600 GLOSS SERIES
PART A B65-650 SEMI-GLOSS SERIES
PART B B65V600 HARDENER

Revised: January 11, 2021

APPLICATION BULLETIN

5.22

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine six parts by volume of Part A with one part by volume of Part B (premeasured components). Thoroughly agitate the mixture with power agitation. Re-stir before using.

If reducer is used, add only after both components have been thoroughly mixed.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate per coat:

	Minimum		Maximum	
Wet mils (microns)	4.5	(112.5)	9.0	(225)
Dry mils (microns)	3.0	(75)	6.0	(150)
~Coverage sq ft/gal (m²/L)	175	(4.3)	346	(8.5)
Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft	1040	(25.5)		

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 6.0 mils wet (150 microns):

	O 05054 500	0.0000000	
	@ 35°F/1.7°C	@ 77°F/25°C	@ 120°F/49°C
		50% RH	
To touch:	4 hours	1 hour	20 minutes
To handle:	18 hours	9 hours	4 hours
To recoat:			
minimum:	18 hours	8 hours	6 hours
maximum:	3 months	3 months	3 months
To cure:	14 days	7 days	5 days
Pot Life:	4 hours	2 hours	45 minutes
(reduced 5% with F	Reducer R7K15)		
Sweat-in-Time:		None	

Drying time is temperature, humidity, and film thickness dependent. Paint temperature must be at least 40°F (4.5°C) minimum.

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Reducer #132, R7K132. Clean tools immediately after use with Reducer #132, R7K132. Follow manufacturer's safety recommendations when using any solvent.

DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build

Excessive reduction of material can affect film build, appearance, and adhesion.

Do not apply the material beyond recommended pot life.

Do not mix previously catalyzed material with new.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer #15, R7K15 or MEK, R6K10.

Mixed coating is sensitive to water. Use water traps in all air lines. Moisture contact can reduce pot life and affect gloss and color.

Quick-Thane Urethane Accelerator is acceptable for use. See data page 5.97 for details.

E-Z Roll Urethane Defoamer is acceptable for use. See data page 5.99 for details.

If maximum recoat time is exceeded, a light abrasion may be necessary to roughen the surface to promote adhesion before recoating.

When over coating for maintenance or covering graffiti, solvent clean with MEK or similar solvent/cleaner prior to overcoating.

Refer to Product Information sheet for additional performance characteristics and properties.

SAFETY PRECAUTIONS

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.