

**LEGEND**

	BUILDING/SHELTER REMOVAL
	PCC REMOVAL
	WOOD CHIP SURFACING REMOVAL
	TREE REMOVAL
	REMOVAL AS NOTED
	CURB REMOVAL

**HORIZONTAL CONTROL - MAD 89**

POINT #	NORTHING	EASTING	DESCRIPTION	ELEVATION
1	172490.000	271952.278	CP MALL	626.21
2	172490.000	271952.278	CP MALL	626.54
3	172490.000	271952.278	CP MALL	626.10
4	172490.000	271952.278	CP MALL	626.82
201	172490.000	271952.278	BM MASONRY CP	626.54
202	172490.000	271952.278	BM MASONRY CP	626.54

- DEMOLITION NOTES**
1. PRIOR TO ANY EXCAVATION AT THE SITE, CONTRACTOR SHALL EXAMINE ANY APPLICABLE DRAWINGS AVAILABLE FROM THE OWNER AND/OR ENGINEER AND CONSULT WITH OWNER'S PERSONNEL AND UTILITY COMPENSATION WILL BE ALLOWED FOR DAMAGE RESULTING FROM FAILURE TO COMPLY WITH THIS REQUIREMENT.
  2. PROTECT ALL TREES WITHIN THE CONTRACT LIMITS NOT INDICATED TO BE REMOVED.
  3. THE CONTRACTOR'S EXPENSES AND DANGERS DUE TO CONTRACTOR'S OPERATIONS SHALL BE REPAIRED AT 4. SANICUT EDGES OF PAVEMENT SHALL BE REPAIRED TO PREVENT DAMAGE TO ADJACENT SLABS AND FINISHES.
  5. CONTRACTOR SHALL KEEP REQUIRED AREAS SECURE WHEN FENCING OR OTHER MEASURES ARE NECESSARILY REQUIRED.
  6. IMMEDIATELY NOTIFY ENGINEER OF UNEXPECTED SUB-SURFACE CONDITIONS, DISCONTINUE WORK IN AREA UNTIL ADVISED BY ENGINEER.
  7. NOTIFY ALL UTILITIES OF ANY SCHEDULED DISCONNECTION OF UTILITIES OR SERVICE DISRUPTIONS.
  8. COORDINATE WITH OWNER WHEN SCHEDULING DISCONNECTION OF UTILITIES OR SERVICE DISRUPTIONS.
  9. USE APPROPRIATE DRAINAGE METHODS FOR ALL UTILITY EXCAVATIONS WITHIN 2' OF PAVED SURFACES.
  10. ALL CONSTRUCTION DEBRIS SHALL BE DISPOSED OF PROPERLY OFF-SITE.

- GENERAL NOTES**
1. CONTRACTOR SHALL COMPLY WITH ALL ILLINOIS STATUTES, ORDINANCES, REGULATIONS FOR ROAD AND ILLINOIS ACCESSIBILITY CODE.
  2. LOCATION OF UNDERGROUND UTILITIES SHOULD BE CONSIDERED AS APPROXIMATE ONLY. IT IS THE CONTRACTOR'S RESPONSIBILITY TO VERIFY THE LOCATION OF ALL UTILITIES PRIOR TO ANY EXCAVATION OR EXISTING UTILITIES IN OR NEAR THE CONSTRUCTION AREA.
  3. CONTRACTOR SHALL PROTECT ALL ABOVE AND BELOW GROUND EXISTING UTILITIES, PAVED STREETS AND OWNER IMMOVABLE PROPERTY. ANY DAMAGE TO EXISTING UTILITIES, PAVED STREETS AND OWNER IMMOVABLE PROPERTY OF ANY NATURE SHALL BE REPAIRED BY THE CONTRACTOR AT HIS OWNERS RISK AND EXPENSE.
  4. IMMEDIATELY NOTIFY ENGINEER OF UNEXPECTED SUB-SURFACE CONDITIONS, DISCONTINUE WORK IN AREA UNTIL NOTIFIED BY ENGINEER TO RESUME WORK.
  5. CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT PER ALL GRADES.
  6. CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT PER ALL GRADES.
  7. CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT PER ALL GRADES.
  8. CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT PER ALL GRADES.
  9. CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT PER ALL GRADES.
  10. CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT PER ALL GRADES.



**ILLINOIS DESIGN FIRM NO. 154-063177**

Seal of the State of Illinois, Department of Transportation, State Engineer, State Surveyor, State Auditor, State Treasurer, State Comptroller, State Attorney General, State Commissioner of Public Safety, State Commissioner of Labor, State Commissioner of Conservation, State Commissioner of Public Health, State Commissioner of State Police, State Commissioner of State Police, State Commissioner of State Police, State Commissioner of State Police.

Seal of the State of Illinois, Department of Transportation, State Engineer, State Surveyor, State Auditor, State Treasurer, State Comptroller, State Attorney General, State Commissioner of Public Safety, State Commissioner of Labor, State Commissioner of Conservation, State Commissioner of Public Health, State Commissioner of State Police, State Commissioner of State Police, State Commissioner of State Police, State Commissioner of State Police.

Seal of the State of Illinois, Department of Transportation, State Engineer, State Surveyor, State Auditor, State Treasurer, State Comptroller, State Attorney General, State Commissioner of Public Safety, State Commissioner of Labor, State Commissioner of Conservation, State Commissioner of Public Health, State Commissioner of State Police, State Commissioner of State Police, State Commissioner of State Police, State Commissioner of State Police.

**rtm**  
 engineering consultants  
 5137 ridley ridge road  
 downers grove, IL 60137  
 www.rtmcc.com

no.	date	revision

Post Office Park  
 121 E 22nd Ave  
 Coal Valley, IL

BUSH Construction

THE PROJECT NO. 2134A-C03  
 PREPARED BY: BUSH  
 CHECKED BY: BUSH  
 DATE: 6/20/22

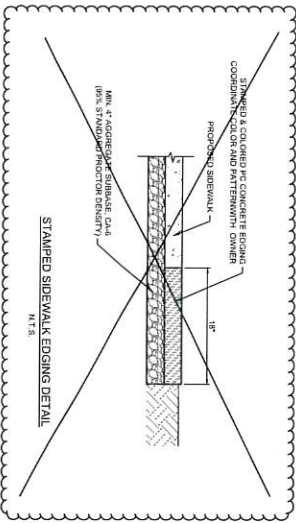
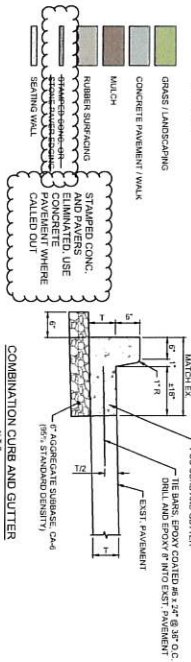
EXISTING  
 TOPO &  
 DEMO PLAN

C-1

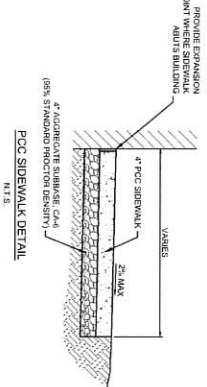




**LEGEND**



STAMPED CONC. AND PAVERS CONCRETE USE PAVEMENT WHERE CALLED OUT



- CONSTRUCTION STAGING AND LAYOUT NOTES:**
- CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT FOR ALL CONSTRUCTION.
  - ALL CONSTRUCTION SHALL BE IN ACCORDANCE WITH THE CITY OF COAL VALLEY, ILL. UNLESS NOTED OTHERWISE. PROPERTY LINES AND PERMANENT REFERENCE MARKERS DISTURBED BY THE CONTRACTOR SHALL BE REPLACED BY A REGISTERED LAND SURVEYOR IN THE STATE OF ILLINOIS AT THE CONTRACTOR'S EXPENSE.
  - STAMPED CONC. AND PAVERS SHALL BE PROVIDED BY THE CONTRACTOR. THE CONTRACTOR SHALL BE RESPONSIBLE FOR OBTAINING ALL NECESSARY PERMITS AND APPROVALS FROM THE CITY OF COAL VALLEY, ILL. PRIOR TO CONSTRUCTION.
  - ELECTRONIC AUTODISK CHITLES WILL BE PROVIDED TO AID CONSTRUCTION LAYOUT. IT IS THE RESPONSIBILITY OF THE CONTRACTOR TO LAYOUT THE LOCATION AND DIMENSIONS BASED ON THE PROVIDED ELECTRONIC FILES FOR CONSTRUCTION. THE CONTRACTOR SHALL BE RESPONSIBLE FOR VERIFYING THE PROVIDED FILES AND THE ELECTRONIC FILES BEFORE PROCEEDING WITH WORK.
  - VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
  - VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
  - VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
  - VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
  - VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
  - VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.

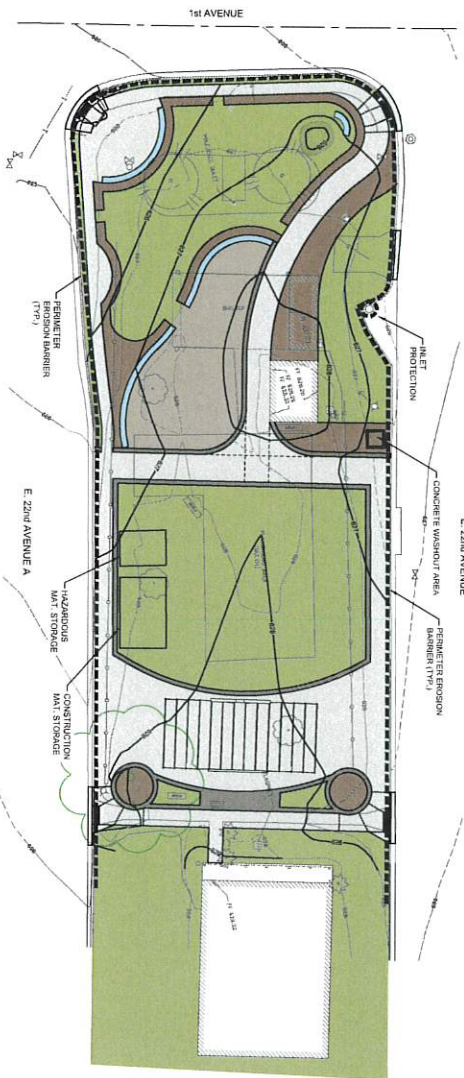
**PCC PAVING AND SIDEWALK NOTES:**

- CONTRACTOR SHALL BE RESPONSIBLE FOR PROVIDING CONSTRUCTION LAYOUT FOR ALL CONSTRUCTION.
- ALL CONSTRUCTION SHALL BE IN ACCORDANCE WITH THE CITY OF COAL VALLEY, ILL. UNLESS NOTED OTHERWISE. PROPERTY LINES AND PERMANENT REFERENCE MARKERS DISTURBED BY THE CONTRACTOR SHALL BE REPLACED BY A REGISTERED LAND SURVEYOR IN THE STATE OF ILLINOIS AT THE CONTRACTOR'S EXPENSE.
- STAMPED CONC. AND PAVERS SHALL BE PROVIDED BY THE CONTRACTOR. THE CONTRACTOR SHALL BE RESPONSIBLE FOR OBTAINING ALL NECESSARY PERMITS AND APPROVALS FROM THE CITY OF COAL VALLEY, ILL. PRIOR TO CONSTRUCTION.
- ELECTRONIC AUTODISK CHITLES WILL BE PROVIDED TO AID CONSTRUCTION LAYOUT. IT IS THE RESPONSIBILITY OF THE CONTRACTOR TO LAYOUT THE LOCATION AND DIMENSIONS BASED ON THE PROVIDED ELECTRONIC FILES FOR CONSTRUCTION. THE CONTRACTOR SHALL BE RESPONSIBLE FOR VERIFYING THE PROVIDED FILES AND THE ELECTRONIC FILES BEFORE PROCEEDING WITH WORK.
- VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
- VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
- VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
- VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
- VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.
- VERIFY ALL COORDINATES PRIOR TO CONSTRUCTION. CHECK HORIZONTAL AND VERTICAL IMPROVEMENTS INCLUDING BUT NOT LIMITED TO: CURBS, SIDEWALKS, DRIVEWAYS, AND DRIVEWAYS. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION. VERIFY THE LOCATION AND DIMENSIONS OF ALL IMPROVEMENTS PRIOR TO CONSTRUCTION.





SITE GRADING PLAN  
SCALE 1" = 20'



EROSION CONTROL PLAN  
SCALE 1" = 20'

**GRADING NOTES**

1. PREPARE EROSION CONTROL AS NECESSARY.
2. REMOVE TOPSOIL FROM AREAS TO BE FURTHER EXCAVATED OR AREAS TO RECEIVE PAVEMENT. STOCKPILE FOR LATER REUSE.
3. AREAS WITHIN THE INFLUENCE LINE OF BUILDING FOUNDATIONS, WALLS AND OTHER HARD FEATURES SHALL REQUIRE A 5% PROCTOR DENSITY PER ACTIVE DESIGN. MAINTAIN MOISTURE WITHIN 5% OF OPTIMAL MOISTURE CONTENT.
4. SLOPE GRADIENTS SHALL BE PROPOSED AS MUCH AS POSSIBLE TO BE ABOVE OPTIMAL MOISTURE CONTENT.
5. TRANSDUCERS SHALL BE PROVIDED FOR BUILDING TO BE PROTECTED. SMOOTH CORNERS WITH RADIUS.
6. SLOPES 3:1 OR GREATER SHALL BE SEEDED AND COVERED WITH MULCH. EROSION CONTROL BARRIERS OR OTHER METHOD APPROVED BY ENGINEER.
7. BEFORE PLACING ANY FILL, THE SITE SHALL BE STRIPPED AND SCATTERED TO A DEPTH OF SIX INCHES AND RECONSTRUCTED TO ORIGINAL NOTED ELEVATION. IF REQUIRING CONSTRUCTION CANNOT BE ACCOMPLISHED, REMOVE OR MATERIAL MAY BE REQUIRED.
8. REMOVE SOFT AREAS OF SUBGRADE INADVAILABLE OF CONSTRUCTION IN PLACE AND BACKFILL WITH STRATIFIED ON-SITE OR OFF-SITE SURFACE QUARRY FILL MATERIAL. SHALL BE PACKED IN LIFTS AND COMPACTED TO AT LEAST 95% OF MAXIMUM STANDARD PROCTOR DRY DENSITY PER ASTM D 1557-2 TO 2% ABOVE OPTIMUM MOISTURE.
9. PROVIDE A UNIFORM SUBGRADE OF 8" DEPTH BENEATH GRANULAR BASE.
10. EXISTING FOUNDATION PERMANENTLY BEYOND EDGE OF PAVEMENT WHERE NOT ADJUTING BUILDING, SIDEWALK, OR EXISTING EXCAVATION OR SUBGRADE.
11. COMPACTED GRANULAR BASE.
12. SUBGRADE CONDITIONS ARE DETAILED UNACCEPTABLE. CONTRACTOR SHALL REMOVE UNSTABLE MATERIAL AND REPLACE WITH COMPACTED GRANULAR STONE. CALL FOR SUBGRADE STABILIZATION OVER ENGINEERING FAVORIT FOOT PRINTS. PROVIDE MINIMUM 12" OF GRANULAR STONE. CALL FOR SUBGRADE STABILIZATION OVER ENGINEERING FAVORIT FOOT PRINTS. PROVIDE MINIMUM 12" OF GRANULAR STONE. CALL FOR SUBGRADE STABILIZATION OVER ENGINEERING FAVORIT FOOT PRINTS. PROVIDE MINIMUM 12" OF GRANULAR STONE.
13. CONSTRUCT GRANULAR BASE USING CRUSHED STONE OR GRAVEL, COME WITH DOT SECTION 104. GRANULAR CALL FOR SUBGRADE STABILIZATION OVER ENGINEERING FAVORIT FOOT PRINTS. PROVIDE MINIMUM 12" OF GRANULAR STONE.
14. EXISTING GRANULAR BASE 8" BEYOND EDGE OF PAVEMENT WHERE NOT ADJUTING BUILDING, SIDEWALK, OR EXISTING EXCAVATION OR SUBGRADE.
15. ABOVE OPTIMUM MOISTURE CONTENT OF FILL MATERIALS. COMPACT TO 95% DRY DENSITY. MODIFIED STANDARD PROCTOR. 90% E. ENSURE THAT TOP 1" OF SUBGRADE IS UNIFORMLY MOIST PRIOR TO PLACING.
16. DO NOT ALLOW HAULING EQUIPMENT AND OTHER TRAFFIC ON COMPLETED SUBGRADE.
17. TOPSOIL.
18. SPRING MINIMUM OF 6" OF TOPSOIL OVER ENTIRE PORTION OF SITE TO BE SEEDED.
19. SEEDING SHALL BE WITHIN 10 DAYS, ROCKS LARGER THAN 6", SOIL CLUMPS LARGER THAN 1", AND BE LEFT SMOOTH PREPARED FOR TOPSOIL AND SEEDING.

**EROSION AND SEDIMENT CONTROL NOTES**

1. ANY OTHER GENERAL PERMIT LETTERS CONSTRUCTION ACTIVITIES IS REQUIRED FOR THIS PROJECT. IT IS THE RESPONSIBILITY OF THE CONTRACTOR TO OBTAIN ALL NECESSARY PERMITS AND TO KEEP THEM ON SITE AT ALL TIMES. A SWPPP BRIEFER WILL BE PROVIDED AND COPY SHALL BE KEPT ON SITE AT ALL TIMES.
2. SEE EROSION CONTROL PLAN FOR EROSION AND SEDIMENT CONTROL REQUIREMENTS.
3. CONTRACTOR SHALL ADHERE TO ALL CITY OF COAL VALLEY EROSION AND SEDIMENT CONTROL REGULATIONS, ILLINOIS URBAN MANUAL, AND ALL EPA RULES AND REGULATIONS.
4. EROSION CONTROL SHALL BE INSTALLED PRIOR TO ANY EARTH MOVING OPERATIONS FOR AS SOON AS PRACTICAL. IT IS THE RESPONSIBILITY OF THE CONTRACTOR TO MAINTAIN EROSION CONTROL MEASURES THROUGHOUT CONSTRUCTION. TRAPS, CHECK DAMS, DIVERSION SWALES, ETC. AS REQUIRED UNTIL VEGETATION IS ESTABLISHED.
5. LOCATION OF EROSION AND SEDIMENT CONTROL DEVICES ON PLANS IS APPROXIMATE. ACTUAL PLACEMENT TO BE DETERMINED BY CONTRACTOR AND DOCUMENTED AS NECESSARY DURING PROGRESS OF CONSTRUCTION.
6. CONTRACTOR SHALL PREVENT OFF-SITE TRACKING OF SEDIMENT. ANY SEDIMENT DEPOSITED ON PUBLIC ROADWAYS SHALL BE REMOVED IMMEDIATELY.
7. ALL DISTURBED AREAS SHALL BE COVERED WITH TOP SOIL, FINE GRADED, SEEDS, AND FERTILIZER. AREAS SHALL BE COVERED WITH EROSION CONTROL BARRIERS, FLEXIBLE GROWN MEDIA, OR OTHER METHOD APPROVED BY ENGINEER.
8. IF NO ACTIVE OCCURS ON IS ANTICIPATED FOR 14 DAYS, THE AREA SHALL BE STABILIZED WITHIN 7 DAYS OF LAST ACTIVITY WITH TEMPORARY SEED COVERED BY MULCH OR EROSION CONTROL BARRIERS.
9. PRIOR TO SUBMITTING A NOTICE OF TERMINATION, A VEGETATIVE DENSITY OF 70% MUST BE ACHIEVED OVER THE ENTIRE SITE.

no.	date	revision

Engineering consultants  
 5137 Ulica Highway  
 Danvers, IA 52807  
 www.rtm.com

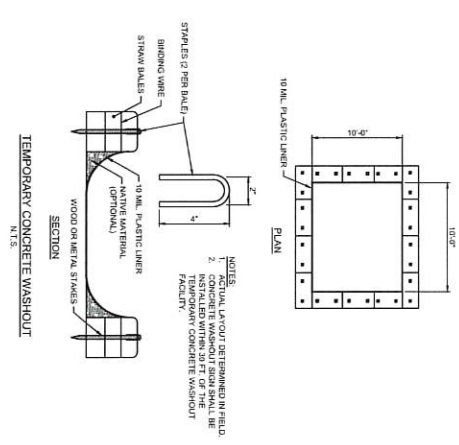
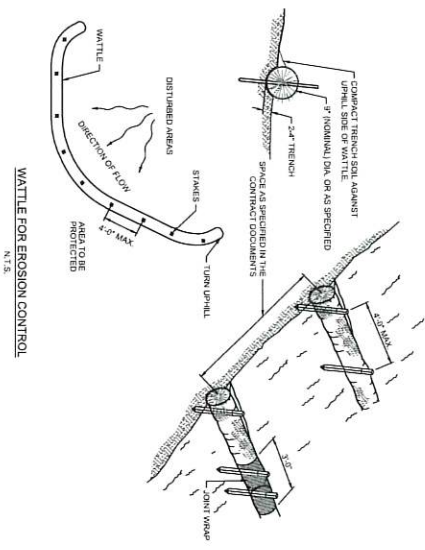
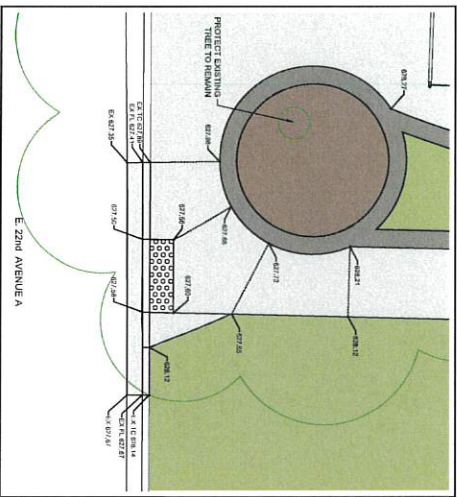
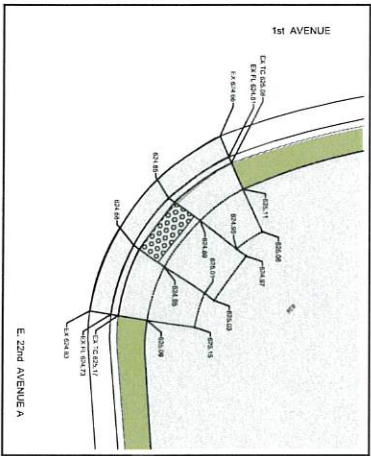
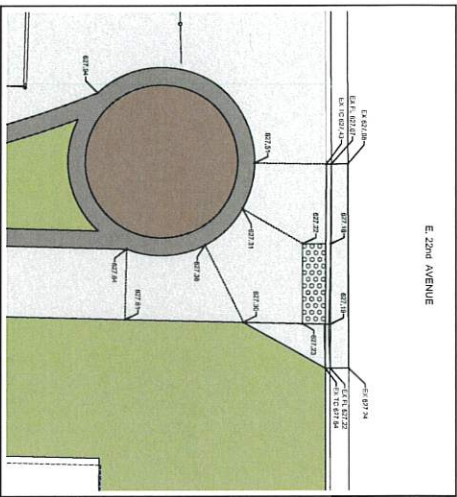
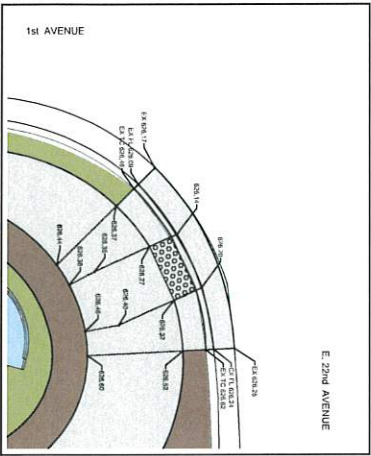
21 SIA, C10  
 Prepared by: [Name]  
 Checked by: [Name]  
 Date: 26.03.2022


POST OFFICE PARK  
 COAL VALLEY, IL  
 STREAMLINE ARCHITECTS

GRADING &  
 EROSION CTRL  
 PLAN

C-3






**Engineering consultants**  
 5137 ulica riggs road  
 davenport, ia 52807  
 www.rtm.com

no.	date	revision

POST OFFICE PARK  
 COAL VALLEY, IL  
 STREAMLINE ARCHITECTS

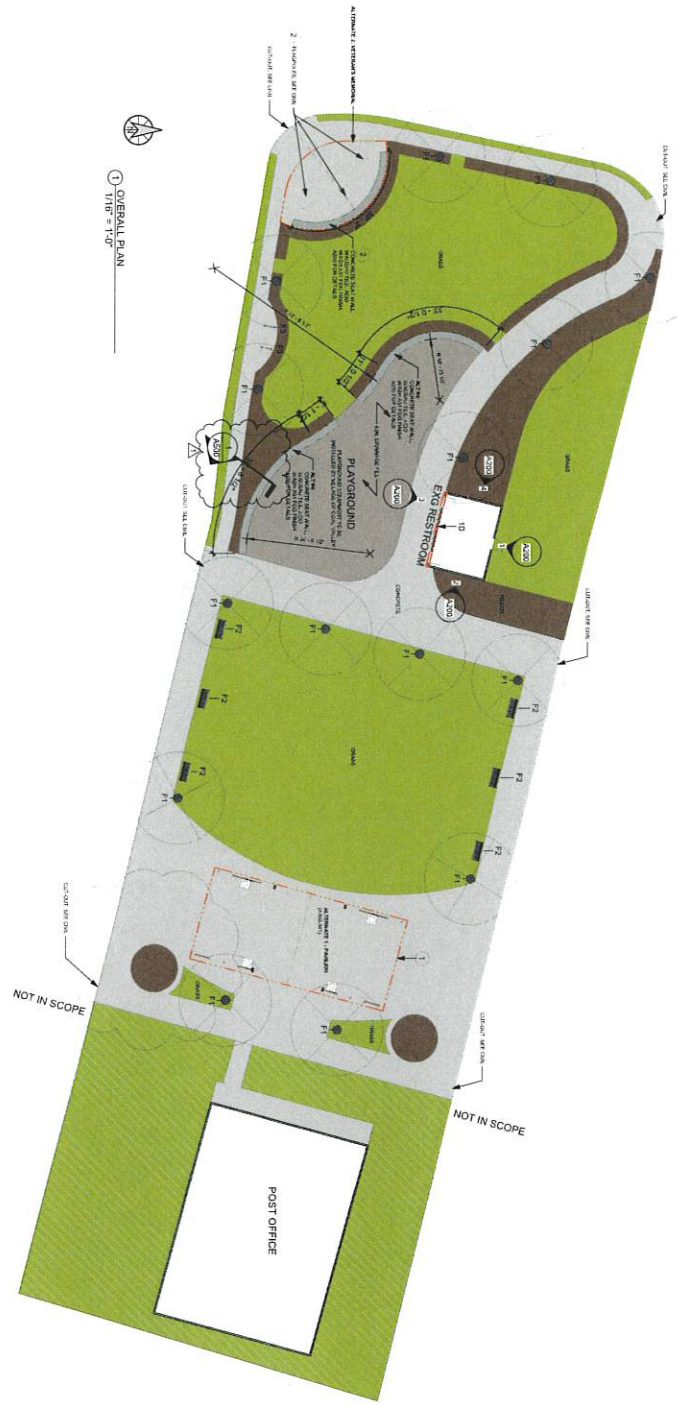
100 project no. 2133A.LTG  
 prepared by: jlm  
 checked by: jlm  
 date: 06.03.2002

**GRADING & EROSION CTRL. DETAILS**  
 C-4

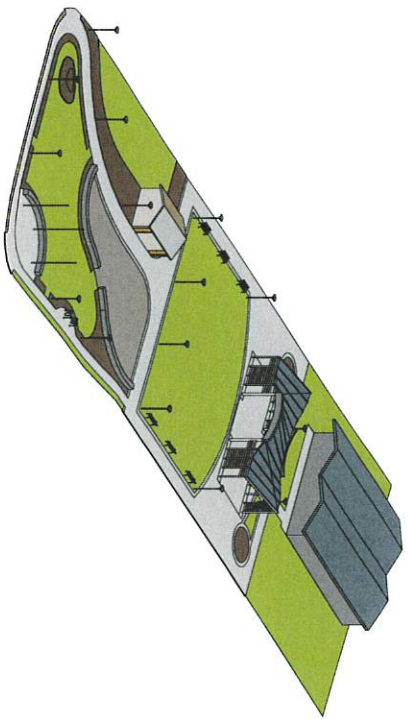


**FLOOR PLAN GENERAL NOTES**

1. ALL WORK SHALL BE COMPLIANT WITH THE AUTHORITY HAVING JURISDICTION OVER THE PROJECT.
2. MECHANICAL CONTRACTOR TO VERIFY ALL COMPLIANCE WITH ALL APPLICABLE CODES.
3. ELECTRICAL SYSTEMS ARE INSTALLED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE (NEC) AND ALL APPLICABLE LOCAL CODES.
4. ALL LIGHTING DESIGN BY ELECTRICAL CONTRACTOR.
5. PLUMBING CONTRACTOR TO VERIFY THAT ALL PLUMBING SHALL COMPLY WITH APPLICABLE LOCAL AND STATE CODES AND ALL APPLICABLE CODES.
6. PLUMBING CONTRACTOR TO VERIFY THAT ALL PLUMBING SHALL COMPLY WITH APPLICABLE LOCAL AND STATE CODES AND ALL APPLICABLE CODES.
7. PLUMBING CONTRACTOR TO VERIFY THAT ALL PLUMBING SHALL COMPLY WITH APPLICABLE LOCAL AND STATE CODES AND ALL APPLICABLE CODES.
8. COMPLIANCE WITH ALL APPLICABLE CODES. ALL FIRE PROTECTION SYSTEMS ARE INSTALLED IN ACCORDANCE WITH THE NATIONAL FIRE PROTECTION ASSOCIATION (NFPA) AND ALL APPLICABLE LOCAL AND STATE CODES.
9. ALL WORK SHALL BE INSTALLED IN ACCORDANCE WITH ALL APPLICABLE CODES AND ALL APPLICABLE LOCAL AND STATE CODES.



1 OVERALL PLAN  
1/10 - 1/19



ALTERNATES LEGEND	
ALT	DESCRIPTION
BASE	BASE BID TO INCLUDE MECHANICAL, ELECTRICAL, AND CONCRETE AWAY FROM VETERANS AREA
14	PAVEMENT W/ ROOF OPT 1 (SEE A311)
15	PAVEMENT W/ ROOF OPT 2 (SEE A311)
16	PAVEMENT W/ ROOF OPT 3 (SEE A311)
17	VETERANS AREA NOT INCLUDING MONUMENT (SEE A311)
18	FURNITURE AND LIGHTING OPT 2 (SEE A301)
19	FURNITURE AND LIGHTING OPT 3 (SEE A301)
20	CONCRETE SEAT WALL AT PLAYGROUND

NO.	DESCRIPTION	DATE
1	ADDITIONAL 1	03-07-2023

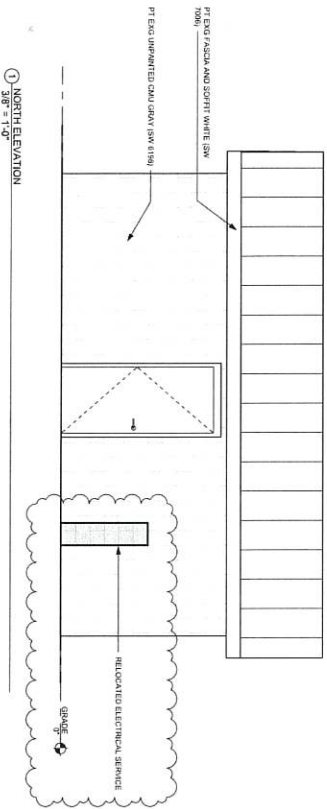
VILLAGE OF COAL VALLEY  
**POST OFFICE PARK**  
 121 E 22nd Ave  
 Coal Valley, IL

A101

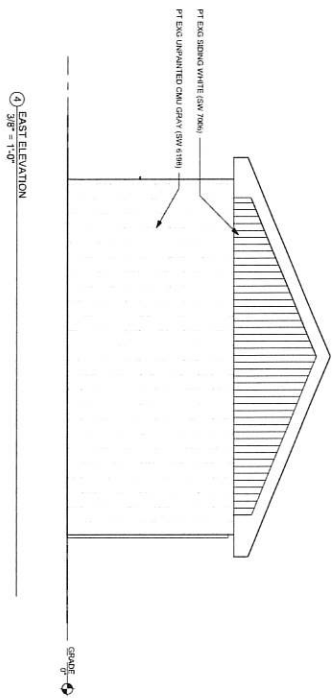


streamline  
 ARCHITECTS  
 www.streamlinearchitects.com  
 STREAMLINE ARCHITECTS, P.L.L.C.  
 ANDREW DUNSON, AIA  
 575 17TH AVENUE  
 EAST MOBILE, IL 61244  
 (889) 345-2724  
 NOAH STRAUSSER  
 noah@streamlinearchitects.com

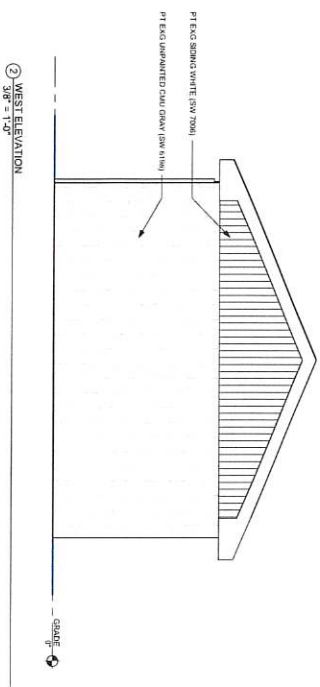




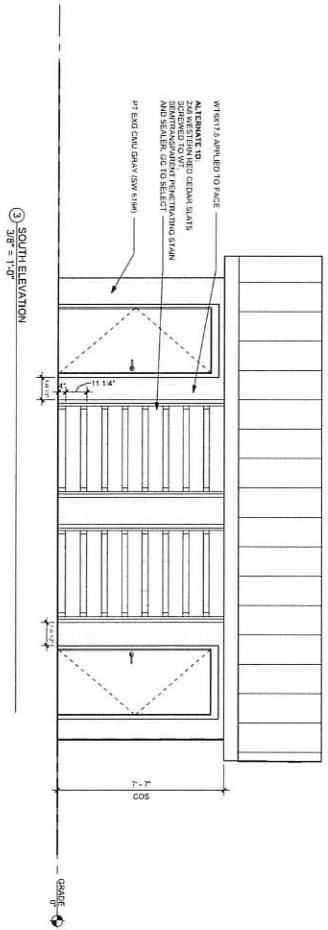
1 NORTH ELEVATION  
3/8" = 1'-0"



4 EAST ELEVATION  
3/8" = 1'-0"



2 WEST ELEVATION  
3/8" = 1'-0"



3 SOUTH ELEVATION  
3/8" = 1'-0"



www.streamlinearchitects.com  
**streamline**  
 ARCHITECTS  
 STREAMLINE ARCHITECTS, P.L.C.  
 ANDREW DASSO, AIA  
 575 12TH AVENUE  
 EAST MOUNTAIN, IL 61824  
 (630) 345-9241  
 NOAH STRAUSSER  
 noah@streamlinearchitects.com

NO.	DESCRIPTION	DATE
1	ADDITIONAL 1	03/21/2022

VILLAGE OF COAL VALLEY  
**POST OFFICE PARK**

121 E 22nd Ave  
 Coal Valley, IL

Project Number: 21-130  
 Date: 01/25/22  
 Drawn By: CS  
 Checked By: CS  
**RESTROOM**

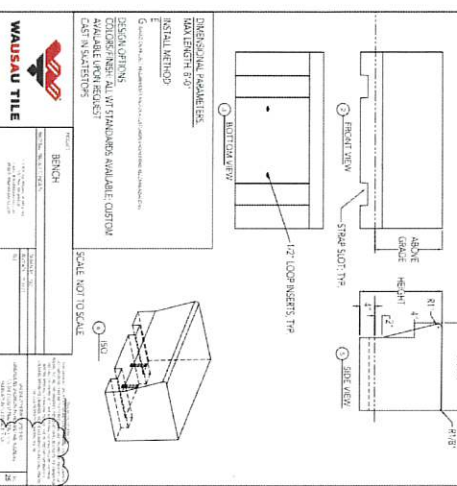
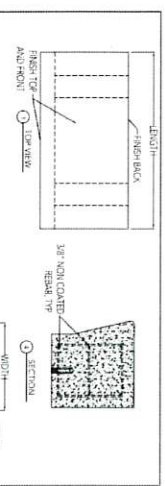
A200



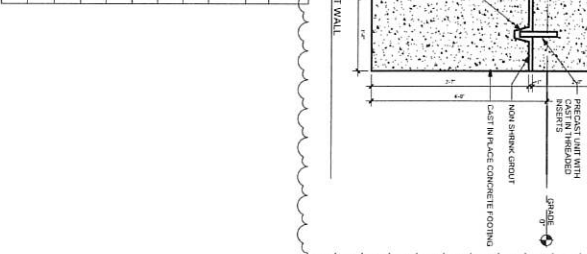








ALT	TAG	MANUFACTURER	MODEL	DESCRIPTION	COUNT*
3A	F1	FORMASURFACES	UPHOLSTERED LIGHTING INCLUDES CHAIRS	W/ LIGHTING	15
	F2	FORMASURFACES	SECTORIAL CORNER BENCH, FREE-STANDING	W/ LIGHTING	6
	F3	DEBO	ROUND BENCH, SURFACE MOUNTED	W/ LIGHTING	2
3B	F1	AMF LIGHTING	ALUMINUM LIGHT COLUMN	W/ LIGHTING	15
	F2	WESTONE BENCH DESIGNS	ENTER BENCH W/ BACK	W/ LIGHTING	6
	F3	WESTONE BENCH DESIGNS	ENTER BENCH W/ BACK	W/ LIGHTING	1
3C	F1	NA	CONCRETE BENCH WITH LIGHTING	W/ LIGHTING	15
	F2	NA	CONCRETE BENCH WITH LIGHTING	W/ LIGHTING	6
	F3	NA	CONCRETE BENCH WITH LIGHTING	W/ LIGHTING	1



ITEM	DESCRIPTION	QUANTITY	UNIT	PRICE	TOTAL
1	CONCRETE SEAT WALL	15	LINEAR FEET	120.00	1800.00
2	CONCRETE SEAT WALL	6	LINEAR FEET	120.00	720.00
3	CONCRETE SEAT WALL	1	LINEAR FEET	120.00	120.00

ITEM	DESCRIPTION	QUANTITY	UNIT	PRICE	TOTAL
1	CONCRETE SEAT WALL	15	LINEAR FEET	120.00	1800.00
2	CONCRETE SEAT WALL	6	LINEAR FEET	120.00	720.00
3	CONCRETE SEAT WALL	1	LINEAR FEET	120.00	120.00

ITEM	DESCRIPTION	QUANTITY	UNIT	PRICE	TOTAL
1	CONCRETE SEAT WALL	15	LINEAR FEET	120.00	1800.00
2	CONCRETE SEAT WALL	6	LINEAR FEET	120.00	720.00
3	CONCRETE SEAT WALL	1	LINEAR FEET	120.00	120.00

ITEM	DESCRIPTION	QUANTITY	UNIT	PRICE	TOTAL
1	CONCRETE SEAT WALL	15	LINEAR FEET	120.00	1800.00
2	CONCRETE SEAT WALL	6	LINEAR FEET	120.00	720.00
3	CONCRETE SEAT WALL	1	LINEAR FEET	120.00	120.00

ITEM	DESCRIPTION	QUANTITY	UNIT	PRICE	TOTAL
1	CONCRETE SEAT WALL	15	LINEAR FEET	120.00	1800.00
2	CONCRETE SEAT WALL	6	LINEAR FEET	120.00	720.00
3	CONCRETE SEAT WALL	1	LINEAR FEET	120.00	120.00

ITEM	DESCRIPTION	QUANTITY	UNIT	PRICE	TOTAL
1	CONCRETE SEAT WALL	15	LINEAR FEET	120.00	1800.00
2	CONCRETE SEAT WALL	6	LINEAR FEET	120.00	720.00
3	CONCRETE SEAT WALL	1	LINEAR FEET	120.00	120.00

**streamline**  
ARCHITECTS

www.streamlinearchitects.com

STREAMLINE ARCHITECTS, P.L.C.  
575 12TH AVENUE  
ANDREW DAVISSO, AIA  
(659) 385-5724 FL 01164

MICHAEL STRAUSSER  
(659) 328-8600  
mstr@streamlinearchitects.com

NO	DESCRIPTION	DATE
1 <td>CONTRACT</td> <td>02/15/2023</td>	CONTRACT	02/15/2023

VILLAGE OF COAL VALLEY  
POST OFFICE PARK

121 E 22nd Ave  
Coal Valley, IL

Project Number: 21-130  
Date: 01/25/23  
Drawn by: NS  
Checked by: CS

FURNITURE AND LIGHTING

A500

























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?
  - a. 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 [andrew@streamlinearchitects.com](mailto:andrew@streamlinearchitects.com), and cc [noah@streamlinearchitects.com](mailto:noah@streamlinearchitects.com).
2. Bid Date is revised to March 10th, 2023 at 1pm.

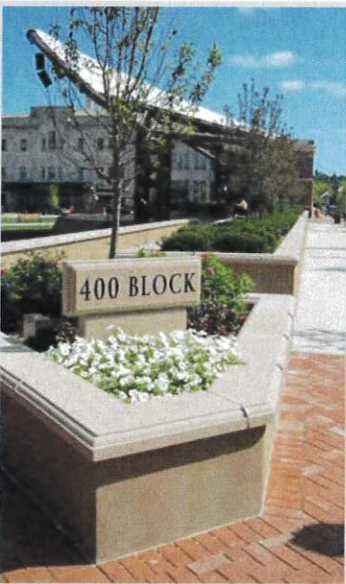




WAUSAU TILE

# 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

## SPECIFICATIONS

WAUSAU TILE PRECAST CONCRETE SPECIFICATION.....	1-5
---	-----

## DETAILS

### TREADS

#### *FULLY SUPPORTED*

C30	6
C31	7
C36	8
C40	9
C51	10
LANDSCAPE TREAD	11

#### *SELF SUPPORTING*

C60(WELD)	12
C60(BOLT)	13
C70(WELD)	14
C70(BOLT)	15
TEARDROP	16

### POOL COPING

SAFETY EDGE	17
SQUARE EDGE	18
FULL BULLNOSE	19
TYPICAL CORNERS	20

### CURB

RECTANGULAR	21
CHAMFERED	22
TYPICAL CORNERS	23
COLUMN CAP	24
BENCH	25
PLANTER WALL	26

## INSTALL METHODS

FULLY SUPPORTED (TREADS) .....	27
SELF SUPPORTING (TREADS) .....	28
MISC .....	29-30

## DESIGN OPTIONS

ABRASIVE STRIPS	31
MISC	31



## **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%

Updated: Mar2021



3. Water-Cement Ratio .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.

Updated: Mar2021



1. 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.
  3. 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](mailto:info@cbpmail.net) Website: [www.custombuildingproducts.com](http://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.
      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. 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.

Updated: Mar2021

- 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

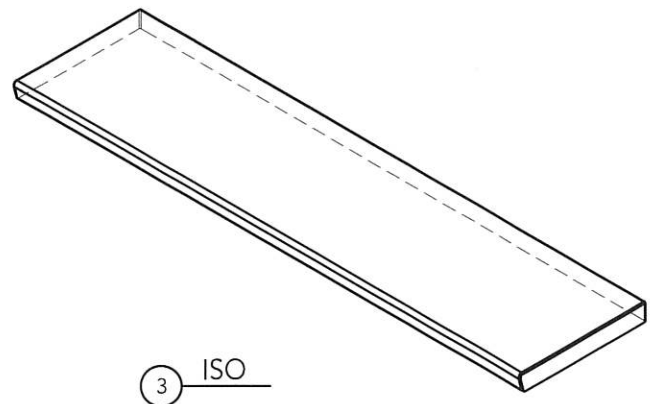
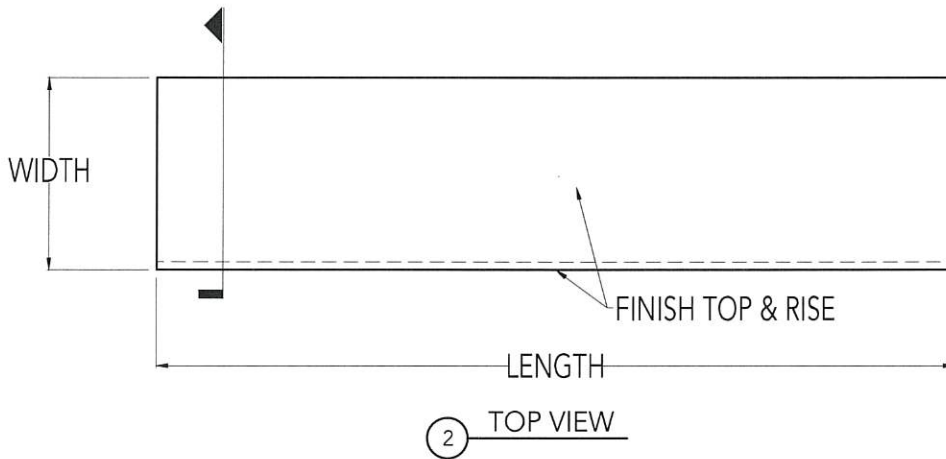
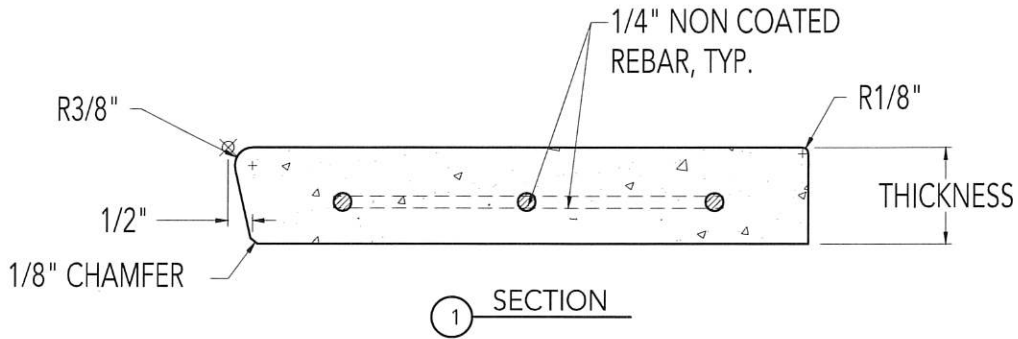
#### A. Cleaning

1. 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.

Updated: Mar2021



- 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
1. Annual maintenance is recommended; however, in cases 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.
    - a. 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" TO 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 AVAILABLE UPON REQUEST

SCALE: NOT TO SCALE



PRODUCT:

C30 FLAT TREAD

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

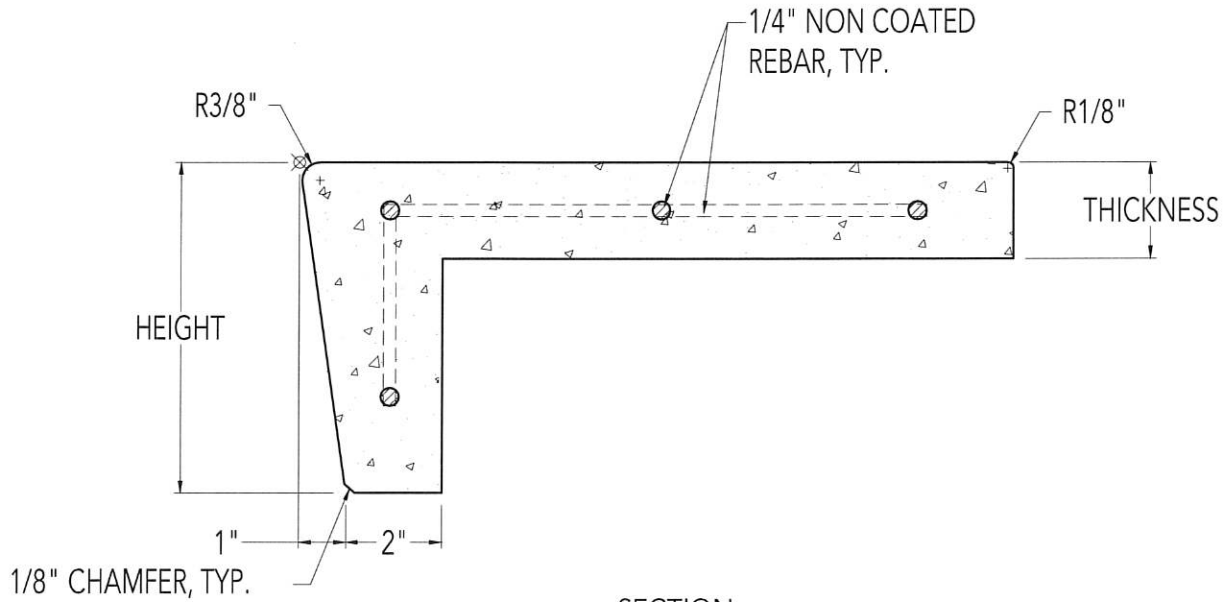
REV DATE: 01.04.21

FILE: -

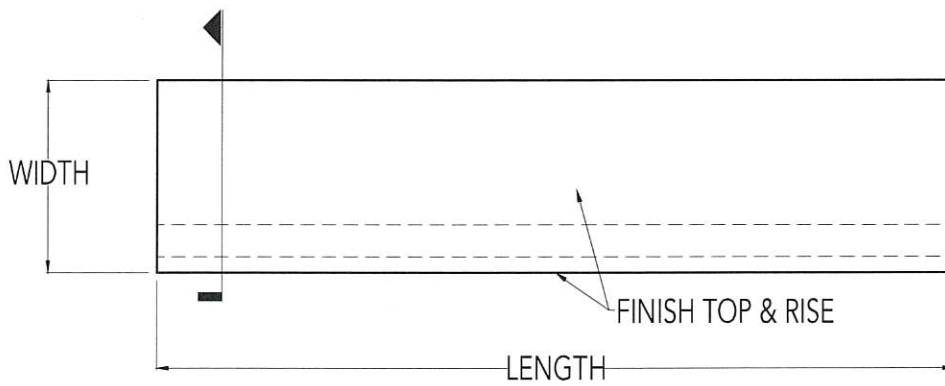
CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"

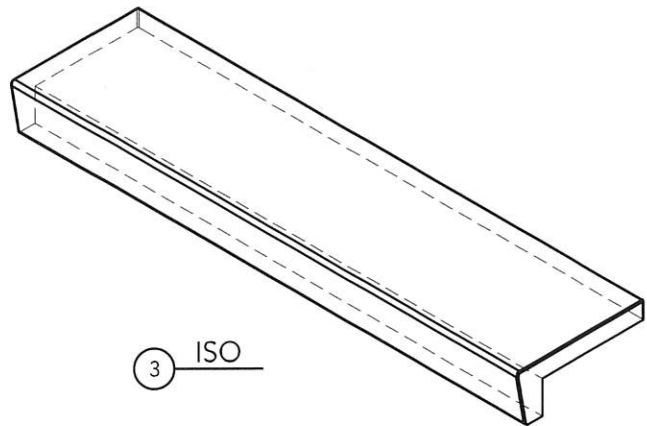




1 SECTION



2 TOP VIEW



3 ISO

SCALE: NOT TO SCALE

**DIMENSIONAL PARAMETERS:**

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

**INSTALL METHOD:**  
 A OR B

**DESIGN OPTIONS:**

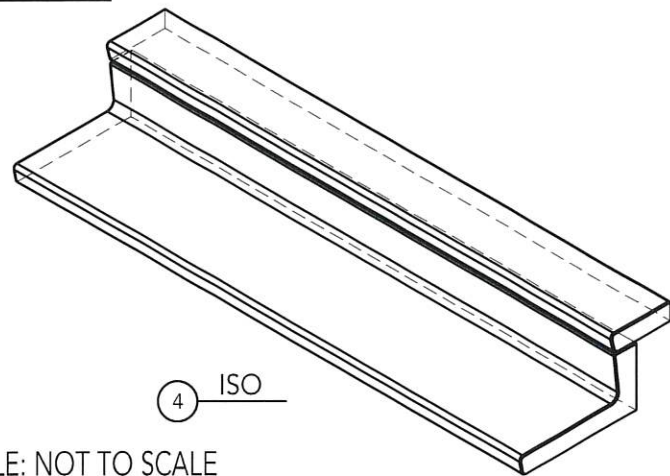
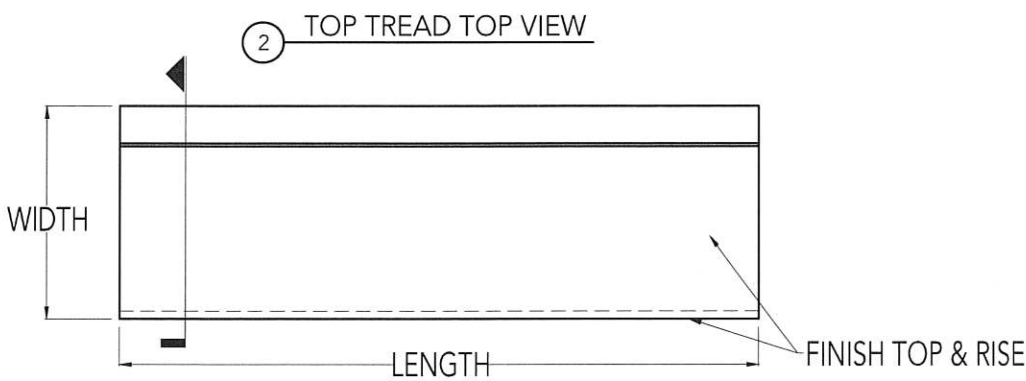
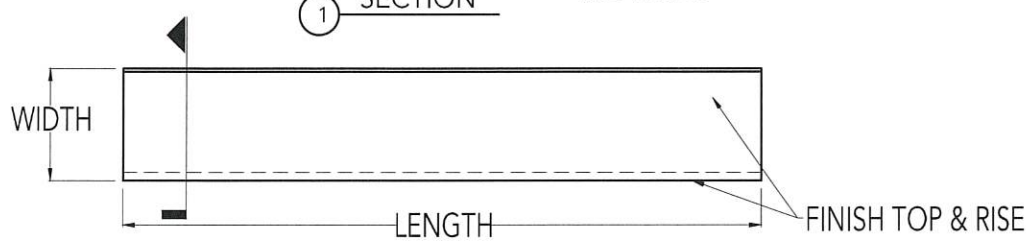
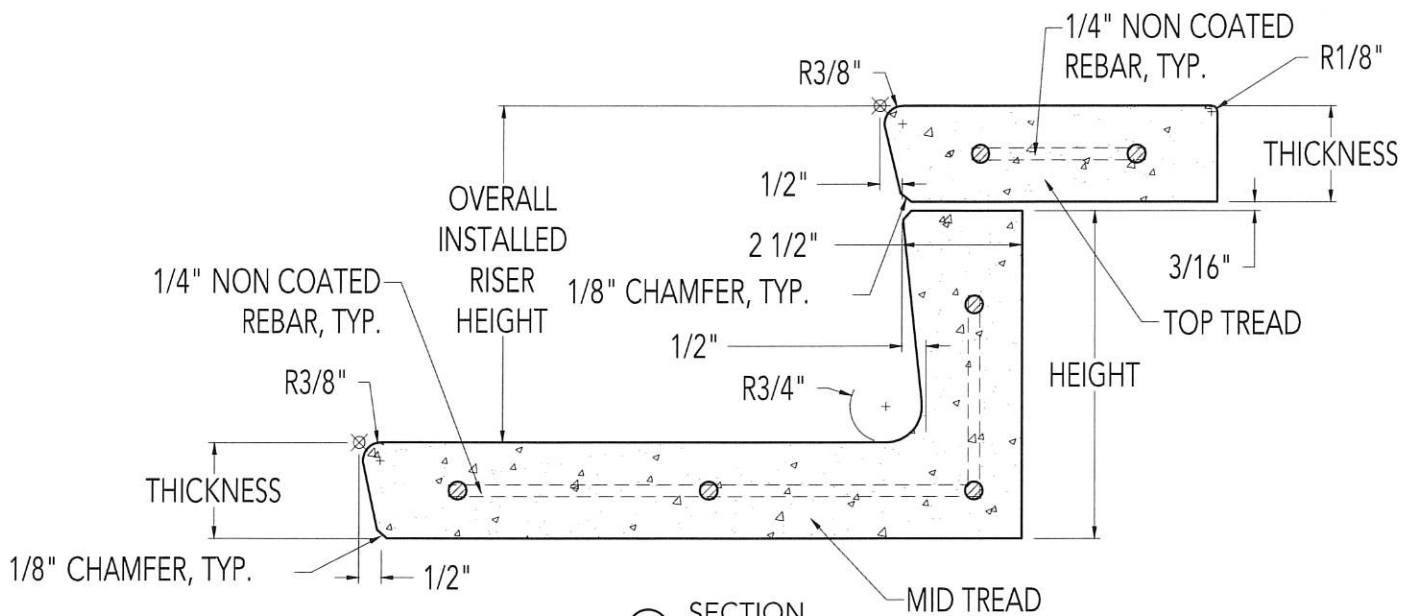
COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST  
 ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST



PRODUCT: <b>C31 TREAD &amp; RISER</b>	
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: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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:**  
 UP TO 6'-0" : 2" MINIMUM THICKNESS  
 6'-0" TO 8'-0" : 2 1/4" MINIMUM THICKNESS  
 MAX LENGTH 8'-0"

**INSTALL METHOD:**  
 A

**DESIGN OPTIONS:**  
 COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST  
 ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST

SCALE: NOT TO SCALE

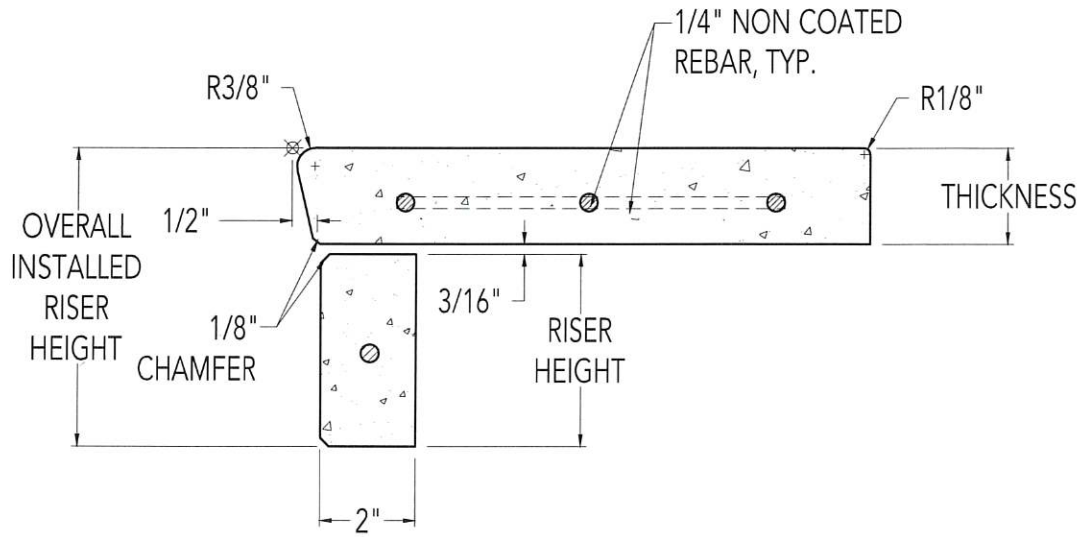


PRODUCT: <b>C36 REVERSE TREAD &amp; RISER</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

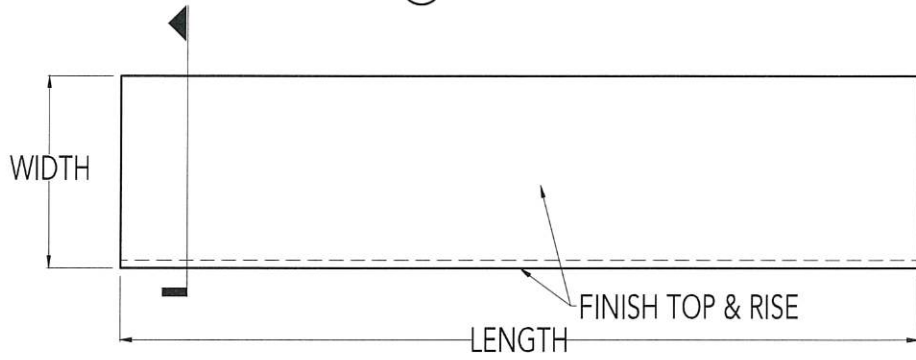
CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"

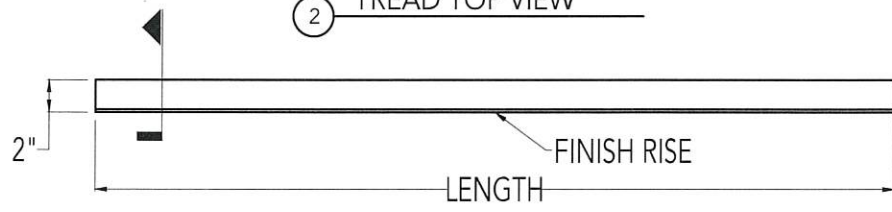




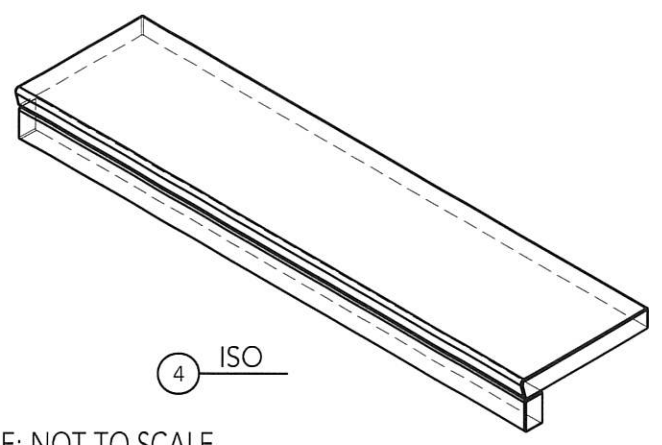
1 SECTION



2 TREAD TOP VIEW



3 RISER TOP VIEW



4 ISO

SCALE: NOT TO SCALE

**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:**  
 A

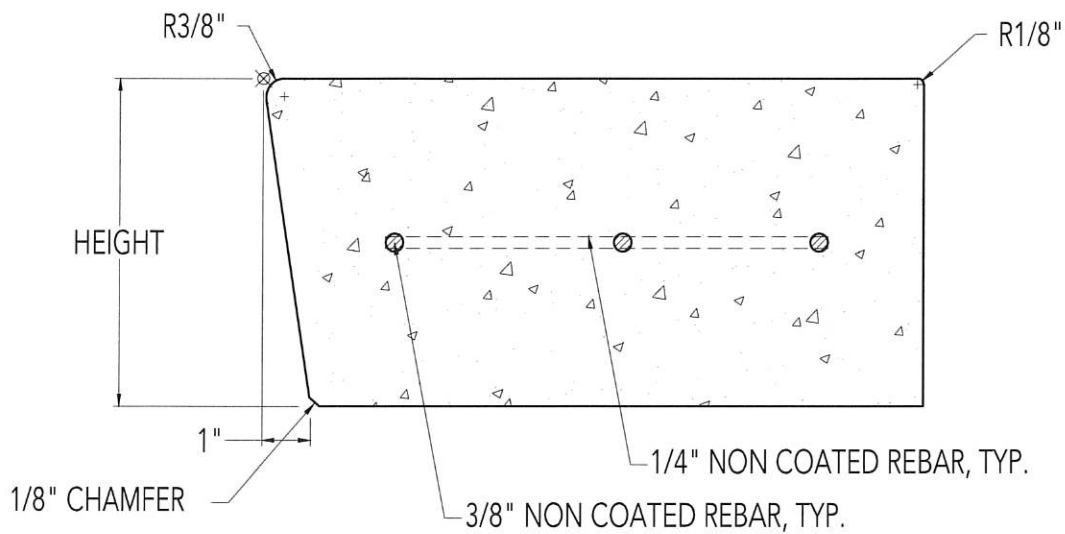
**DESIGN OPTIONS:**  
 COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST  
 ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST



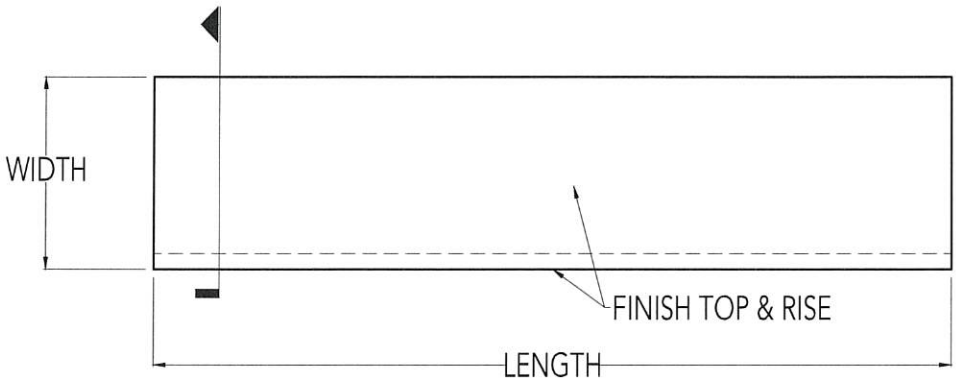
PRODUCT: <b>C40 SEPARATE TREAD &amp; RISER</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN THE SOLE PROPERTY OF WAUSAU TILE, INC.

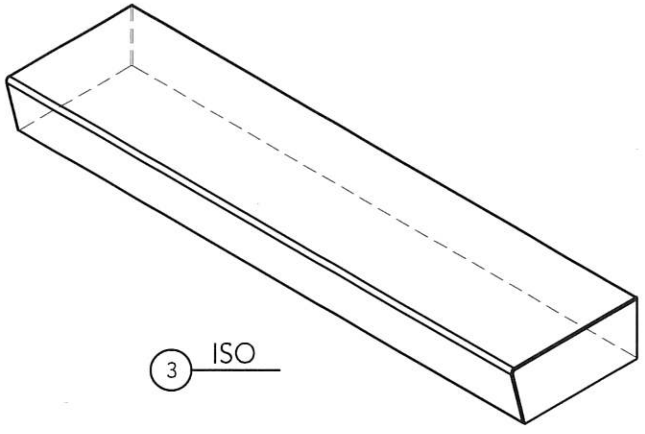
UNLESS OTHERWISE SPECIFIED  
 DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED  
 TO THE CLOSEST FRACTION + 1/16"  
 FABRICATION TOLERANCE: ± 1/8"



1 SECTION



2 TOP VIEW



3 ISO

**DIMENSIONAL PARAMETERS:**  
 MAX LENGTH 8'-0"

**INSTALL METHOD:**  
 A

**DESIGN OPTIONS:**  
 COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST  
 ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST

SCALE: NOT TO SCALE



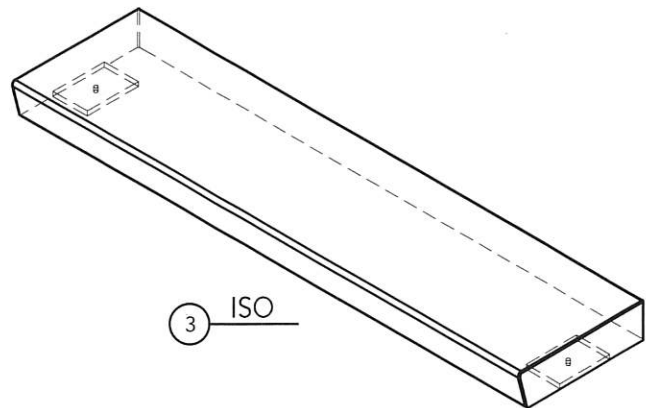
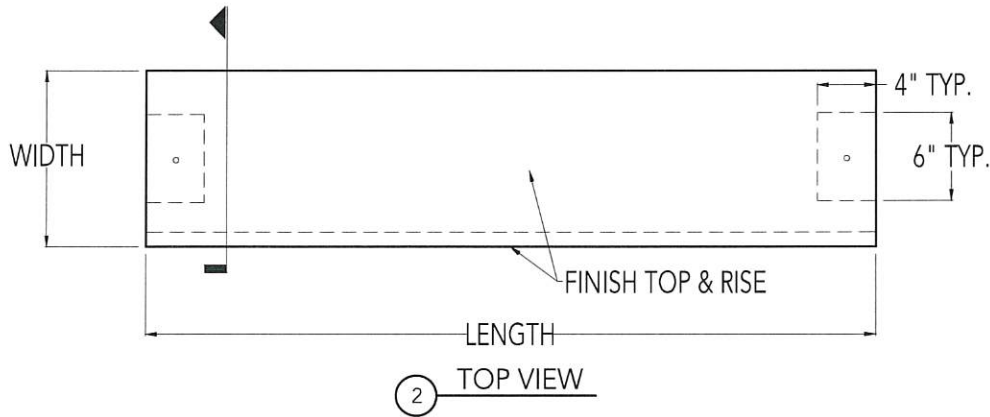
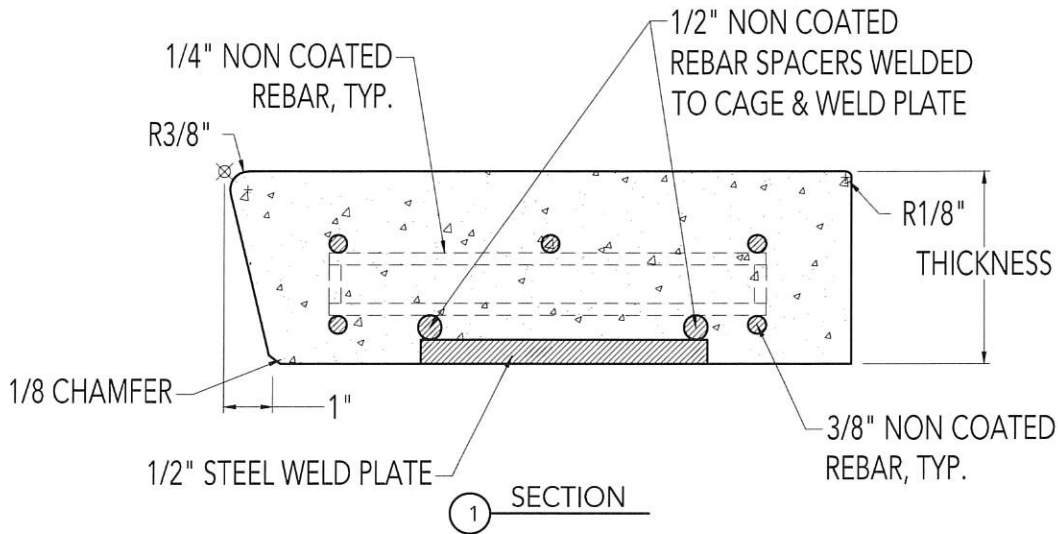
PRODUCT: <b>C51 BLOCK TREAD</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"

PG 10





**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:**

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:

**C60 SELF SUPPORTING FLAT TREAD (WELD)**

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

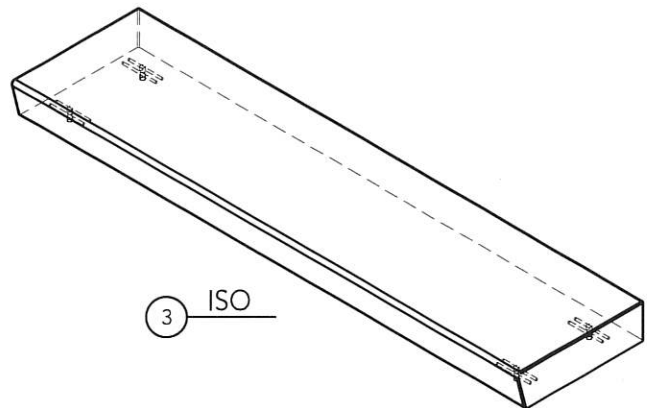
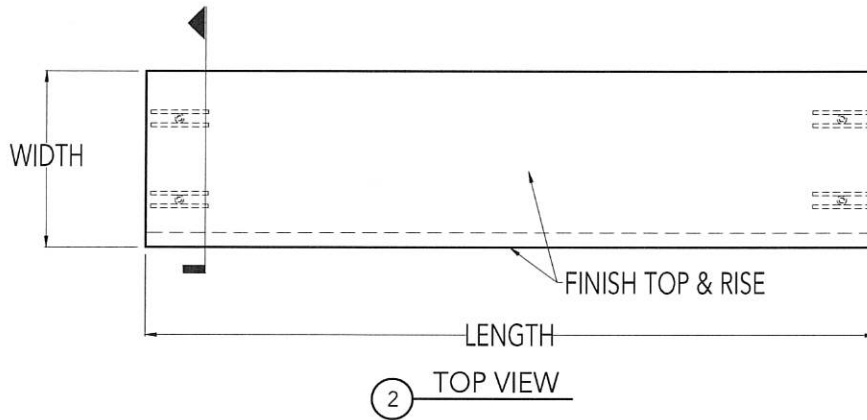
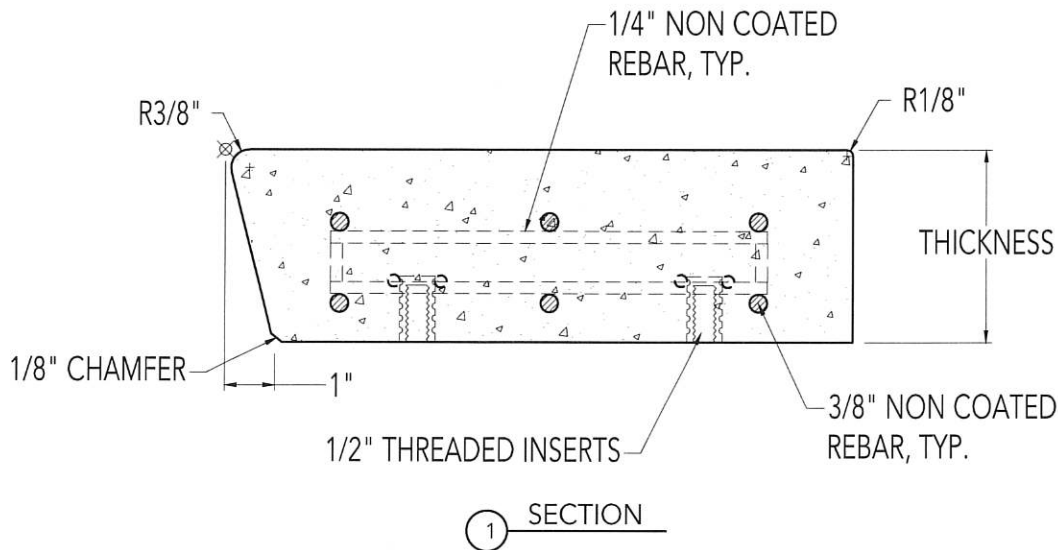
DRAWN BY: SKD

REV DATE: 01.04.21

FILE: -

CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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:**

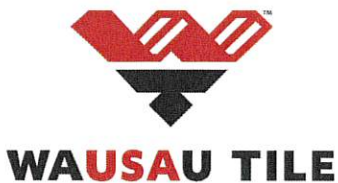
UP TO 6'-0" : 4" MINIMUM THICKNESS  
 6'-0" TO 8'-0" : 5" MINIMUM THICKNESS  
 MAX LENGTH 8'-0"

**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

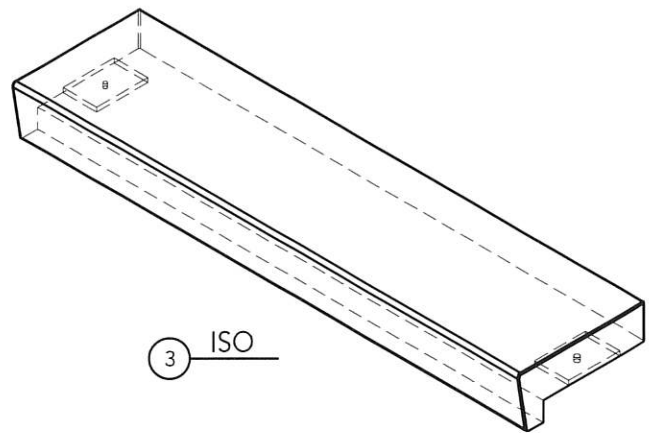
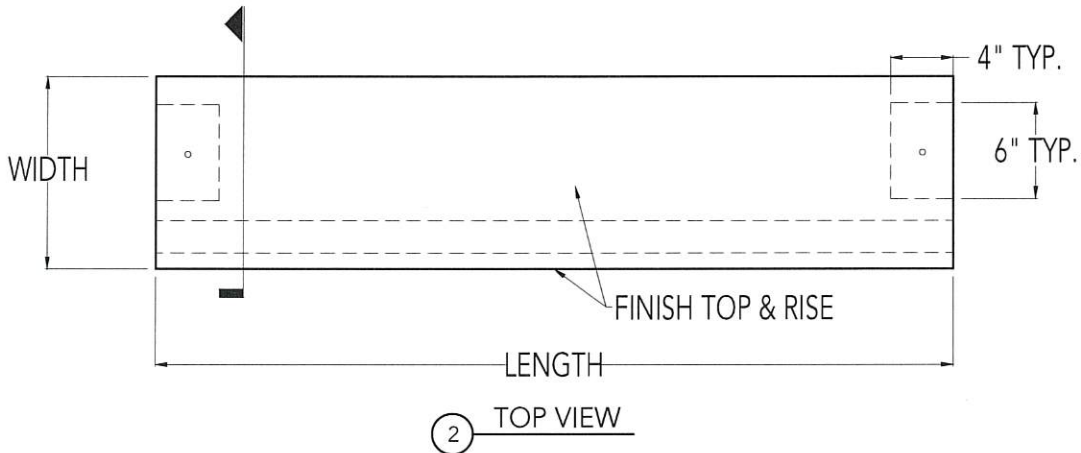
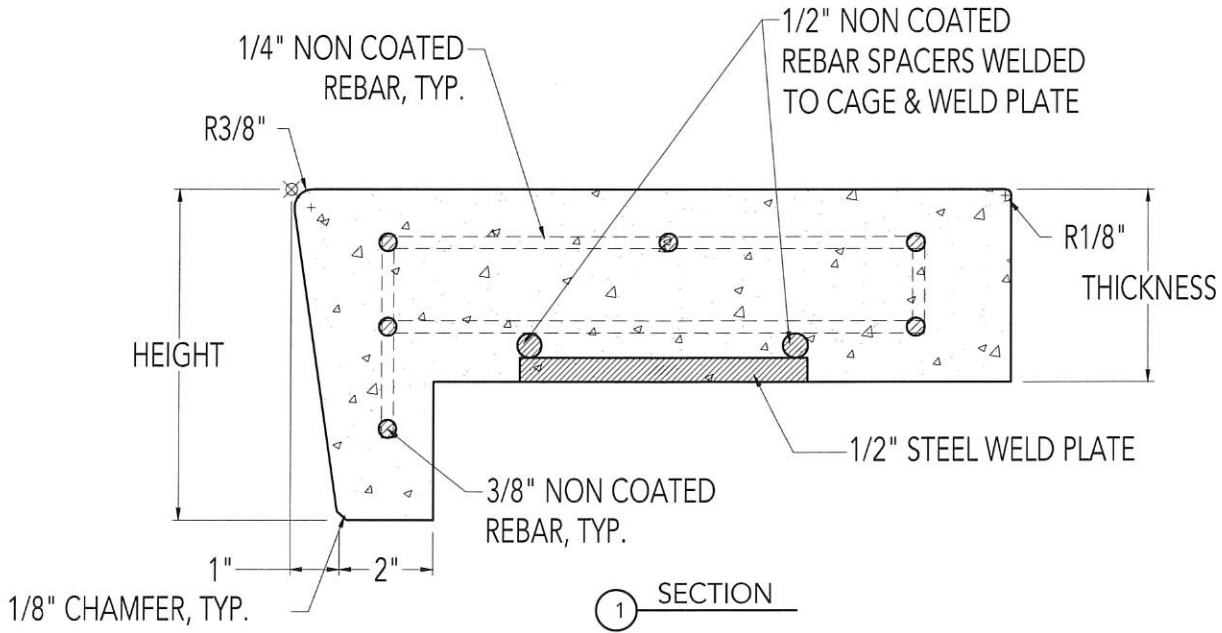


PRODUCT: <b>C60 SELF SUPPORTING FLAT TREAD (BOLT)</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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:**

4" MINIMUM THICKNESS

MAX LENGTH 8'-0"

**INSTALL METHOD:**

D (PREFERRED)

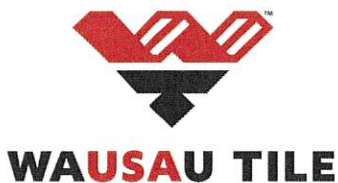
**DESIGN OPTIONS:**

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 (WELD)**

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

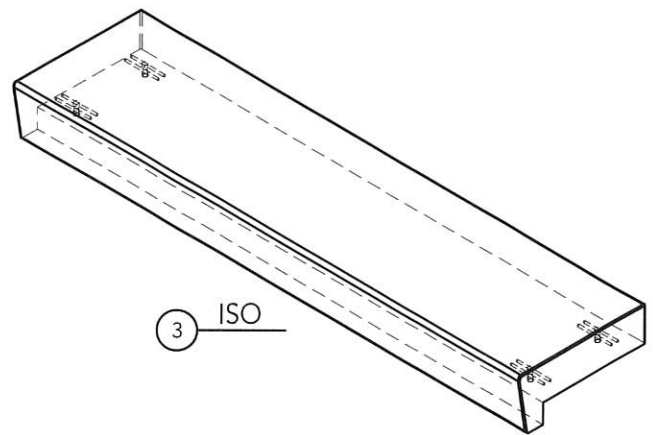
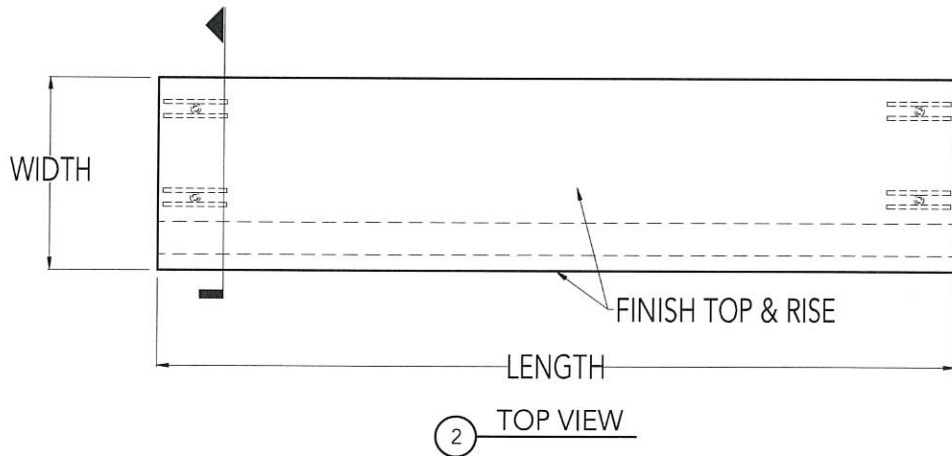
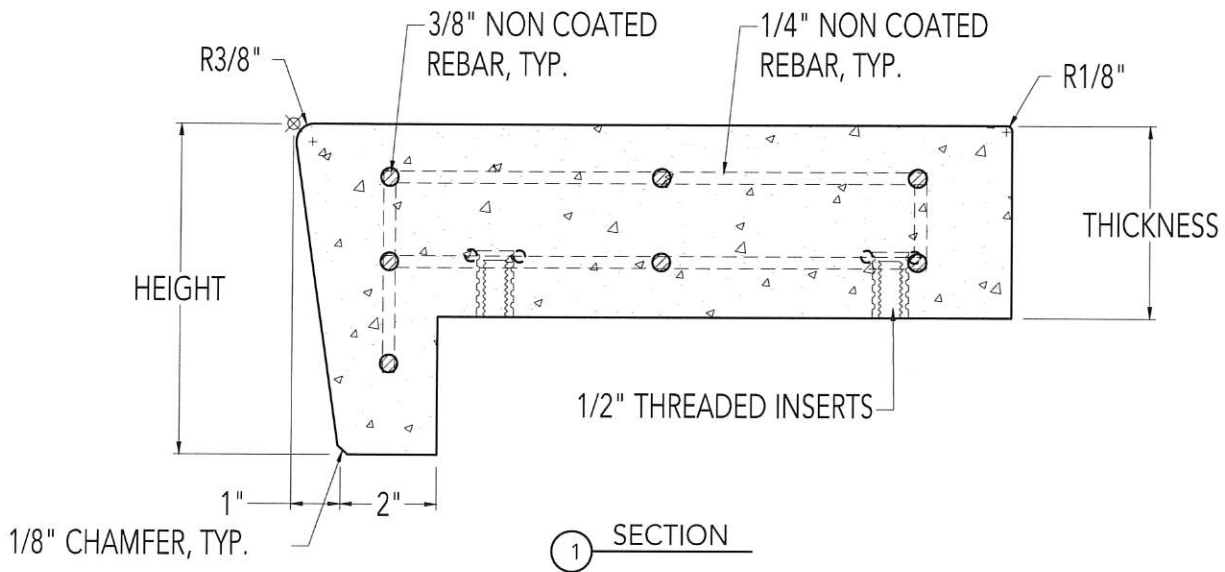
DRAWN BY: SKD

REV DATE: 01.04.21

FILE: -

**CONFIDENTIAL INFORMATION**  
THESE DRAWINGS, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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:**

4" MINIMUM THICKNESS

MAX LENGTH 8'-0"

**INSTALL METHOD:**

C

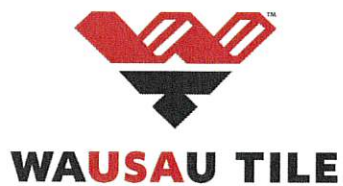
**DESIGN OPTIONS:**

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

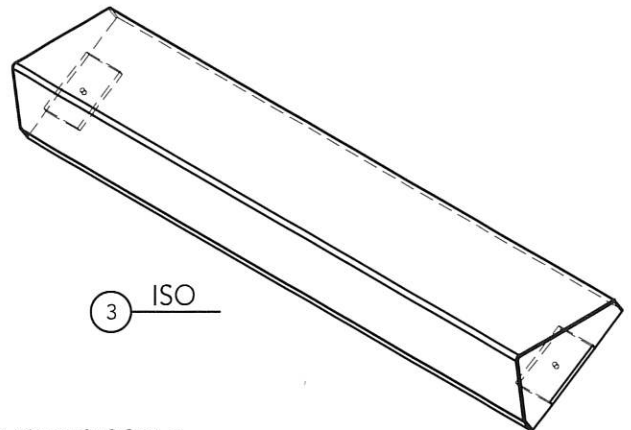
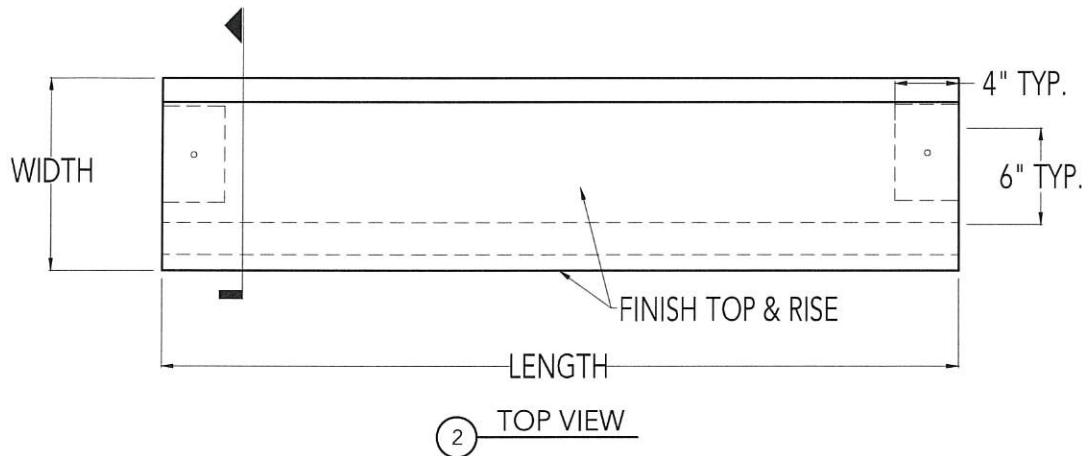
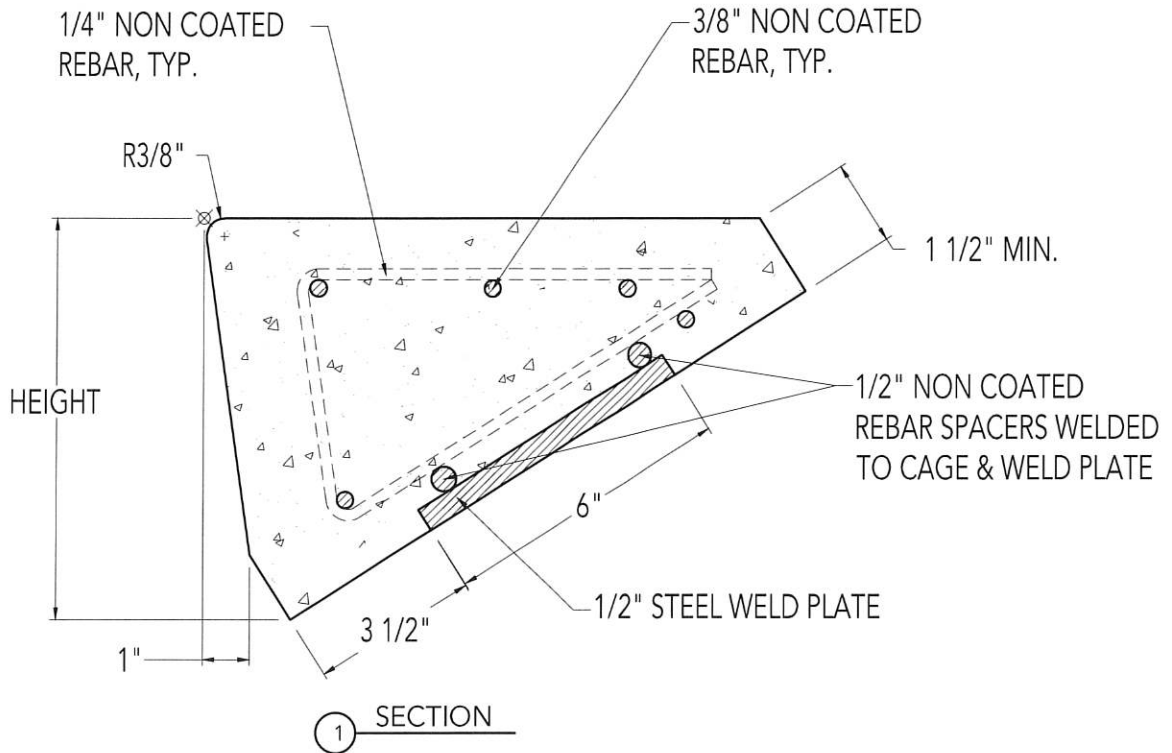
P.O. BOX 1520 WAUSAU, WI 54402-1520  
TOLL FREE: 800-388-8728  
E-MAIL: WTILE@WAUSAUTILE.COM  
WEBSITE: WWW.WAUSAUTILE.COM

DRAWN BY: SKD  
REV DATE: 01.04.21  
FILE: -

CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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:**

D

**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:

**TEARDROP SELF SUPPORTING**

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

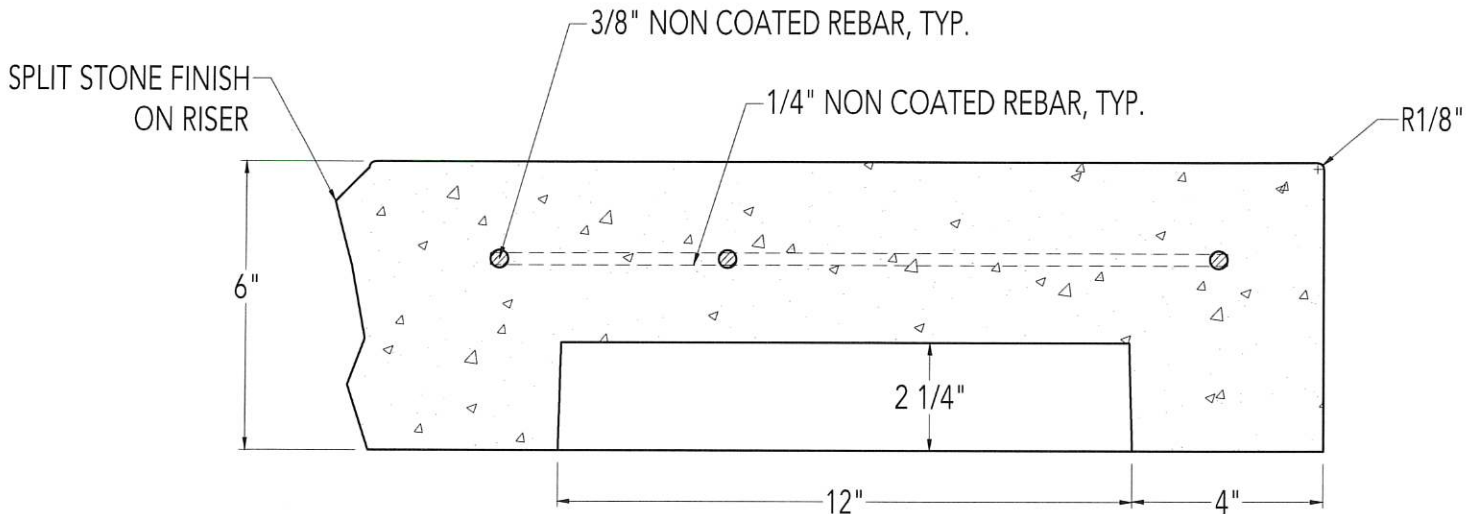
DRAWN BY: SKD

REV DATE: 01.04.21

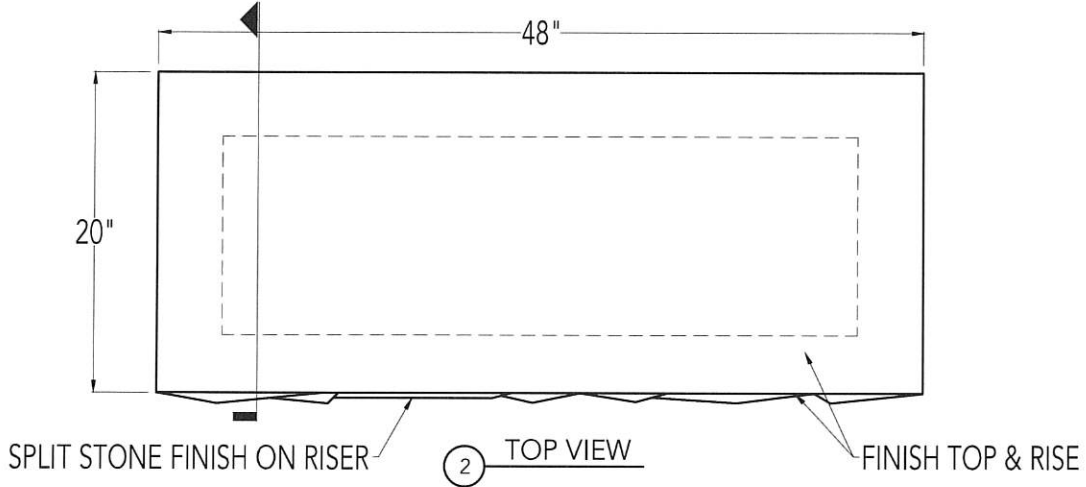
FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN THE SOLE PROPERTY OF WAUSAU TILE, INC.

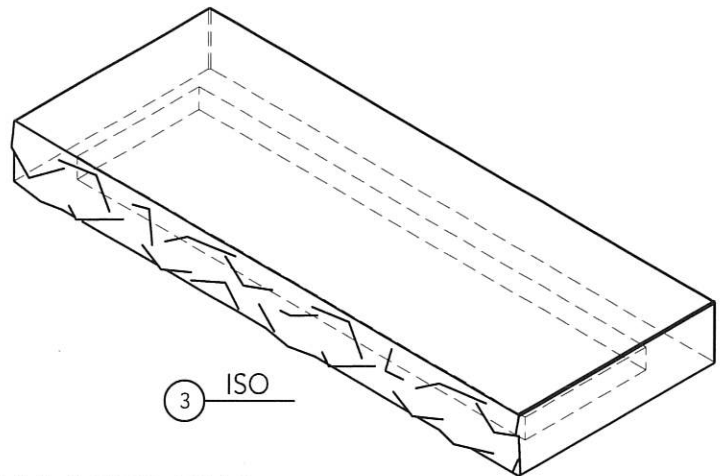
UNLESS OTHERWISE SPECIFIED  
 DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED  
 TO THE CLOSEST FRACTION + 1/16"  
 FABRICATION TOLERANCE: ± 1/8"



1 SECTION



2 TOP VIEW



3 ISO

SCALE: NOT TO SCALE

DIMENSIONAL PARAMETERS:  
AS DRAWN

INSTALL METHOD:  
A

DESIGN OPTIONS:  
COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST  
ABRASIVE STRIPS: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST

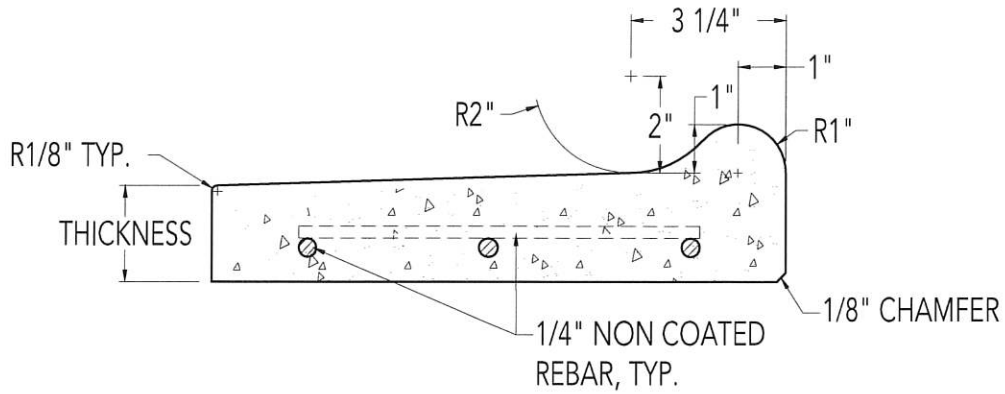


PRODUCT: <b>LANDSCAPE TREAD</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

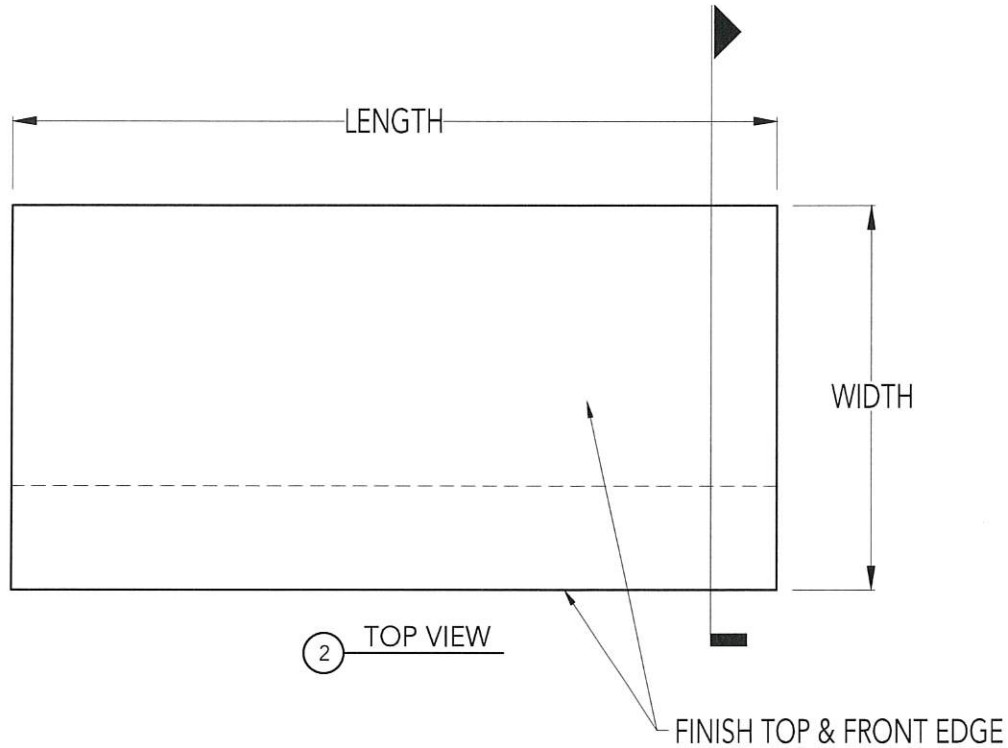
CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"

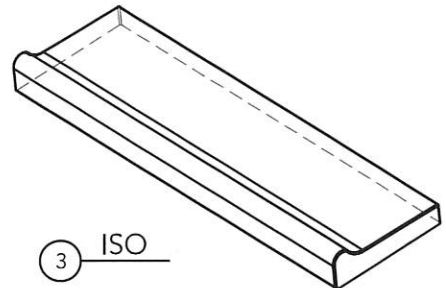




1 SECTION



2 TOP VIEW



3 ISO

**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:**

F

**DESIGN OPTIONS:**

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

SCALE: NOT TO SCALE



PRODUCT:

POOL COPING: SAFETY EDGE

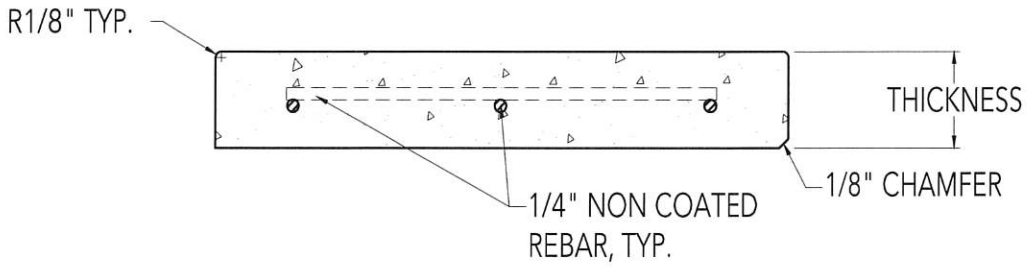
MATERIAL: PRECAST CONCRETE

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

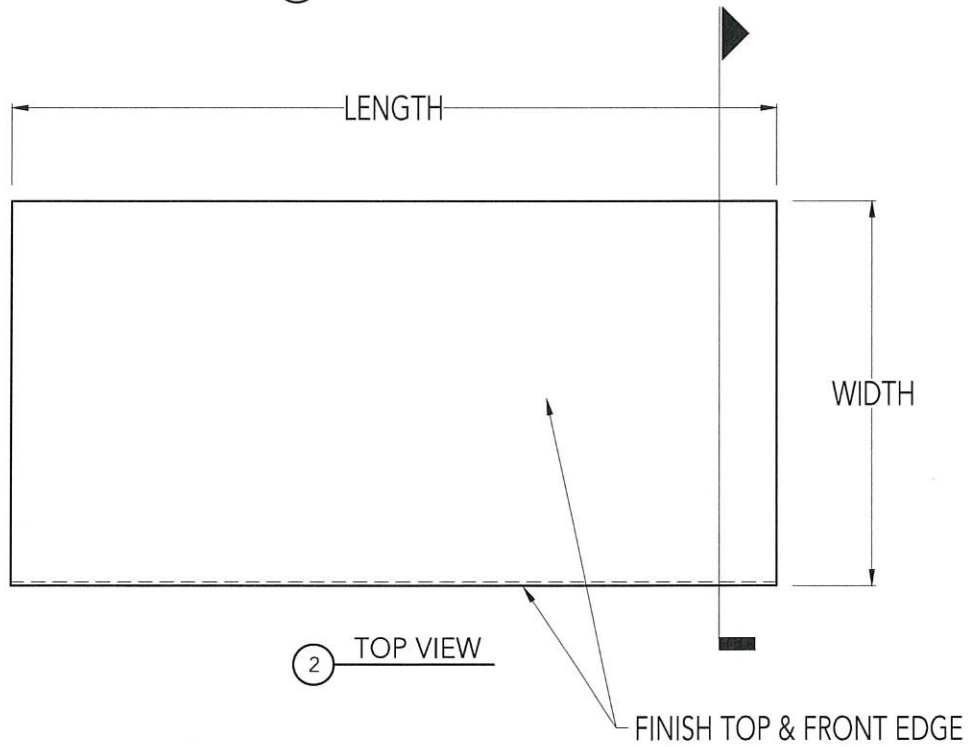
DRAWN BY: SKD  
 REV DATE: 01.04.21  
 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN THE SOLE PROPERTY OF WAUSAU TILE, INC.

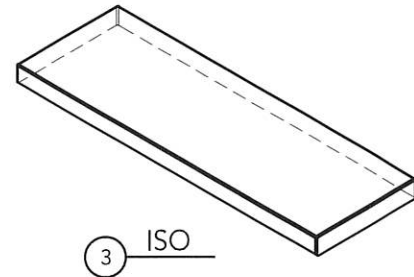
UNLESS OTHERWISE SPECIFIED  
 DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED  
 TO THE CLOSEST FRACTION + 1/16"  
 FABRICATION TOLERANCE: ± 1/8"



1 SECTION



2 TOP VIEW



3 ISO

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"

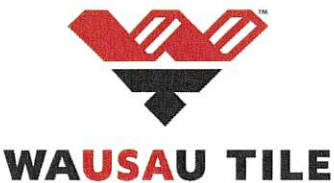
INSTALL METHOD:

F

DESIGN OPTIONS:

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

SCALE: NOT TO SCALE



PRODUCT:

POOL COPING: SQUARE EDGE

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

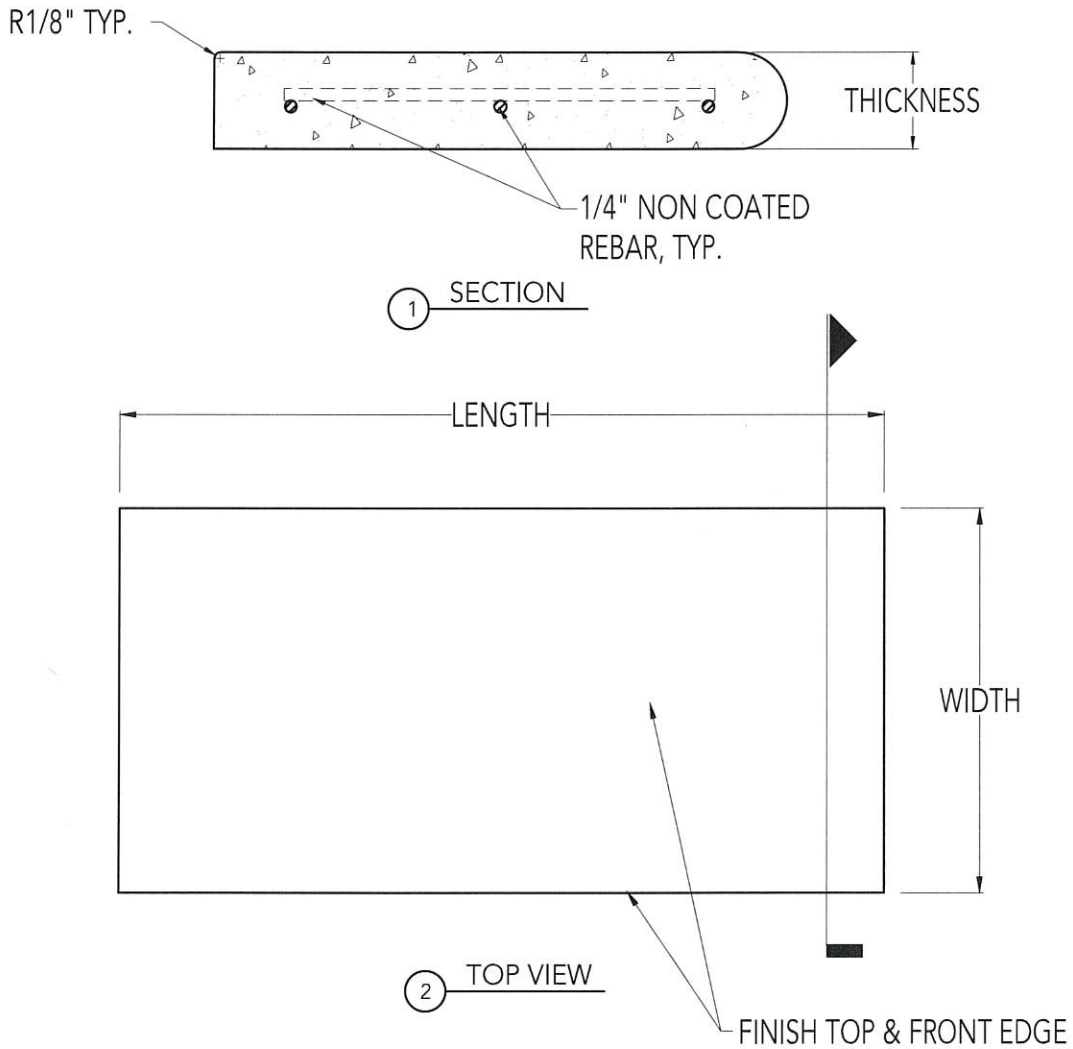
REV DATE: 01.04.21

FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"

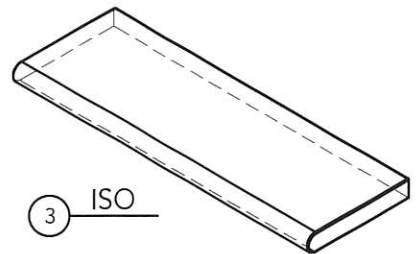




**DIMENSIONAL PARAMETERS:**  
 UP TO 4'-0" : 2" MINIMUM THICKNESS  
 4'-0" TO 6'-0" : 2 1/2" MINIMUM THICKNESS  
 6'-0" TO 8'-0" : 3" MINIMUM THICKNESS  
 MAX LENGTH 8'-0"

**INSTALL METHOD:**  
 F

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



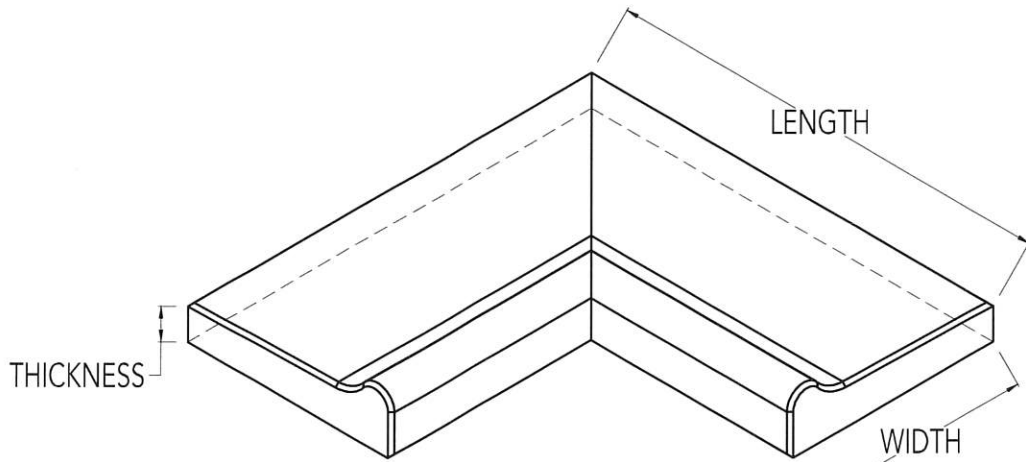
SCALE: NOT TO SCALE



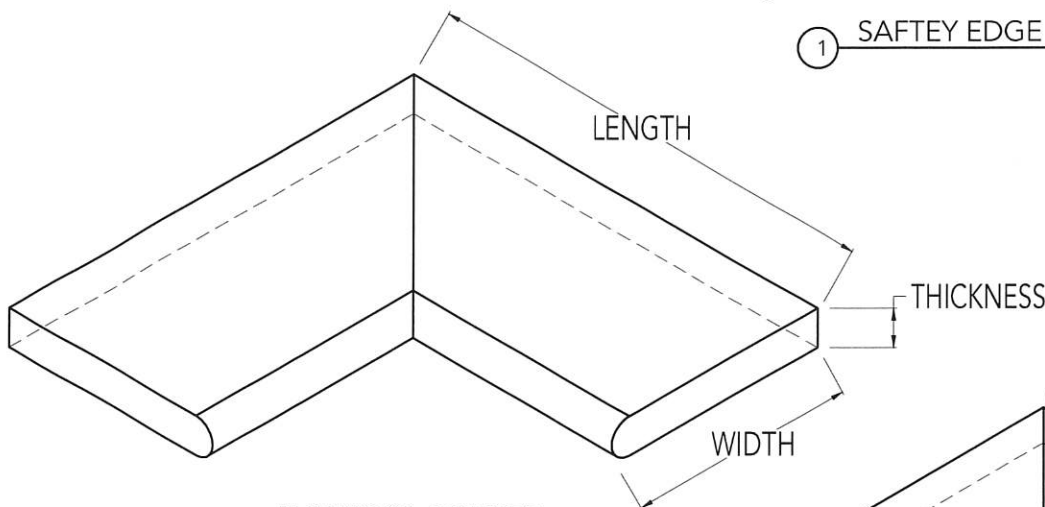
PRODUCT: <b>POOL COPING: BULLNOSE</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN THE SOLE PROPERTY OF WAUSAU TILE, INC.

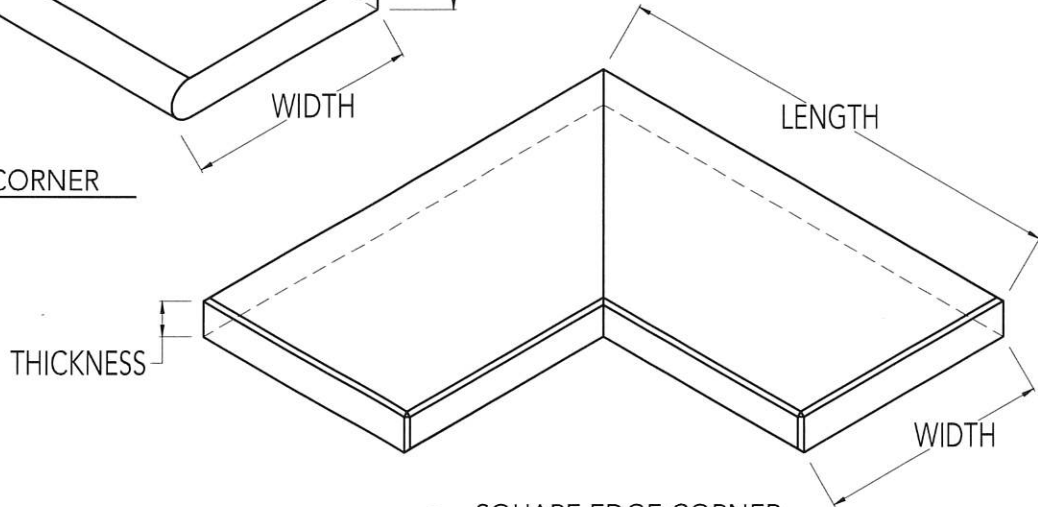
UNLESS OTHERWISE SPECIFIED  
 DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED  
 TO THE CLOSEST FRACTION + 1/16"  
 FABRICATION TOLERANCE: ± 1/8"



① SAFETY EDGE CORNER



② BULLNOSE CORNER



③ SQUARE EDGE CORNER

**DIMENSIONAL PARAMETERS:**  
 MAX 4'-0" SIDES: 2" MINIMUM THICKNESS

**INSTALL METHOD:**  
 F

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

SCALE: NOT TO SCALE

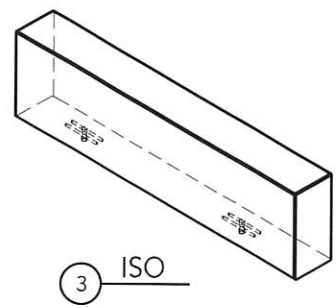
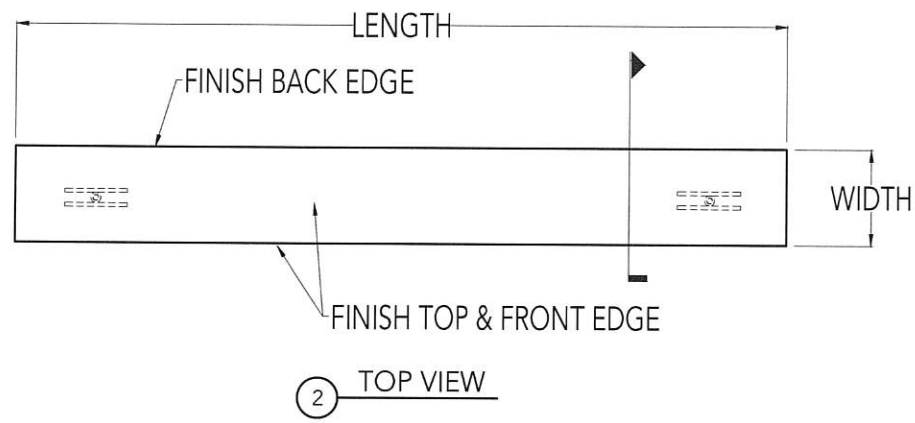
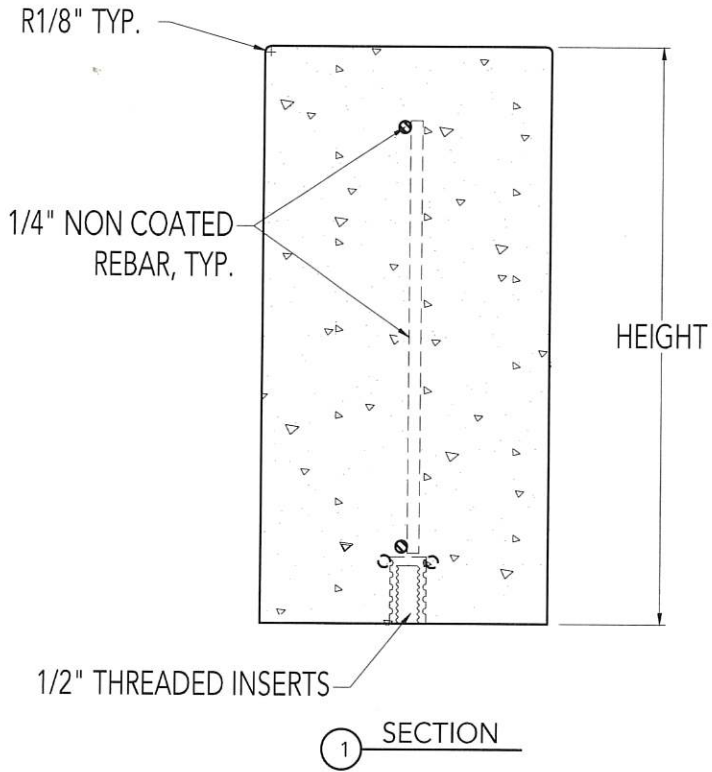


PRODUCT: <b>POOL COPING: TYPICAL CORNERS</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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:  
 E

DESIGN OPTIONS:  
 COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST  
 ADDITIONAL SIDES FINISHED BY REQUEST

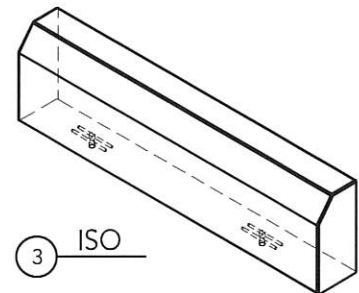
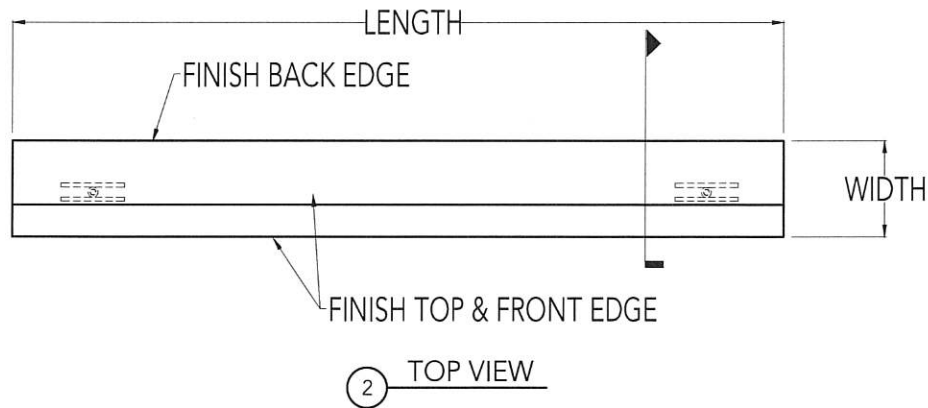
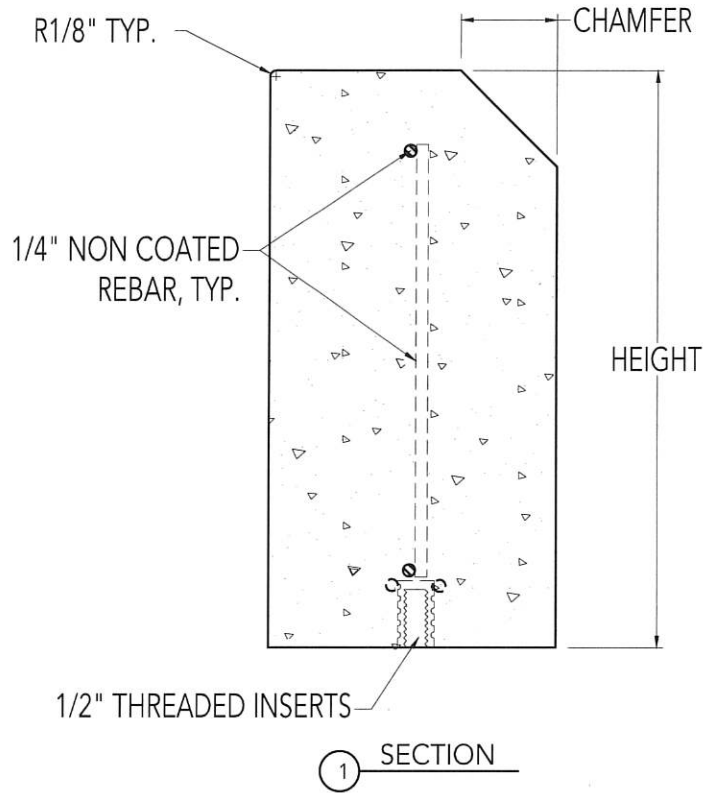
SCALE: NOT TO SCALE



PRODUCT: <b>CURB</b>	
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: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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:**

E

**DESIGN OPTIONS:**

COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM

AVAILABLE UPON REQUEST

ADDITIONAL SIDES FINISHED BY REQUEST

SCALE: NOT TO SCALE



PRODUCT:

**CHAMFERED CURB**

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

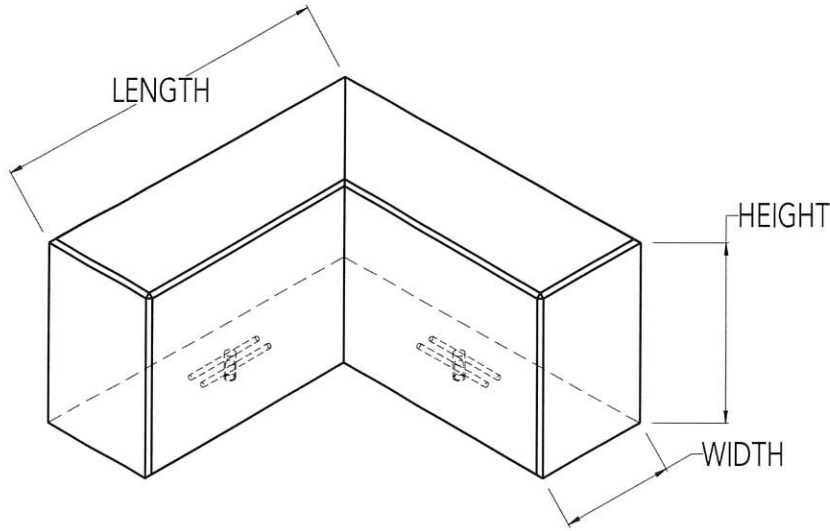
DRAWN BY: SKD

REV DATE: 01.04.21

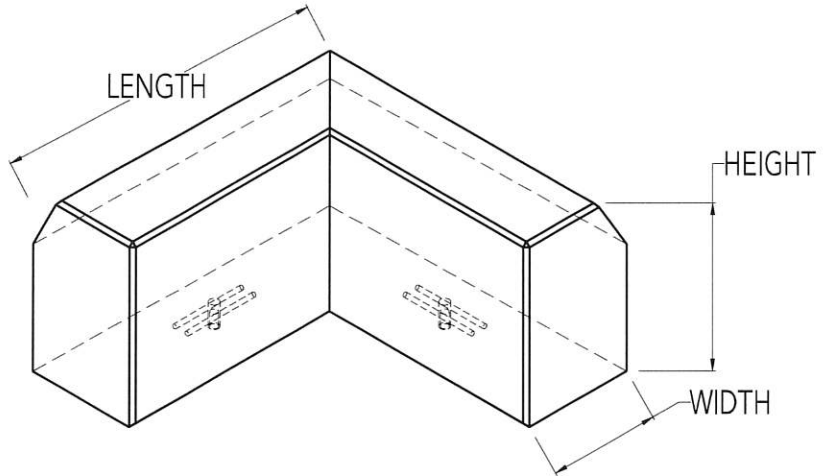
FILE: -

CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS  
ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF  
WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR  
USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR  
WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION  
CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN  
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"



① STANDARD CURB CORNER



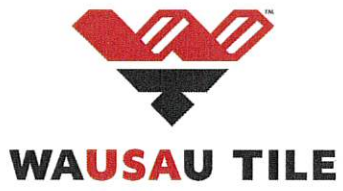
② CHAMFER CURB CORNER

DIMENSIONAL PARAMETERS:  
MAX 4'-0" SIDES:

INSTALL METHOD:  
E

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

SCALE: NOT TO SCALE



PRODUCT: <b>CURB: TYPICAL CORNERS</b>	
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: -

CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"



1/4" NON COATED REBAR, TYP.

2" MINIMUM

HEIGHT

1/2" THREADED INSERTS

1 SECTION

FINISH TOP & ALL EDGES

LENGTH

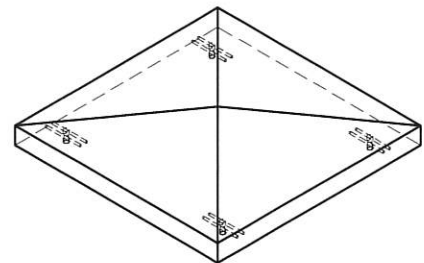
WIDTH

2 TOP VIEW

DIMENSIONAL PARAMETERS:  
MAX SIZE: 4' WIDTH / 8' LENGTH

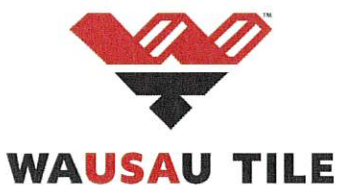
INSTALL METHOD:  
E

DESIGN OPTIONS:  
COLORS/FINISH: ALL WT STANDARDS AVAILABLE; CUSTOM AVAILABLE UPON REQUEST  
1/4" DRIP EDGE



3 ISO

SCALE: NOT TO SCALE



PRODUCT:

COLUMN CAP

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

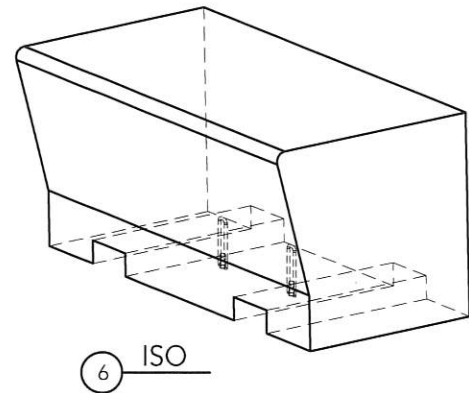
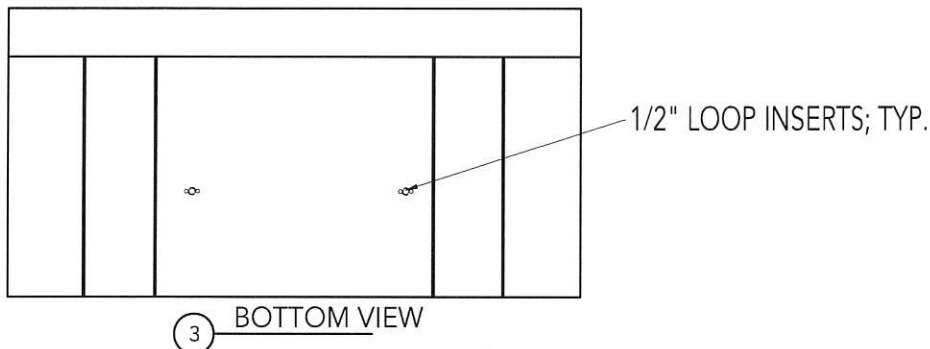
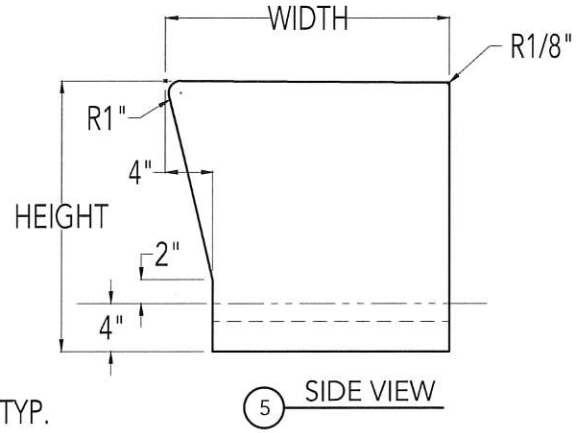
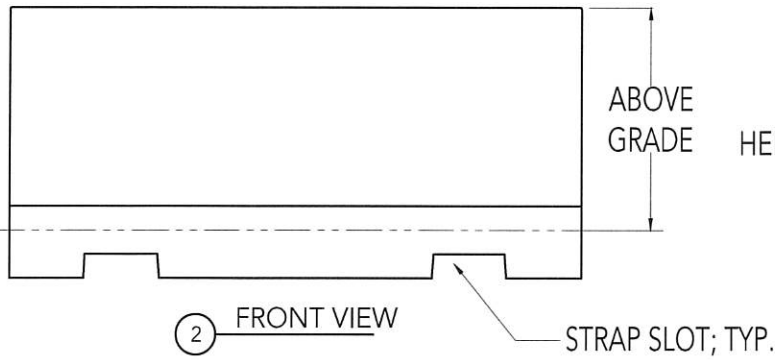
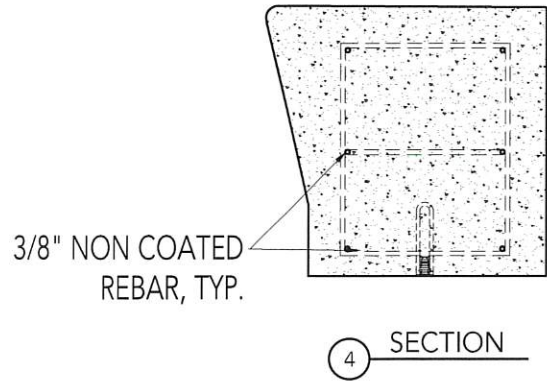
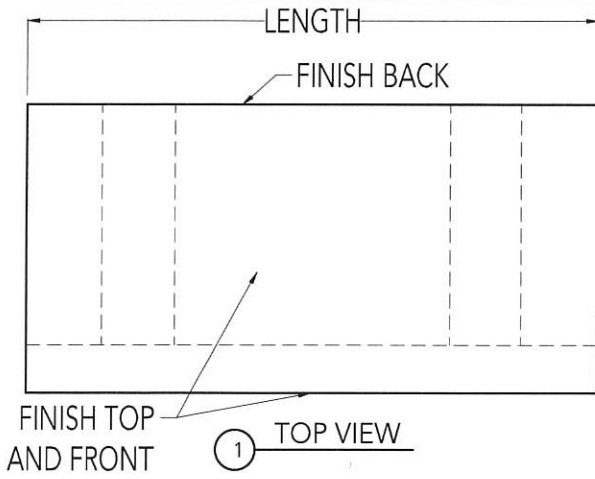
DRAWN BY: SKD

REV DATE: 01.04.21

FILE: -

CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"

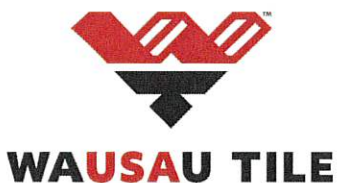
INSTALL METHOD:

E  
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

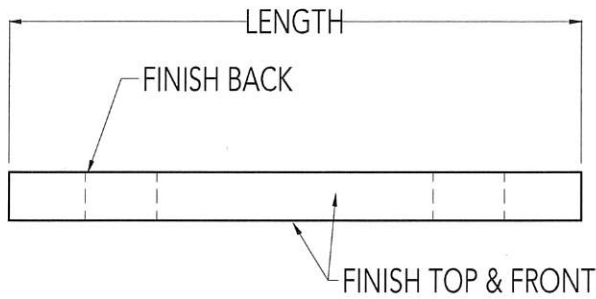
SCALE: NOT TO SCALE



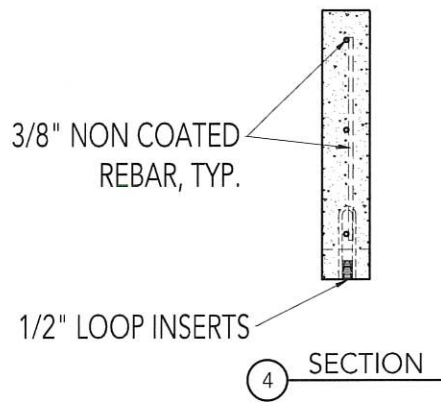
PRODUCT: <b>BENCH</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8723 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN THE SOLE PROPERTY OF WAUSAU TILE, INC.

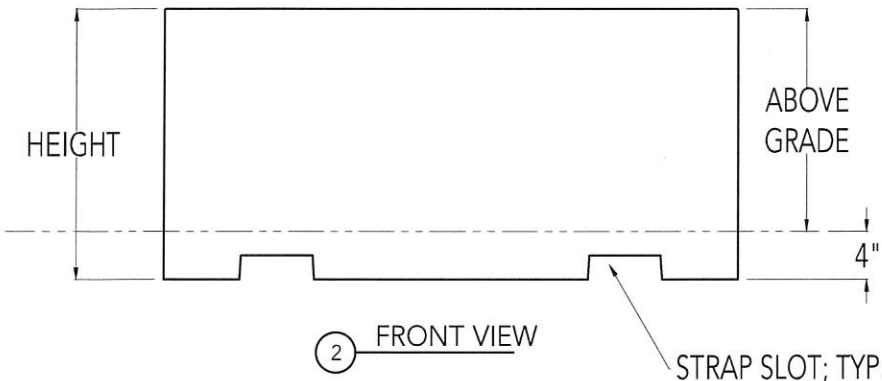
UNLESS OTHERWISE SPECIFIED  
DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED  
TO THE CLOSEST FRACTION + 1/16"  
FABRICATION TOLERANCE: ± 1/8"



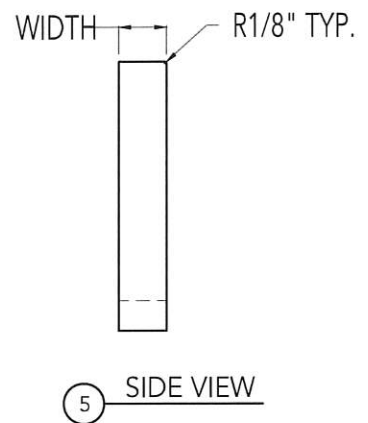
1 TOP VIEW



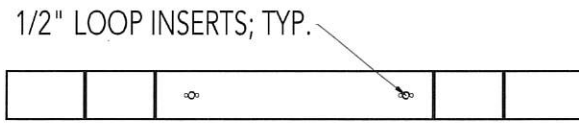
4 SECTION



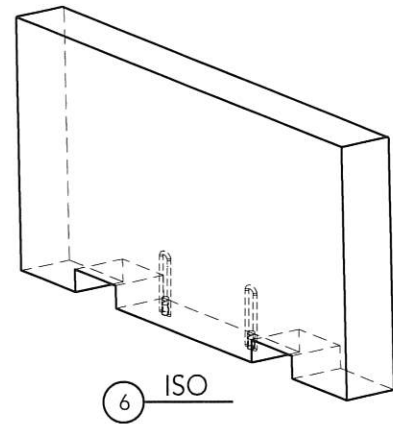
2 FRONT VIEW



5 SIDE VIEW



3 BOTTOM VIEW



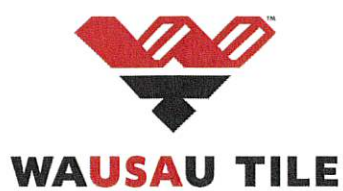
6 ISO

DIMENSIONAL PARAMETERS:  
MAX LENGTH: 8'-0"

INSTALL METHOD:  
E  
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

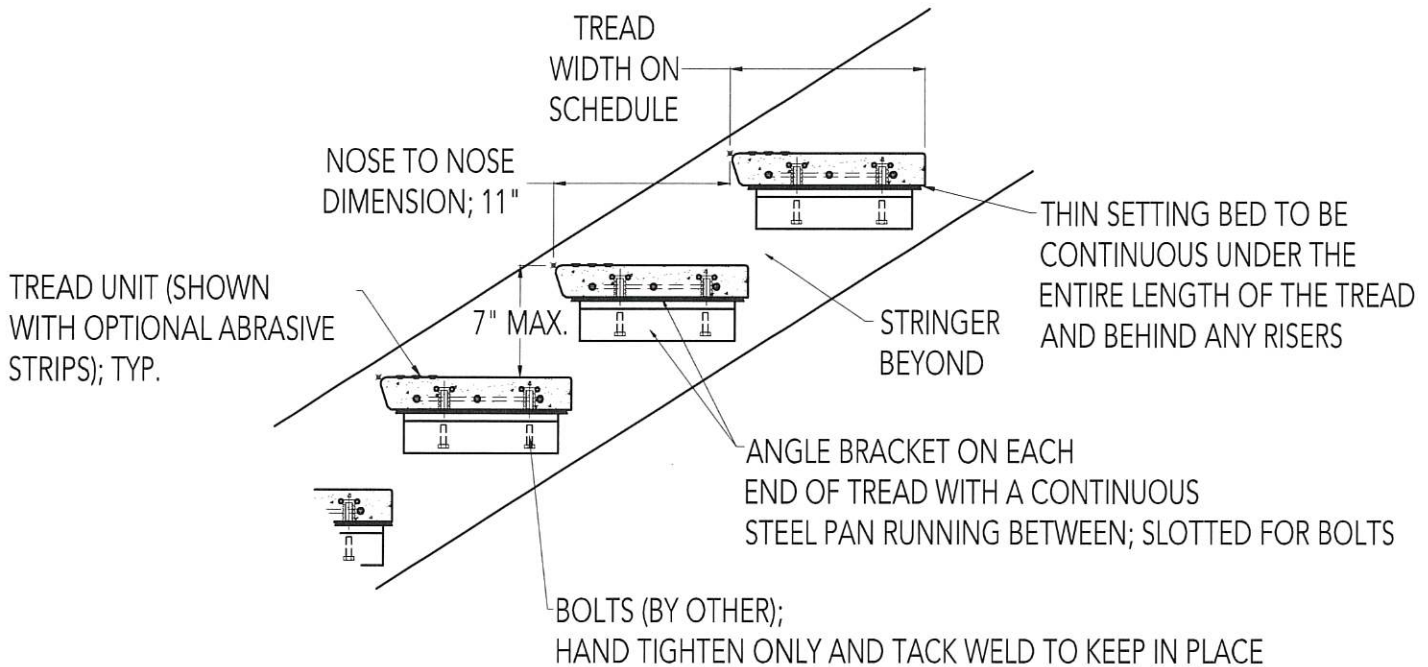
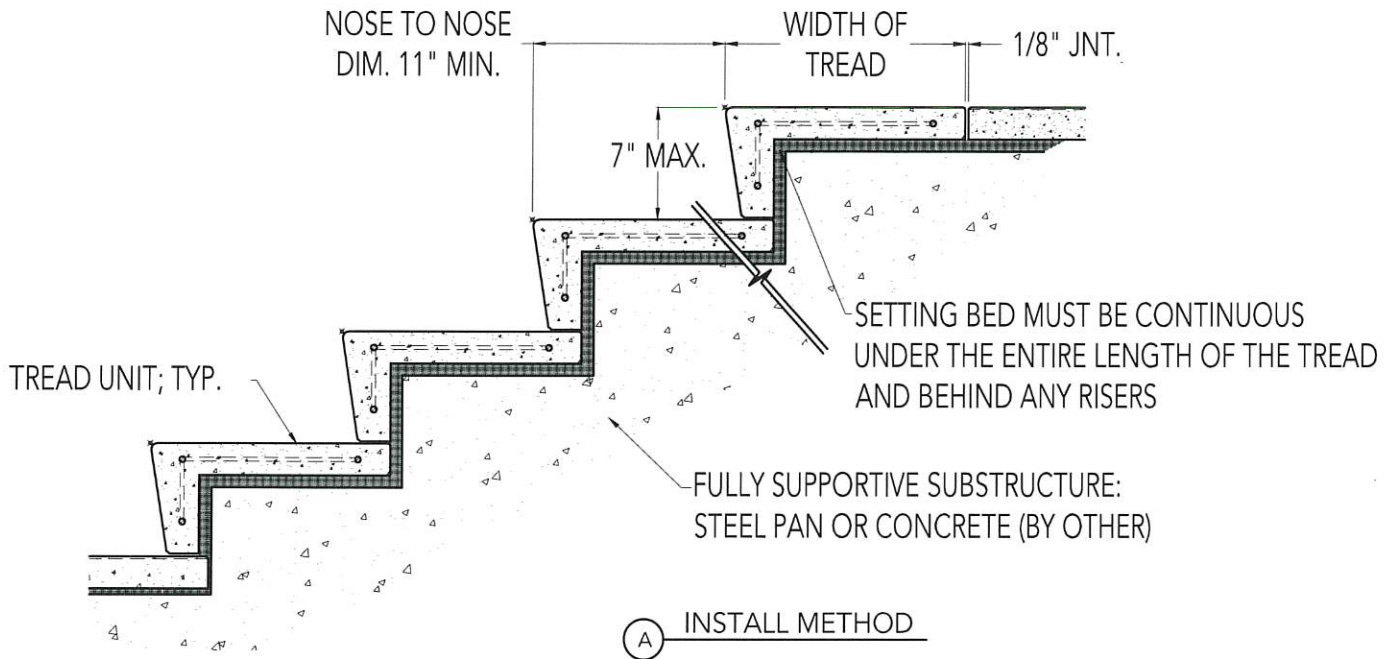


PRODUCT: <b>PLANTER WALL</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"





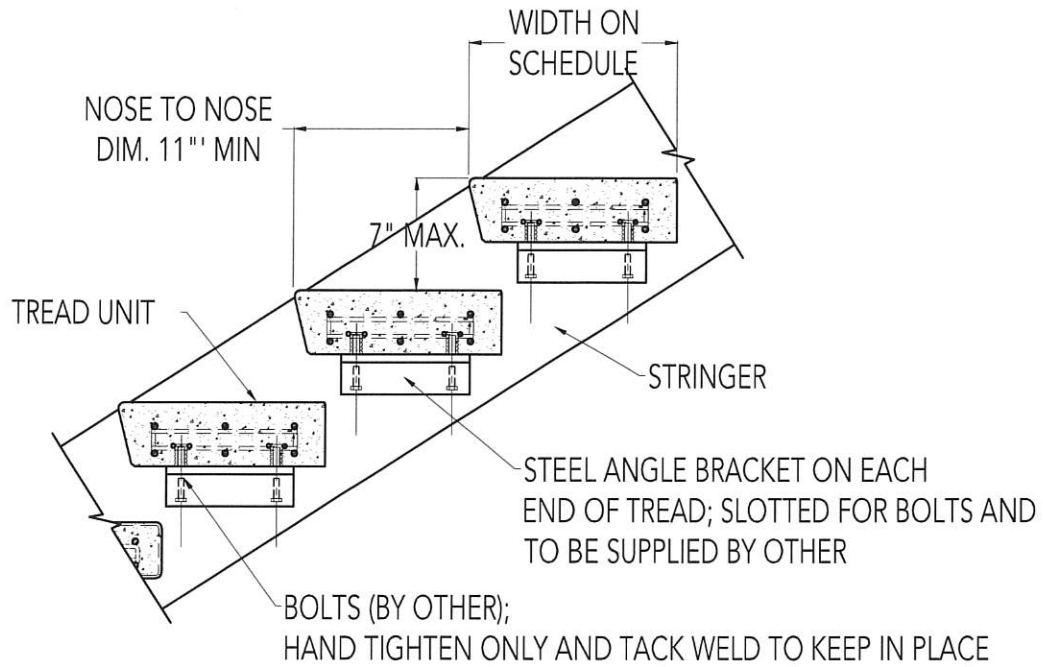
SCALE: NOT TO SCALE



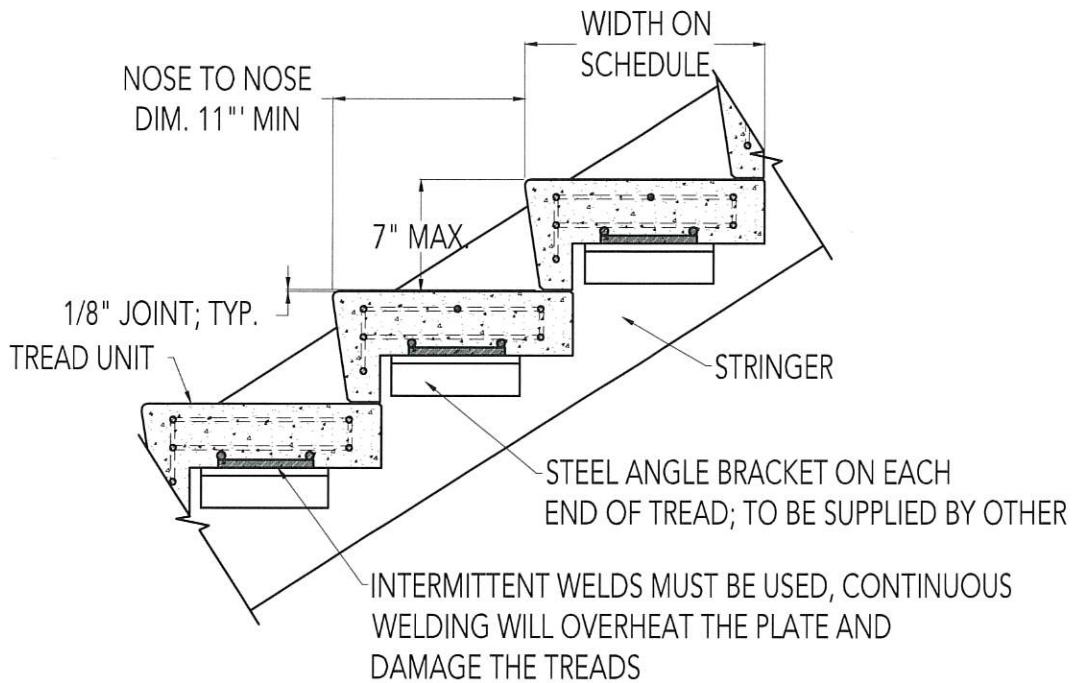
PRODUCT: <b>FULLY SUPPORTED INSTALL STYLES</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"



**C** INSTALL METHOD



**D** INSTALL METHOD

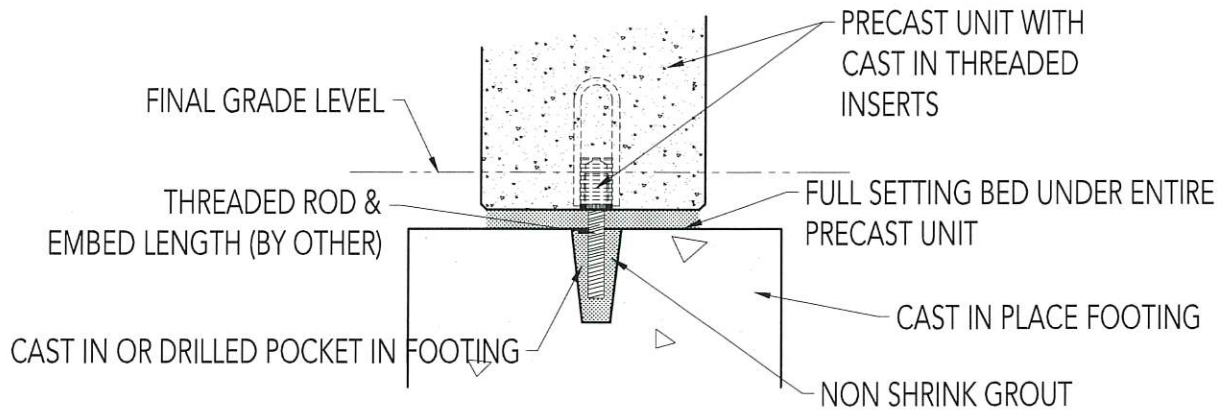
SCALE: NOT TO SCALE



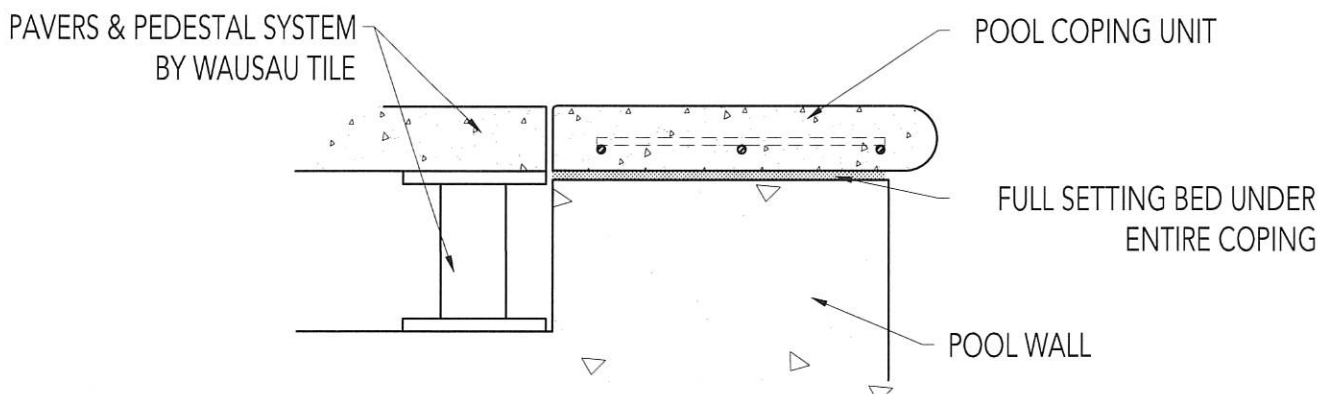
PRODUCT: <b>SELF SUPPORTING INSTALL STYLES</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WALSAUTILE.COM WEBSITE: WWW.WALSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"



(E) INSTALL METHOD



(F) INSTALL METHOD

SCALE: NOT TO SCALE

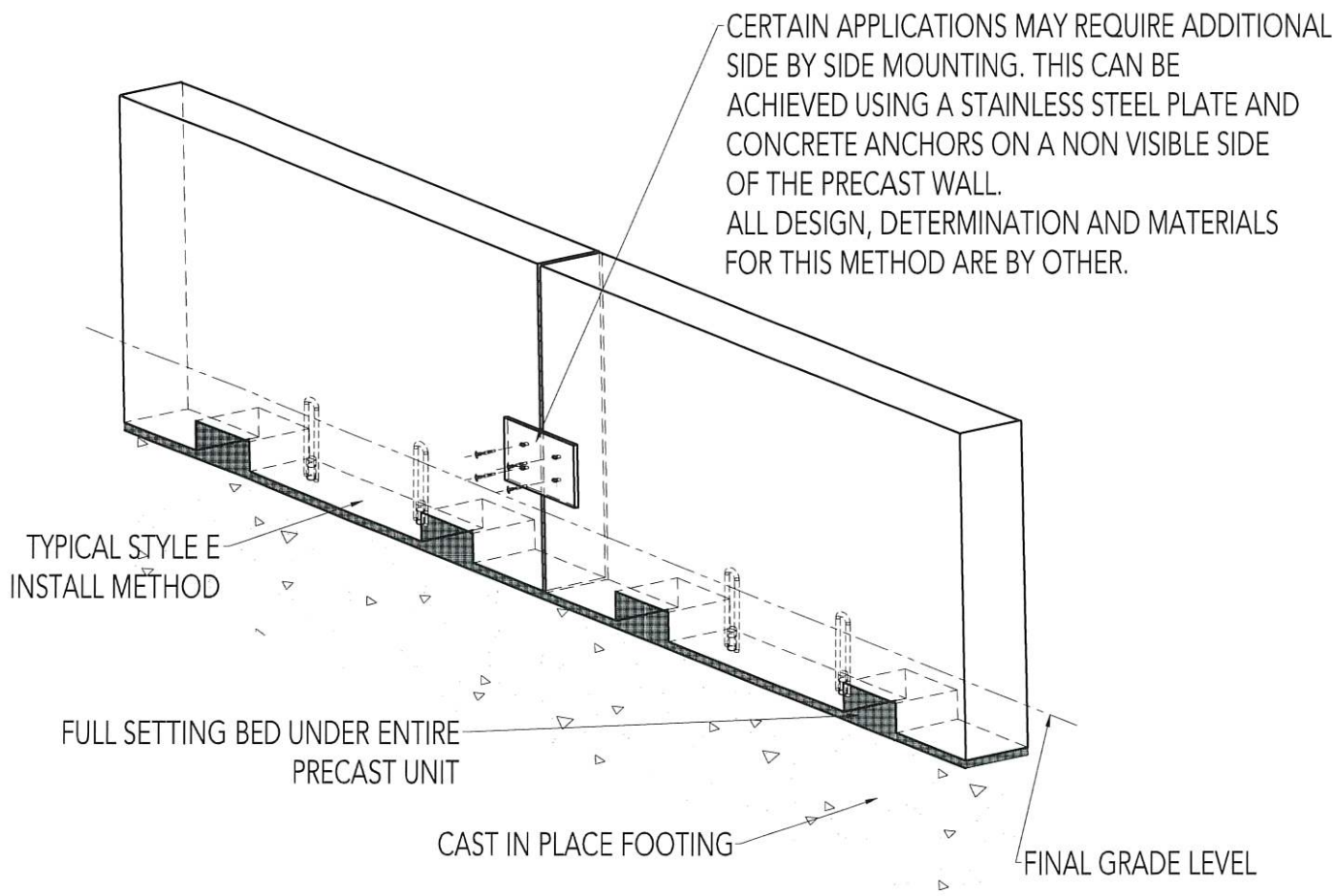


PRODUCT: <b>MISC PRODUCT INSTALL STYLES</b>	
MATERIAL: PRECAST CONCRETE	
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM	DRAWN BY: SKD REV DATE: 01.04.21 FILE: -

CONFIDENTIAL INFORMATION  
 THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"



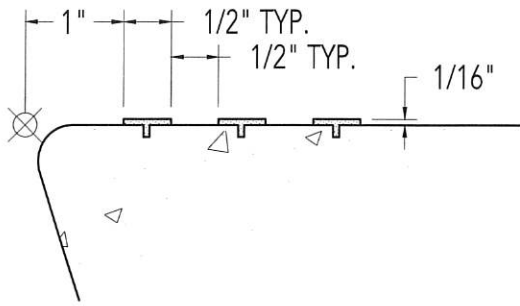


G INSTALL METHOD

SCALE: NOT TO SCALE

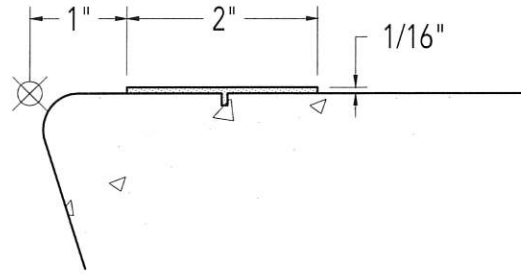


PRODUCT: <b>MISC PRODUCT INSTALL STYLES</b>		CONFIDENTIAL INFORMATION THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN THE SOLE PROPERTY OF WAUSAU TILE, INC.	
MATERIAL: PRECAST CONCRETE		DRAWN BY: SKD	UNLESS OTHERWISE SPECIFIED DIMENSIONS SHOWN IN INCHES AND ARE ROUNDED TO THE CLOSEST FRACTION + 1/16" FABRICATION TOLERANCE: ± 1/8"
P.O. BOX 1520 WAUSAU, WI 54402-1520 TOLL FREE: 800-388-8728 E-MAIL: WTILE@WAUSAUTILE.COM WEBSITE: WWW.WAUSAUTILE.COM		REV DATE: 01.04.21	
		FILE: -	
			PG <b>30</b>



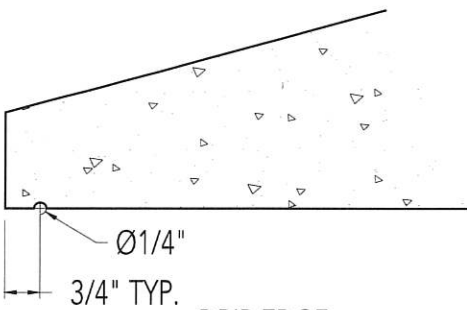
**3-LINE EPOXY ABRASIVE**

STANDARD: BLACK  
CUSTOM: AVAILABLE



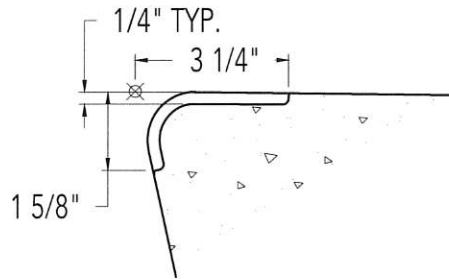
**2 INCH EPOXY ABRASIVE**

STANDARD: BLACK  
CUSTOM: AVAILABLE

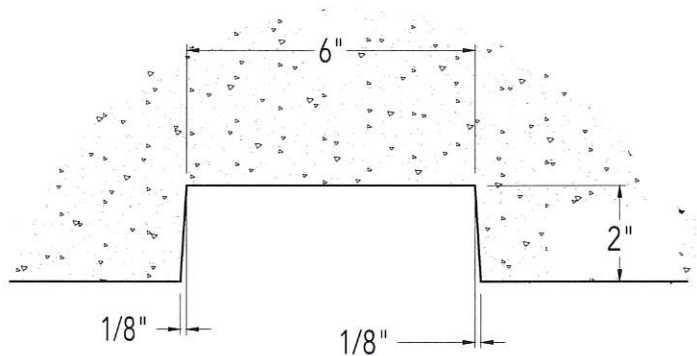


**DRIP EDGE**

STANDARD: 1/4"

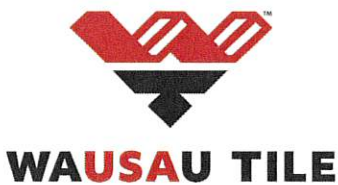


**CAST IN SKATE STOP**



**STRAP SLOT DETAIL**

SCALE: NOT TO SCALE



PRODUCT: <b>DESIGN OPTIONS</b>	
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: -

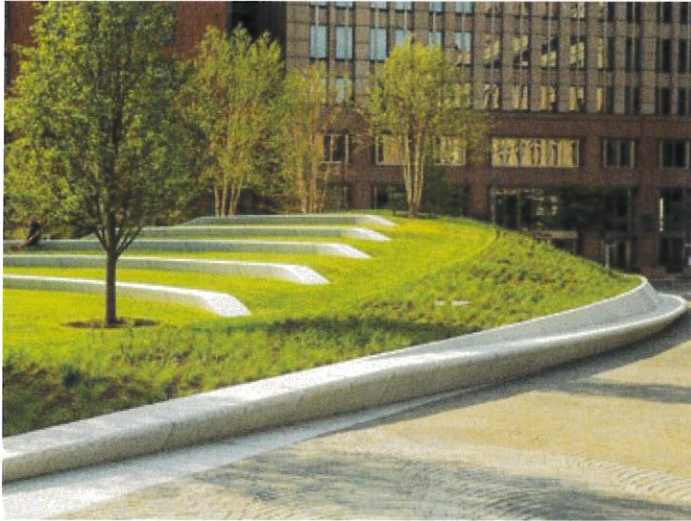
CONFIDENTIAL INFORMATION  
THESE DRAWING, SPECIFICATIONS AND OTHER INFORMATION AND DOCUMENTS ACCOMPANYING THEM ARE THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF WAUSAU TILE, INC. THE DRAWINGS THEMSELVES SHALL BELONG TO THE OWNER FOR USE ONLY ON THE PROJECT. ANY ADDITIONAL USE SHALL REQUIRE THE PRIOR WRITTEN APPROVAL OF WAUSAU TILE, INC. THE PROPRIETARY INFORMATION CONTAINED WITHIN THE DRAWINGS AND THE DOCUMENTS IS AND SHALL REMAIN 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"



**WAUSAU TILE**

# 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](http://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)	

**CALL FOR FURTHER DETAILS & PRICING.**

P: 800.388.8728 | E: [wtile@wausautile.com](mailto:wtile@wausautile.com) | [WAUSAUTILE.COM](http://WAUSAUTILE.COM)





SHERWIN-WILLIAMS.

*Streamline Architects  
Runners Park Sunshade  
March 02, 2021*

---

## 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



**SHERWIN-WILLIAMS.**

## 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 ASTM D4261).

**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 have 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. Mill 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. Mill 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. Mill 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-SP 1 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 objective 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 mill 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 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 allow as much of the tightly adherent rust and other corrosion 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.





*SHERWIN-WILLIAMS*®

# Reference Pages

# Data Pages



**Protective & Marine Coatings**  
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**

<b>Finish:</b>	Flat
<b>Colors:</b>	Gray-Green
<b>Volume Solids:</b>	68% ± 2%, ASTM D2697, mixed
<b>VOC (mixed):</b>	<340 g/L; 2.8 lb/gal, unreduced <340 g/L; 2.8 lb/gal, reduced 5%
<b>Mix Ratio:</b>	2 components, premeasured; 8:1 2.25 gallons (8.5L) total
<b>Typical Thickness:</b>	
<b>Recommended Spreading Rate per coat:</b>	
	<b>Minimum      Maximum</b>
<b>Wet mils (microns)</b>	<b>5.0 (125)      8.0 (200)</b>
<b>Dry mils (microns)</b>	<b>3.0 (75)      5.0 (125)</b>
<b>~Coverage sq ft/gal (m<sup>2</sup>/L)</b>	<b>218 (5.4)      363 (8.9)</b>
<b>Theoretical coverage sq ft/gal (m<sup>2</sup>/L) @ 1 mil / 25 microns dft</b>	<b>1090 (26.8)</b>
<i>NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.</i>	
<b>Shelf Life:</b>	18 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C).
<b>Flash Point:</b>	80°F (27°C), PMCC, mixed
<b>Reducer/Clean Up:</b>	Above 80°F (27°C): M.E.K. Below 80°F (27°C): Reducer #58 or M.E.K.
<b>Weight:</b>	26.45 ± 0.2 lb/gal ; 3.17 Kg/L, mixed

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

	<b>40°F (4.5°C)</b>	<b>77°F (25°C)</b>	<b>110°F (43°C)</b>
		<b>50% RH</b>	
<b>Touch:</b>	45 minutes	30 minutes	15 minutes
<b>Handle:</b>	1.5 hours	1 hour	45 minutes
<b>Recoat*:</b>			
<b>minimum:</b>	6 hours	4 hours	2 hours
<b>maximum**:</b>	none	none	none
<b>Cure:</b>	10 days	10 days	7-10 days
<b>Pot Life:</b>	8 hours	6 hours	4 hours
<b>Sweat-in-time:</b>	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.*





**Protective & Marine Coatings**  
PRODUCT DATA SHEET



# ZINC CLAD® IV (85)

## ORGANIC ZINC RICH COATING

APPLICATION	APPLICATION CONDITIONS
-------------	------------------------

**Airless Spray**  
(use Teflon packings and continuous agitation)  
 Pressure.....2000-2300 psi (138-158 bar)  
 Hose.....3/8" ID (9.5 mm)  
 Tip .....0.19" (0.48 mm)  
 Reduction.....As needed, up to 10% by volume

**Conventional Spray**  
(continuous agitation required)  
 Gun .....Binks 95  
 Fluid Nozzle .....68  
 Air Nozzle.....68P  
 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.

**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.

RECOMMENDED SYSTEMS
---------------------

Dry Film Thickness / ct.	<u>Mils</u>	<u>(Microns)</u>
<b>Steel, Organic Zinc/Epoxy</b>		
1 Ct. Zinc Clad IV (85)	3.0-5.0	(75-125)
1-2 Cts. Macropoxy 646	5.0-10.0	(125-250)
<b>Steel, Organic Zinc/Epoxy/Urethane</b>		
1 Ct. Zinc Clad IV (85)	3.0-5.0	(75-125)
1-2 Cts. Macropoxy 646	5.0-10.0	(125-250)
1 Ct. Acrolon 7300	2.0-4.0	(50-100)
<b>Steel, Organic Zinc/Epoxy/Urethane</b>		
1 Ct. Zinc Clad IV (85)	3.0-5.0	(75-125)
1 Ct. Macropoxy 267	5.0	(125)
1 Ct. Acrolon 7300	2.0-4.0	(50-100)
<b>Steel, Organic Zinc/Polysiloxane</b>		
1 Ct. Zinc Clad IV (85)	3.0-5.0	(75-125)
1-2 Cts. Sher-Loxane 800	2.0-4.0	(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.

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
------------

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 Sheet.





**Protective & Marine Coatings**  
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**

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

**Recommended Spreading Rate per coat:**

	Minimum	Maximum
<b>Wet mils (microns)</b>	<b>7.0</b> (175)	<b>13.5</b> (338)
<b>Dry mils (microns)</b>	<b>5.0*</b> (125)	<b>10.0</b> (250)
<b>~Coverage sq ft/gal (m<sup>2</sup>/L)</b>	<b>115</b> (2.9)	<b>230</b> (5.8)
<b>Theoretical coverage sq ft/gal (m<sup>2</sup>/L) @ 1 mil / 25 microns dft</b>	<b>1152</b> (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.*

<b>Shelf Life:</b>	36 months, unopened Store indoors at 40°F (4.5°C) to 110°F (43°C).
<b>Flash Point:</b>	91°F (33°C), TCC, mixed
<b>Reducer/Clean Up:</b>	Reducer #15, Reducer #58, or MEK (California) Reducer #111 or Oxsol 100
<b>Weight:</b>	12.9 ± 0.2 lb/gal ; 1.55 Kg/L, mixed, may 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
<b>Touch:</b>	4-5 hours	2 hours	1.5 hours
<b>Handle:</b>	48 hours	8 hours	4.5 hours
<b>Recoat:</b>			
<b>minimum:</b>	48 hours	8 hours	4.5 hours
<b>maximum:</b>	1 year	1 year	1 year
<b>Cure to service:</b>			
<b>atmospheric:</b>	10 days	7 days	4 days
<b>immersion:</b>	14 days	7 days	4 days

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

<b>Touch:</b>	3 hours	1 hour	1 hour
<b>Handle:</b>	48 hours	4 hours	2 hours
<b>Recoat:</b>			
<b>minimum:</b>	16 hours	4 hours	2 hours
<b>maximum:</b>	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.*

<b>Pot Life:</b>	10 hours	4 hours	2 hours
<b>Sweat-in-time:</b>	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:**

<b>Iron &amp; Steel:</b>	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
<b>Stainless Steel:</b>	Atmospheric: SSPC-SP16, 1 mil (25 micron) profile
<b>Aluminum &amp; Galvanizing:</b>	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.
<b>Concrete &amp; Masonry:</b>	Atmospheric: SSPC-SP13/NACE 6, or ICRI No. 310.2R CSP 1-3 Immersion: SSPC-SP13/NACE 6-4.3.1
<b>Ductile Iron Pipe:</b>	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





# Protective & Marine Coatings

PRODUCT DATA SHEET

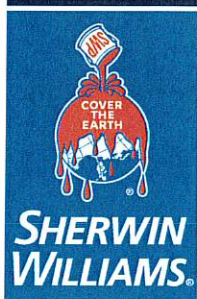


# MACROPOXY® 646

## FAST CURE EPOXY

APPLICATION	APPLICATION CONDITIONS																								
<p><b>Airless Spray*</b></p> <p>Pump.....30:1            Pressure.....2800-3000 psi (193-206 bar)            Hose.....1/4" ID (6.3 mm)            Tip......017"-.023" (0.43-0.58 mm)            Filter.....60 mesh            Reduction.....As needed up to 10% by volume</p> <p><b>Conventional Spray*</b></p> <p>Gun.....DeVilbiss MBC-510            Fluid Tip.....E            Air Nozzle.....704            Atomization Pressure.....60-65 psi (4.1-4.5 bar)            Fluid Pressure.....10-20 psi (0.7-1.4 bar)</p> <p><b>Brush*</b></p> <p>Brush.....Nylon/Polyester or Natural Bristle</p> <p><b>Roller*</b></p> <p>Cover.....3/8" woven with solvent resistant core</p> <p><b>Plural Component Spray</b>..Acceptable</p> <p>*Reduction.....As needed up to 10% by volume</p> <p>If specific application equipment is not listed above, equivalent equipment may be substituted.</p>	<p><b>Temperature:</b></p> <p>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</p> <p>Relative humidity: 85% maximum</p> <p>*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.</p>																								
	APPROVALS																								
	<ul style="list-style-type: none"> <li>• Suitable for use in USDA inspected facilities</li> <li>• Acceptable for use in Canadian Food Processing facilities, categories: D1, D2, D3 (Confirm acceptance of specific part numbers/rexes with your SW Sales Representative)</li> <li>• Conforms to AWWA D102 OCS #5</li> <li>• Conforms to MPI # 108</li> <li>• This product meets specific design requirements for non-safety related nuclear plant applications in Level II, III and Balance of Plant, and DOE nuclear facilities*</li> <li>• Meets Class A requirements for Slip Coefficient, 0.36 @ 6 mils / 150 microns dft (Mill White only)</li> <li>• Approved intermediate for NEPCOAT System B</li> </ul> <p>* Nuclear qualifications are NRC license specific to the facility</p>																								
RECOMMENDED SYSTEMS	ADDITIONAL NOTES																								
<table border="1"> <thead> <tr> <th>Dry Film Thickness / ct.</th> <th>Mils</th> <th>(Microns)</th> </tr> </thead> <tbody> <tr> <td><b>Steel &amp; Ductile Iron, Immersion &amp; Atmospheric</b> 2 Cts. Macropoxy 646</td> <td>5.0-10.0</td> <td>(125-250)</td> </tr> <tr> <td><b>Steel, Organic Zinc Primer, Atmospheric</b> 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646</td> <td>3.0-5.0 5.0-10.0</td> <td>(75-125) (125-250)</td> </tr> <tr> <td><b>Steel, Inorganic Zinc Primer, Atmospheric</b> 1 Ct. Zinc Clad II (85) 1 Ct. Macropoxy 646</td> <td>2.0-4.0 5.0-10.0</td> <td>(50-100) (125-250)</td> </tr> <tr> <td><b>Steel, Organic Zinc/Epoxy/Urethane Topcoat</b> 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646 1 Ct. Acrolon 7300</td> <td>3.0-5.0 3.0-10.0 2.0-4.0</td> <td>(75-125) (75-250) (50-100)</td> </tr> <tr> <td><b>Steel, Inorganic Zinc/Epoxy/Urethane Topcoat</b> 1 Ct. Zinc Clad II (85) 1 Ct. Macropoxy 646 1 Ct. Acrolon 7300</td> <td>2.0-4.0 3.0-10.0 2.0-4.0</td> <td>(50-100) (75-250) (50-100)</td> </tr> <tr> <td><b>Steel, Organic Zinc/Epoxy/Polysiloxane Topcoat, Atmospheric</b> 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646 1-2 Cts. Sher-Loxane 800</td> <td>3.0-5.0 3.0-10.0 2.0-4.0</td> <td>(75-125) (75-250) (50-100)</td> </tr> <tr> <td><b>Concrete/Masonry, Smooth, Immersion &amp; Atmospheric</b> 2 Cts. Macropoxy 646</td> <td>5.0-10.0</td> <td>(125-250)</td> </tr> </tbody> </table> <p>The systems listed above are representative of the product's use, other systems may be appropriate.</p>	Dry Film Thickness / ct.	Mils	(Microns)	<b>Steel &amp; Ductile Iron, Immersion &amp; Atmospheric</b> 2 Cts. Macropoxy 646	5.0-10.0	(125-250)	<b>Steel, Organic Zinc Primer, Atmospheric</b> 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646	3.0-5.0 5.0-10.0	(75-125) (125-250)	<b>Steel, Inorganic Zinc Primer, Atmospheric</b> 1 Ct. Zinc Clad II (85) 1 Ct. Macropoxy 646	2.0-4.0 5.0-10.0	(50-100) (125-250)	<b>Steel, Organic Zinc/Epoxy/Urethane Topcoat</b> 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)	<b>Steel, Inorganic Zinc/Epoxy/Urethane Topcoat</b> 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)	<b>Steel, Organic Zinc/Epoxy/Polysiloxane Topcoat, Atmospheric</b> 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	(75-125) (75-250) (50-100)	<b>Concrete/Masonry, Smooth, Immersion &amp; Atmospheric</b> 2 Cts. Macropoxy 646	5.0-10.0	(125-250)	<p>Tint Part A with Maxitoners at 150% strength. Five minutes minimum mixing on a mechanical shaker is required for complete mixing of color.</p> <p>Tinting is not recommended for immersion service.</p> <p>Quik-Kick Epoxy Accelerator is acceptable for use. See data page for details.</p> <p>Acceptable for concrete floors.</p> <p>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.</p> <p>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.</p> <p>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 agitation. Allow the material to sweat-in as indicated prior to application. Re-stir before using.</p>
Dry Film Thickness / ct.	Mils	(Microns)																							
<b>Steel &amp; Ductile Iron, Immersion &amp; Atmospheric</b> 2 Cts. Macropoxy 646	5.0-10.0	(125-250)																							
<b>Steel, Organic Zinc Primer, Atmospheric</b> 1 Ct. Zinc Clad IV (85) 1 Ct. Macropoxy 646	3.0-5.0 5.0-10.0	(75-125) (125-250)																							
<b>Steel, Inorganic Zinc Primer, Atmospheric</b> 1 Ct. Zinc Clad II (85) 1 Ct. Macropoxy 646	2.0-4.0 5.0-10.0	(50-100) (125-250)																							
<b>Steel, Organic Zinc/Epoxy/Urethane Topcoat</b> 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)																							
<b>Steel, Inorganic Zinc/Epoxy/Urethane Topcoat</b> 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)																							
<b>Steel, Organic Zinc/Epoxy/Polysiloxane Topcoat, Atmospheric</b> 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	(75-125) (75-250) (50-100)																							
<b>Concrete/Masonry, Smooth, Immersion &amp; Atmospheric</b> 2 Cts. Macropoxy 646	5.0-10.0	(125-250)																							
WARRANTY	HEALTH AND SAFETY																								
<p>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.</p>	<p>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.</p>																								
	DISCLAIMER																								
	<p>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 Sheet.</p>																								





# Protective & Marine Coatings

# 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

<b>Finish:</b>	Gloss or Semi-Gloss
<b>Color:</b>	Wide range of colors available
<b>Volume Solids:</b>	65% ± 2%, mixed, may vary by color
<b>Weight Solids:</b>	78% ± 2%, mixed, may vary by color
<b>VOC (EPA Method 24):</b>	Unreduced: <300 g/L; 2.5 lb/gal mixed Reduced 10% with R7K15: <340 g/L; 2.8 lb/gal mixed Reduced 9% with MEK, R6K10: <340 g/L; 2.8 lb/gal
<b>Mix Ratio:</b>	6:1 by volume, 1 gallon or 5 gallon mixes premeasured components

### Recommended Spreading Rate per coat:

	Minimum	Maximum
<b>Wet mils (microns)</b>	<b>4.5</b> (112.5)	<b>9.0</b> (225)
<b>Dry mils (microns)</b>	<b>3.0</b> (75)	<b>6.0</b> (150)
<b>~Coverage sq ft/gal (m<sup>2</sup>/L)</b>	<b>175</b> (4.3)	<b>346</b> (8.5)
<b>Theoretical coverage sq ft/gal (m<sup>2</sup>/L) @ 1 mil / 25 microns dft</b>	<b>1040</b> (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):

	@ 35°F/1.7°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
<b>To touch:</b>	4 hours	1 hour	20 minutes
<b>To handle:</b>	18 hours	9 hours	4 hours
<b>To recoat:</b>			
<b>minimum:</b>	18 hours	8 hours	6 hours
<b>maximum:</b>	3 months	3 months	3 months
<b>To cure:</b>	14 days	7 days	5 days
<b>Pot Life:</b>	4 hours	2 hours	45 minutes
(reduced 5% with Reducer R7K15)			
<b>Sweat-in-Time:</b>	None		
<i>Drying time is temperature, humidity, and film thickness dependent. Paint temperature must be at least 40°F (4.5°C) minimum.</i>			

**Shelf Life:** Part A\* - 36 months, unopened  
Part B - 24 months, unopened  
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
- Rail cars and locomotives
- Conveyors
- 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
- Tank exteriors
- Pipelines
- Ships

### PERFORMANCE CHARACTERISTICS

**Substrate\*:** Steel

**Surface Preparation\*:** SSPC-SP10/NACE 2

**System Tested\*:**

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

<sup>1</sup> Finish coat only tested

<sup>2</sup> Primer Zinc-Clad II Plus

Intermediate Macropoxy 646

Finish Acrolon 218 HS

<sup>3</sup>Primer Zinc-Clad III HS





# Protective & Marine Coatings

# 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 Thickness / ct.	
		Mils	(Microns)
<b>Steel:</b>			
1 ct.	Macropoxy 646	5.0-10.0	(125-250)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>			
1 ct.	Zinc Clad II Plus	2.0-4.0	(50-100)
1 ct.	Macropoxy 646	3.0-10.0	(75-250)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>			
1 ct.	Zinc Clad IV	3.0-5.0	(75-125)
	or Zinc Clad 4100	3.0-5.0	(75-125)
1 ct.	Macropoxy 646	3.0-10.0	(75-250)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>			
1 ct.	Zinc Clad IV	3.0-5.0	(75-125)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>			
1 ct.	Corothane I-GalvaPac Zinc Primer	3.0-4.0	(75-100)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>			
1 ct.	Epoxy Mastic Aluminum II	6.0	(150)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Steel:</b>			
1 ct.	Recoatable Epoxy Primer	4.0-6.0	(100-150)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)
<b>Concrete/Masonry:</b>			
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)
<b>Aluminum/Galvanizing:</b>			
1 ct.	DTM Wash Primer	0.7-1.3	(18-32)
1-2 cts.	Acrolon 218 HS Polyurethane	3.0-6.0	(75-150)

### FIRETEX ONLY:

#### Finish Coat for FIRETEX Hydrocarbon Systems:

1 ct. 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.

### 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.

### 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
- \* Galvanizing: SSPC-SP1
- \* Concrete & Masonry: 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	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted C St 2	C St 2	SP 2	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Rusted	C St 3	C St 3	SP 3	-
Power Tool Cleaning	Pitted & Rusted D St 3	D St 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

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

Refer to product Application Bulletin for detailed application information.

### ORDERING INFORMATION

Packaging:	1 gallon (3.78L) mix: 5 gallon (18.9L) mix:
Part A:	.86 gal (3.25L) 4.29 gal (16.2L)
Part B:	.14 gal (0.53L) 0.71 gal (2.7L)
	(premeasured components)

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

### 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.





# Protective & Marine Coatings

# 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

### 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	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	C St 2	C St 2	SP 2	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Rusted	C St 3	C St 3	SP 3	-
Power Tool Cleaning	D St 3	D St 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 .....0.13" - .017"  
Filter.....60 mesh  
Reduction.....As needed up to 10% by volume with 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\*

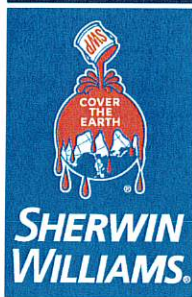
#### Roller

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





# Protective & Marine Coatings

# 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 (m <sup>2</sup> /L)	175 (4.3)	346 (8.5)
Theoretical coverage sq ft/gal (m <sup>2</sup> /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):

	@ 35°F/1.7°C	@ 77°F/25°C 50% RH	@ 120°F/49°C
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 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.