

**SECTION 32 05 23  
CEMENT AND CONCRETE FOR EXTERIOR IMPROVEMENTS**

**PART 1 - GENERAL****1.1 DESCRIPTION**

- A. This section shall cover site work concrete constructed upon the prepared subgrade and in conformance with the lines, grades, thickness, and cross sections shown on the Drawings. Construction shall include the following:
- B. Mountable curb and gutter
- C. Vehicular Pavement: loading docks
- D. Bollards Foundations

**1.2 RELATED WORK**

- A. Section 01 00 00, GENERAL CONDITIONS.
- B. Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES
- C. Section 01 45 29, TESTING LABORATORY SERVICES.
- D. Section 03 30 00, CAST-IN-PLACE CONCRETE.
- E. Section 05 50 00, METAL FABRICATIONS.
- F. Section 31 20 11, EARTHWORK.

**1.3 DESIGN REQUIREMENTS**

Design all elements with the latest published version of applicable codes.

**1.4 WEATHER LIMITATIONS**

- A. Hot Weather: Follow the recommendations of ACI 305 or as specified to prevent problems in the manufacturing, placing, and curing of concrete that can adversely affect the properties and serviceability of the hardened concrete. Methods proposed for cooling materials and arrangements for protecting concrete shall be made in advance of concrete placement and approved by COR.
- B. Cold Weather: Follow the recommendations of ACI 306 or as specified to prevent freezing of concrete and to permit concrete to gain strength properly. Use only the specified non-corrosive, non-chloride accelerator. Do not use calcium chloride, thiocyanates or admixtures containing more than 0.05 percent chloride ions. Methods proposed for heating materials and arrangements for protecting concrete shall be made in advance of concrete placement and approved by COR.

**1.5 SELECT SUBBASE MATERIAL JOB-MIX**

Washed Stone: Shall be clean, open-graded gravel. Maximum size of aggregate shall be 1 inch. At least 75% shall be retained on a 1/4 inch sieve.

**1.6 SUBMITTALS**

Contractor shall submit the following.

- A. Manufacturers' Certificates and Data certifying that the following materials conform to the requirements specified.
  - 1. Expansion joint filler
  - 2. Hot poured sealing compound
  - 3. Reinforcement
  - 4. Curing materials
  - 5. Concrete Protective Coating
- B. Jointing Plan for all concrete areas.
- C. Concrete Mix Design.
- D. Concrete Test Reports
- E. Construction Staking Notes from Surveyor.
- F. Sieve and Test Reports: Select subbase material.

#### **1.7 APPLICABLE PUBLICATIONS**

The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the basic designation only. Refer to the latest edition of all referenced Standards and codes.

- A. American Association of State Highway and Transportation Officials (AASHTO):
  - M147-65-UL.....Materials for Aggregate and Soil-Aggregate Subbase, Base and Surface Courses (R 2004)
  - M148-05-UL.....Liquid Membrane-Forming Compounds for Curing Concrete (ASTM C309)
  - M171-05-UL.....Sheet Materials for Curing Concrete (ASTM C171)
  - M182-05-UL.....Burlap Cloth Made from Jute or Kenaf and Cotton Mats
- B. American Society for Testing and Materials (ASTM):
  - A82/A82M-07.....Standard Specification for Steel Wire, Plain, for Concrete Reinforcement
  - A185/185M-07.....Standard Specification for Steel Welded Wire Reinforcement, Plain, for Concrete
  - A615/A615M-12.....Standard Specification for Deformed and Plain Carbon Steel Bars for Concrete Reinforcement
  - A653/A653M-11.....Standard Specification for Steel Sheet, Zinc Coated (Galvanized) or Zinc Iron Alloy Coated (Galvannealed) by the Hot Dip Process
  - A706/A706M-09b.....Standard Specification for Low Alloy Steel Deformed and Plain Bars for Concrete Reinforcement

A767/A767M-09.....Standard Specification for Zinc Coated  
(Galvanized) Steel Bars for Concrete  
Reinforcement

A775/A775M-07b.....Standard Specification for Epoxy Coated  
Reinforcing Steel Bars

A820/A820M-11.....Standard Specification for Steel Fibers for  
Fiber Reinforced Concrete

C31/C31M-10.....Standard Practice for Making and Curing Concrete  
Test Specimens in the field

C33/C33M-11a.....Standard Specification for Concrete Aggregates

C39/C39M-12.....Standard Test Method for Compressive Strength of  
Cylindrical Concrete Specimens

C94/C94M-12.....Standard Specification for Ready Mixed Concrete

C143/C143M-10a.....Standard Test Method for Slump of Hydraulic  
Cement Concrete

C150/C150M-12.....Standard Specification for Portland Cement

C171-07.....Standard Specification for Sheet Materials for  
Curing Concrete

C172/C172M-10.....Standard Practice for Sampling Freshly Mixed  
Concrete

C173/C173M-10b.....Standard Test Method for Air Content of Freshly  
Mixed Concrete by the Volumetric Method

C192/C192M-07.....Standard Practice for Making and Curing Concrete  
Test Specimens in the Laboratory

C231/C231M-10.....Standard Test Method for Air Content of Freshly  
Mixed Concrete by the Pressure Method

C260/C260M-10a.....Standard Specification for Air Entraining  
Admixtures for Concrete

C309-11.....Standard Specification for Liquid Membrane  
Forming Compounds for Curing Concrete

C494/C494M-12.....Standard Specification for Chemical Admixtures  
for Concrete

C618-12.....Standard Specification for Coal Fly Ash and Raw  
or Calcined Natural Pozzolan for Use in Concrete

C666/C666M-03 (2008).....Standard Test Method for Resistance of Concrete  
to Rapid Freezing and Thawing

D1751-04 (2008).....Standard Specification for Preformed Expansion  
Joint Filler for Concrete Paving and Structural  
Construction (Non-extruding and Resilient  
Bituminous Types)

D4263-83(2012).....Standard Test Method for Indicating Moisture in  
Concrete by the Plastic Sheet Method.

D4397-10.....Standard Specification for Polyethylene Sheeting  
for Construction, Industrial and Agricultural  
Applications

C. American Welding Society (AWS):

D1.4/D1.4M (2005).....Structural Welding Code - Reinforcing Steel

## PART 2 - PRODUCTS

### 2.1 GENERAL

A. Concrete Type: Concrete shall be as per Table 1 - Concrete Type, air entrained.

TABLE I - CONCRETE TYPE

	Concrete Strength		Non-Air- Entrained	Air-Entrained	
	Min. 28 Day Comp. Str. Psi (MPa)	Min. Cement lbs/c. yd (kg/m <sup>3</sup> )	Max. Water Cement Ratio	Min. Cement lbs/c. yd (kg/m <sup>3</sup> )	Max. Water Cement Ratio
Type A	5000 (35) <sup>1,3</sup>	630 (375)	0.45	650 (385)	0.40
Type B	4000 (30) <sup>1,3</sup>	550 (325)	0.55	570 (340)	0.50
Type C	3000 (25) <sup>1,3</sup>	470 (280)	0.65	490 (290)	0.55
Type D	3000 (25) <sup>1,2</sup>	500 (300)	*	520 (310)	*

1. If trial mixes are used, the proposed mix design shall achieve a compressive strength 1200 psi (8.3 MPa) in excess of the compressed strength. For concrete strengths above 5000 psi (35 Mpa), the proposed mix design shall achieve a compressive strength 1400 psi (9.7 MPa) in excess of the compressed strength.

2. For concrete exposed to high sulfate content soils maximum water cement ratio is 0.44.

3. Determined by Laboratory in accordance with ACI 211.1 for normal concrete or ACI 211.2 for lightweight structural concrete.

B. Maximum Slump: Maximum slump, as determined by ASTM C143 with tolerances as established by ASTM C94, for concrete to be vibrated shall be as shown in Table II.

TABLE II - MAXIMUM SLUMP - INCHES (MM)

TYPE	MAXIMUM SLUMP*
Curb & Gutter	3 inches (75 mm)
Vehicular Pavement	2 inches (50 mm) (Machine Finished) 4 inches (100 mm) (Hand Finished)

Bollard Foundation	3 to 4 inches (75 to 100 mm)
* For concrete to be vibrated: Slump as determined by ASTM C143. Tolerances as established by ASTM C94.	

**2.2 REINFORCEMENT**

- A. The type, amount, and locations of steel reinforcement shall be as shown on the drawings and in the specifications.

**2.3 SELECT SUBBASE**

- A. Washed Stone: Shall be clean, open-graded gravel. Maximum size of aggregate shall be 1 inch. At least 75% shall be retained on a 1/4 inch sieve.

**2.4 FORMS**

- A. Use metal or wood forms that are straight and suitable in cross-section, depth, and strength to resist springing during depositing and consolidating the concrete, for the work involved.
- B. Do not use forms if they vary from a straight line more than 1/8 inch (3 mm) in any ten foot (3000 mm) long section, in either a horizontal or vertical direction.
- C. Wood forms should be at least 2 inches (50 mm) thick (nominal). Wood forms shall also be free from warp, twist, loose knots, splits, or other defects. Use approved flexible or curved forms for forming radii.

**2.5 CONCRETE CURING MATERIALS**

- A. Concrete curing materials shall conform to one of the following:
1. Burlap having a weight of seven ounces (233 grams) or more per yard (square meter) when dry.
  2. Impervious Sheeting conforming to ASTM C171.
  3. Liquid Membrane Curing Compound conforming to ASTM C309, Type 1 and shall be free of paraffin or petroleum.

**2.6 EXPANSION JOINT FILLERS**

Material shall conform to ASTM D1751-04.

**2.7 CONCRETE PROTECTION MATERIALS**

Linseed Oil mixture conforming to AASHTO M233.

**PART 3 - EXECUTION****3.1 SUBGRADE PENETRATION**

- A. Prepare, construct, and finish the subgrade as specified in Section 31 20 00, EARTHWORK.

- B. Maintain the subgrade in a smooth, compacted condition, in conformance with the required section and established grade until the succeeding operation has been accomplished.

### 3.2 SELECT SUBBASE

- A. Mixing: Proportion the select subbase by weight or by volume in quantities so that the final approved job-mixed formula gradation requirements will be met after subbase course has been placed and compacted.
- B. Placing:
  - 1. Place the mixed material on the prepared subgrade in a uniform layer to the required contour and grades, and to a loose depth not to exceed 8 inches (200 mm), and that when compacted, will produce a layer of the designated thickness.
  - 2. When the designated compacted thickness exceeds 6 inches (150 mm), place the material in layers of equal thickness. Remove unsatisfactory areas and replace with satisfactory mixture, or mix the material in the area.
  - 3. In no case will the addition of thin layers of material be added to the top layer in order to meet grade.
  - 4. If the elevation of the top layer is 1/2 inch (13 mm) or more below the grade, excavate the top layer and replace with new material to a depth of at least 3 inches (75 mm) in compacted thickness.
- C. Compaction:
  - 1. Perform compaction with approved hand or mechanical equipment well suited to the material being compacted.
  - 2. Moisten or aerate the material as necessary to provide the moisture content that will readily facilitate obtaining the specified compaction with the equipment used.
  - 3. Compact each layer to at least 95 percent or 100 percent of maximum density as specified in Section 31 20 11, EARTHWORK.
- D. Smoothness Test and Thickness Control: Test the completed subbase for grade and cross section with a straight edge.
  - 1. The surface of each layer shall not show any deviations in excess of 3/8 inch (10 mm).
  - 2. The completed thickness shall be within 1/2 inch (13 mm) of the thickness as shown on the Drawings.
- E. Protection:
  - 1. Maintain the finished subbase in a smooth and compacted condition until the concrete has been placed.

2. When Contractor's subsequent operations or adverse weather disturbs the approved compacted subbase, excavate, and reconstruct it with new material meeting the requirements herein specified, at no additional cost to the Government.

### **3.3 SETTING FORMS**

#### **A. Base Support:**

1. Compact the base material under the forms true to grade so that, when set, they will be uniformly supported for their entire length at the grade as shown.
2. Correct imperfections or variations in the base material grade by cutting or filling and compacting.

#### **B. Form Setting:**

1. Set forms sufficiently in advance of the placing of the concrete to permit the performance and approval of all operations required with and adjacent to the form lines.
2. Set forms to true line and grade and use stakes, clamps, spreaders, and braces to hold them rigidly in place so that the forms and joints are free from play or movement in any direction.
3. Forms shall conform to line and grade with an allowable tolerance of 1/8 inch (3 mm) when checked with a straightedge and shall not deviate from true line by more than 1/4 inch (6 mm) at any point.
4. Do not remove forms until removal will not result in damaged concrete or at such time to facilitate finishing.
5. Clean and oil forms each time they are used.
6. Make necessary corrections to forms immediately before placing concrete.
7. When any form has been disturbed or any subgrade or subbase has become unstable, reset and recheck the form before placing concrete.

- #### **C. The Contractor's Registered Professional Land Surveyor, specified in Section 01 00 00, GENERAL CONDITIONS, shall establish the control, alignment and the grade elevations of the forms. Staking notes shall be submitted for approval to the COR prior to placement of concrete. If discrepancies exist between the field conditions and the Drawings, Contractor shall notify COR immediately. No placement of concrete shall occur if a discrepancy greater than 1 inch (25 mm) is discovered.**

### **3.4 EQUIPMENT**

- A. The COR shall approve equipment and tools necessary for handling materials and performing all parts of the work prior to commencement of work.
- B. Maintain equipment and tools in satisfactory working condition at all times.

**3.5 PLACING REINFORCEMENT**

- A. Reinforcement shall be free from dirt, oil, rust, scale or other substances that prevent the bonding of the concrete to the reinforcement. All reinforcement shall be supported for proper placement within the concrete section.
- B. Before the concrete is placed, the COR shall approve the reinforcement placement, which shall be accurately and securely fastened in place with suitable supports and ties. The type, amount, and position of the reinforcement shall be as shown on the Drawings.

**3.6 PLACING CONCRETE - GENERAL**

- A. Obtain approval of the COR before placing concrete.
- B. Remove debris and other foreign material from between the forms before placing concrete.
- C. Before the concrete is placed, uniformly moisten the subgrade, base, or subbase appropriately, avoiding puddles of water.
- D. Convey concrete from mixer to final place of deposit by a method which will prevent segregation or loss of ingredients. Deposit concrete so that it requires as little handling as possible.
- E. While being placed, spade or vibrate and compact the concrete with suitable tools to prevent the formation of voids or honeycomb pockets. Vibrate concrete well against forms and along joints. Over-vibration or manipulation causing segregation will not be permitted. Place concrete continuously between joints without bulkheads.
- F. Install a construction joint whenever the placing of concrete is suspended for more than 30 minutes and at the end of each day's work.
- G. Workmen or construction equipment coated with foreign material shall not be permitted to walk or operate in the concrete during placement and finishing operations.
- H. Cracked or Chipped Concrete Surfaces and Bird Baths. Cracked or chipped concrete and bird baths will not be allowed. Concrete with cracks or chips and bird baths will be removed and replaced to the nearest joints, and as approved by the COR, by the Contractor with no additional cost to the Government.

**3.7 PLACING CONCRETE FOR CURB AND GUTTER**

- A. Place concrete in the forms in one layer of such thickness that, when compacted and finished, it will conform to the cross section as shown.
- B. Deposit concrete as near to joints as possible without disturbing them but do not dump onto a joint assembly.
- C. After the concrete has been placed in the forms, use a strike-off guided by the side forms to bring the surface to the proper section to be compacted.



- D. Consolidate the concrete thoroughly by tamping and spading, or with approved mechanical finishing equipment.
- E. Finish the surface to grade with a wood or metal float.

### **3.8 PLACING CONCRETE FOR VEHICULAR PAVEMENT**

- A. Deposit concrete into the forms as close as possible to its final position.
- B. Place concrete rapidly and continuously between construction joints.
- C. Strike off concrete and thoroughly consolidate by a finishing machine, vibrating screed, or by hand-finishing.
- D. Finish the surface to the elevation and crown as shown.
- E. Deposit concrete as near the joints as possible without disturbing them but do not dump onto a joint assembly. Do not place adjacent lanes without approval by the COR.

### **3.9 CONCRETE FINISHING - GENERAL**

- A. The sequence of operations, unless otherwise indicated, shall be as follows:
  - 1. Consolidating, floating, straight-edging, troweling, texturing, and edging of joints.
  - 2. Maintain finishing equipment and tools in a clean and approved condition.

### **3.10 CONCRETE FINISHING CURB AND GUTTER**

- A. Round the edges of the gutter and top of the curb with an edging tool to a radius of 1/4 inch (6 mm) or as otherwise detailed.
- B. Float the surfaces and finish with a smooth wood or metal float until true to grade and section and uniform in textures.
- C. Finish the surfaces, while still wet, with a bristle type brush with longitudinal strokes.
- D. Immediately after removing the front curb form, rub the face of the curb with a wood or concrete rubbing block and water until blemishes, form marks, and tool marks have been removed. Brush the surface, while still wet, in the same manner as the gutter and curb top.
- E. Except at grade changes or curves, finished surfaces shall not vary more than 1/8 inch (3 mm) for gutter and 1/4 (6 mm) for top and face of curb, when tested with a 10 foot (3000 mm) straightedge.
- F. Remove and reconstruct irregularities exceeding the above for the full length between regularly scheduled joints.
- G. Correct any depressions which will not drain. See Article 3.6, Paragraph H, above.
- H. Visible surfaces and edges of finished curb, gutter, and/or combination curb and gutter shall be free of blemishes, form marks, and tool marks, and shall be uniform in color, shape, and appearance.

**3.11 CONCRETE FINISHING FOR VEHICULAR PAVEMENT**

- A. Accomplish longitudinal floating with a longitudinal float not less than 10 feet (3000 mm) long and 6 inches (150 mm) wide, properly stiffened to prevent flexing and warping. Operate the float from foot bridges in a sawing motion parallel to the direction in which the pavement is being laid from one side of the pavement to the other, and advancing not more than half the length of the float.
- B. After the longitudinal floating is completed, but while the concrete is still plastic, eliminate minor irregularities in the pavement surfaces by means of metal floats, 5 feet (1500 mm) in length, and straightedges, 10 feet (3000 mm) in length. Make the final finish with the straightedges, which shall be used to float the entire pavement surface.
- C. Test the surface for trueness with a 10 foot (3000 mm) straightedge held in successive positions parallel and at right angles to the direction in which the pavement is being laid and the entire area covered as necessary to detect variations. Advance the straightedge along the pavement in successive stages of not more than one half the length of the straightedge. Correct all irregularities and refinish the surface.
- D. The finished surface of the pavement shall not vary more than 1/4 inch (6 mm) in both longitudinal and transverse directions when tested with a 10 foot (3000 mm) straightedge.
- E. The thickness of the pavement shall not vary more than 1/4 inch (6 mm).
- F. When most of the water glaze or sheen has disappeared and before the concrete becomes nonplastic, give the surface of the pavement a broomed finish with an approved fiber broom not less than 18 inches (450 mm) wide. Pull the broom gently over the surface of the pavement from edge to edge. Brooming shall be transverse to the line of traffic and so executed that the corrugations thus produced will be uniform in character and width, and not more than 1/8 inch (3 mm) in depth. Carefully finish the edge of the pavement along forms and at the joints with an edging tool. The brooming shall eliminate the flat surface left by the surface face of the edger.
- G. The finish surfaces of new and existing abutting pavements shall be flush and in alignment at their juncture.

**3.12 JOINTS - GENERAL**

- A. Place joints, where shown on the Shop Drawings and Drawings, conforming to the details as shown, and perpendicular to the finished grade of the concrete surface.
- B. Joints shall be straight and continuous from edge to edge of the pavement.

**3.13 CONTRACTION JOINTS**

- A. Cut joints to depth as shown with a grooving tool or jointer of a radius as shown or by sawing with a blade producing the required width and depth.
- B. Construct joints in curbs and gutters by inserting 1/8 inch (3 mm) steel plates conforming to the cross sections of the curb and gutter.
- C. Plates shall remain in place until concrete has set sufficiently to hold its shape and shall then be removed.
- D. Finish edges of all joints with an edging tool having the radius as shown.

**3.14 EXPANSION JOINTS**

- A. Use a preformed expansion joint filler material of the thickness as shown to form expansion joints.
- B. Material shall extend the full depth of concrete, cut and shaped to the cross section as shown, except that top edges of joint filler shall be below the finished concrete surface where shown to allow for sealing.
- C. Anchor with approved devices to prevent displacing during placing and finishing operations.
- D. Round the edges of joints with an edging tool.
- E. Form expansion joints as follows:
  - 1. Without dowels, about structures and features that project through, into, or against any site work concrete construction.
  - 2. Using joint filler of the type, thickness, and width as shown.
  - 3. Installed in such a manner as to form a complete, uniform separation between the structure and the site work concrete item.

**3.15 CONSTRUCTION JOINTS**

- A. Locate longitudinal and transverse construction joints between slabs of vehicular pavement as shown on the Shop Drawing jointing plan and Drawings.
- B. Place transverse construction joints of the type shown, where indicated and whenever the placing of concrete is suspended for more than 30 minutes.
- C. Use a butt-type joint with dowels in curb and gutter if the joint occurs at the location of a planned joint.
- D. Use keyed joints with tiebars if the joint occurs in the middle third of the normal curb and gutter joint interval.

**3.16 FORM REMOVAL**

- A. Forms shall remain in place at least 12 hours after the concrete has been placed. Remove forms without injuring the concrete.

- B. Do not use bars or heavy tools against the concrete in removing the forms. Promptly repair any concrete found defective after form removal.

### **3.17 CURING OF CONCRETE**

- A. Cure concrete by one of the following methods appropriate to the weather conditions and local construction practices, against loss of moisture, and rapid temperature changes for at least seven days from the beginning of the curing operation. Protect unhardened concrete from rain and flowing water. All equipment needed for adequate curing and protection of the concrete shall be on hand and ready to install before actual concrete placement begins. Provide protection as necessary to prevent cracking of the pavement due to temperature changes during the curing period. If any selected method of curing does not afford the proper curing and protection against concrete cracking, remove and replace the damaged pavement and employ another method of curing as directed by the COR.
- B. Burlap Mat: Provide a minimum of two layers kept saturated with water for the curing period. Mats shall overlap each other at least 150 mm (6 inches).
- C. Impervious Sheeting: Use waterproof paper, polyethylene-coated burlap, or polyethylene sheeting. Polyethylene shall be at least 4 mils (0.1 mm) in thickness. Wet the entire exposed concrete surface with a fine spray of water and then cover with the sheeting material. Sheets shall overlap each other at least 12 inches (300 mm). Securely anchor sheeting.
- D. Liquid Membrane Curing:
  - 1. Apply pigmented membrane-forming curing compound in two coats at right angles to each other at a rate of 200 square feet per gallon (5 m<sup>2</sup>/L) for both coats.
  - 2. Do not allow the concrete to dry before the application of the membrane.
  - 3. Cure joints designated to be sealed by inserting moistened paper or fiber rope or covering with waterproof paper prior to application of the curing compound, in a manner to prevent the curing compound entering the joint.
  - 4. Immediately re-spray any area covered with curing compound and damaged during the curing period.

### **3.18 CLEANING**

- A. After completion of the curing period:
  - 1. Remove the curing material (other than liquid membrane).
  - 2. Sweep the concrete clean.
  - 3. After removal of all foreign matter from the joints, seal joints as specified.

4. Clean the entire concrete of all debris and construction equipment as soon as curing and sealing of joints has been completed.

### **3.19 PROTECTION**

- A. The contractor shall protect the concrete against all damage prior to final acceptance by the Government. Remove concrete containing excessive cracking, fractures, spalling, or other defects and reconstruct the entire section between regularly scheduled joints, when directed by the COR, and at no additional cost to the Government. Exclude traffic from vehicular pavement until the concrete is at least seven days old, or for a longer period of time if so directed by the COR.
- B. Protective Coating: Protection costing is not required if concrete will be in place for a cumulative time of six weeks at a continuous minimum temperature of 5 °C (40 °F), other coating is required. Apply protective coating of linseed oil mixture to exposed-to-view concrete surfaces, drainage structures, and features that project through, into, or against the items constructed under this section to protect the concrete against the action of deicing materials.
  1. Application: Complete backfilling and curing operation prior to applying protective coating. Concrete shall be surface dry and thoroughly clean before each application. Give the concrete surface at least two applications. Coverage shall not be more than 11 m<sup>2</sup>/L (50 square yards per gallon) for first application, and not more than 16 m<sup>2</sup>/L (70 square yards per gallon) for the second application, except when the number of applications and coverage for each application for commercially prepared mixture shall be in accordance with the manufacturer's instructions. Protect coated surfaces from vehicular and pedestrian traffic until dry.
  2. Precautions: Do not heat protective coating, and do not expose the protective coating to open flame, sparks, or fire adjacent to open containers or applicators. Do not apply material at temperatures lower than 10°C (50°F).

### **3.20 FINAL CLEAN-UP**

Remove all debris, rubbish and excess material from the Station.

- - - E N D - - -