



APC Precision-Pac™ Integral Colors

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Smoke 5lbs per CY	Pecan 7lbs per CY	Bamboo 10lbs per CY	Dark Ochre 12.5lbs per CY	Ole Hickory 14lbs per CY
				
Salt Lake Gray 15lbs per CY	Terracotta 15lbs per CY	Oyster 15lbs per CY	Santa Fe 15lbs per CY	Greige 15lbs per CY
				
Mesa Stone 5lbs per CY	Straw 5lbs per CY	Khaki 5lbs per CY	Mint 5lbs per CY	Alabama Ochre 7.5lbs per CY
				
Plum 10lbs per CY	Char Green 10lbs per CY	Camel 10lbs per CY	Dove Gray 10lbs per CY	Cinnamon 10lbs per CY
				
Greystone 10lbs per CY	Augusta Gold 15lbs per CY	Port City Buff 15lbs per CY	Wine Berry 20lbs per CY	Charcoal 20lbs per CY
				
Nutmeg 20lbs per CY	Red Mountain 20lbs per CY	Piedmont Soil 20lbs per CY	Slate 20lbs per CY	Old Brick 20lbs per CY
				
Sandstone 25lbs per CY	Talladega Tan 25lbs per CY	Bristol Brown 25lbs per CY	Black 30lbs per CY	Midnight 35lbs per CY

Colors shown approximate the shade of color based on a 5 sack mix (3000psi) using Grey Type 1 cement at a 4" slump. Variations can be expected due to differences in cement color, slump, aggregates, admixtures and method of application. Colored concrete should be batched, placed, and cured as directed in the APC data sheet on recommended procedures for colored concrete. We recommend that a test slab be poured and approved prior to the start of the job. Colors shown are representative of integrally colored concrete sealed with one of APC's decorative concrete sealer products.

Precision-Pac™ Integral Color for Concrete

APC: Iron oxide pigments are used in ready mix, pre-cast, tilt-up, ornamental concrete, shotcrete, mortar, concrete masonry units, pavers, roof tiles, and retaining wall units. Additional uses are to color stucco, plaster, cast stone, and many other cement-based construction materials.

Materials: APC Precision-Pacs™ are permanent, light-fast, inert and stable to atmospheric conditions. APC colors comply with ASTM C979, Pigments for Integrally Colored Concrete. Integral colors are not designed for dust-on application.

Packaging: APC Precision-Pacs™ are packaged in pre-measured per cubic yard repulpable bags. Precision-Pacs™ may be tossed into mixer without opening or pouring. The mixing action disintegrates the bag allowing the pigment to disperse throughout the mix. Select colors are available in standard 50lb paper bags, 2000lb super sacs, and bulk tanker loads. Quality is assured by a batch label system that tracks the product through production to the warehouse and to your job site. Standard packaging is based on a 5 sack mix (3000psi) per cubic yard.

Mix Design: Make sure to use the same mix design and a consistent water to cement ratio throughout the job with a consistent slump between 4" to 6". Color variation may occur if batch proportion and slump are not maintained from load to load. Keep all raw materials (sand, cement, and aggregates especially) as consistent as possible throughout the entire project. Changes in raw materials (size, color, moisture content) affect the final color. Remember water has a vast affect on final color. Adding too much water will lighten the color of the project giving it a pale or washed out look. When better flow ability is required, use a plasticizer or water-reducing admixture. Calcium chloride or any chloride based accelerator should not be used. Chloride based additives will cause discoloration in the finished project.

Mixing Color:

Batch Plant - When mixing at batch plant, truck mixers should be thoroughly cleaned prior to use. For best results add two-thirds of the water and one-half of the aggregates to the drum. Add Precision-Pacs to the drum. Mix at full charging speed for three minutes or until bags break apart and pigment is dispersed evenly. Add balance of ingredients and mix at full charging speed for 8-12 minutes (120-150 revolutions).

Job Site- APC Precision-Pac™ Integral Color can also be added at the job site. Add bags to drum and mix for 10-12 minutes (120-150 revolutions). Order concrete at a workable slump (4"-6") and always keep water addition to a minimum. Make every effort to maintain consistency with multiple loads. Water addition can lead to inconsistent color.

Additional Items for the Contractor

APC recommends following similar procedures for colored and uncolored concrete regarding base preparation, use of vapor barriers, form placement, reinforcement and joints. Integrally colored concrete should be installed the same way as high quality uncolored concrete. Listed are additional guidelines that should be observed for colored concrete. For more detailed information, please review our color guide.

- **Avoid adding extra water at the job site. Do not wet finishing tools or add water to the surface of the colored concrete.**
- **When the surface becomes wet, stop floating. Allow bleed water to evaporate, then begin troweling. Waiting too long, may allow dark spots or "burn" marks to appear.**
- **Do not use wet coverings, plastic sheeting, water proof paper, or liquid membrane curing compounds.**
- **Even curing + even drying = even color.**
- **Pigment loading should never exceed 10% of the weight of the cement content.**
- **Consistency = Reliability.**
- **Do not sprinkle pigment onto the surface of the concrete.**
- **Complete the job by sealing your project with one of APC's Precision-Seal™ products.**
- **Contact your local sales person for pump mix design color requirement.**

Efflorescence is a naturally occurring process. It is a white powdery substance that may occur on the surface of the concrete. This is a result of water evaporation and is more noticeable on colored concrete. Proper curing and protection from water penetration will help reduce the effects of efflorescence. If efflorescence occurs, care should be taken to clean the surface. Use APC Precision Clean & Etch for cleaning colored concrete and be sure to seal with an APC Precision sealer. APC Cure - Seal 25 is designed to be applied to freshly placed concrete as soon as the finishing process is completed. This product seals and protects, assures proper curing and will help to prevent efflorescence. Please refer to APC product label and data sheets for proper application. Always follow manufacturer's recommendations carefully.

09/19



Birmingham Zoo • Birmingham, Alabama
Precision-Pac™ Integral Color



Auburn University • Auburn, Alabama
Dark Ochre Integral



Taco Bell • Oak Ridge, Tennessee
Midnight Integral



Payne Stewart Golf Course • Branson, Missouri
Dark Ochre Integral