

HVLP Airgun Application of **KrystalKote™ (CalTrans Formula)** Graffiti-Resistant Polyurethane Coating to **Traffic Signage**

SURFACE PREPARATION

Refer to the **KrystalKote™ Data Sheet** for product preparation prior to application.

- 1.) The sign surface to be coated must be completely clean of all contaminants prior to application: including factory release agent, oil, grease, dust, powder, water, etc. Refer to sign manufacturer's instructions on normal cleaning procedures for product to be coated.
- 2.) *Reflective sheeting* signs require a moderate wipe-down with Acetone to remove fingerprints, etc., and to prepare surface to receive **KrystalKote™**. Wipe with Acetone-damp cloth until surface feels "tacky" as cloth is wiped across. Light, white swirl marks are normal, and will disappear completely when **KrystalKote™** is spray-applied. Allow no more than 5- to 10-minutes to elapse between surface prep wipe-down and spray-application. *Reflective sheeting* surface should be slightly "tacky", and not re-harden.
- 3.) Previously used, or field-mounted *reflective sheeting* signs may require the use of a non-damaging graffiti-remover or surface cleaner prior to wipe-down as outlined in step #2 above. Extreme caution should be to avoid damaging sheeting during cleaning.

APPLICATION: CLEAR COATING

QUALIFIED, PROFESSIONAL APPLICATION RECOMMENDED

Equipment & materials requires:

- ▶ "Wet Film Thickness (WFT) gauge;
- ▶ Conventional or HVLP air-spray equipment;
- ▶ Proper air delivery system (compressor, reservoir, moisture trap, regulators, etc.);
- ▶ Methyl Ethyl Ketone (M.E.K.) or Acetone (E.E.K.) as thinning solvent, if needed;
- ▶ Lacquer Thinner, M.E.K., Acetone, or Toluene as equipment cleaning solvent;
- ▶ Proper OSHA protective clothing and activated-charcoal filtered breathing mask apparatus.

Spray Equipment Selection Guide: Suitable equipment from other manufacturers may be used. Changes in pressure and tip sizes may be needed for proper spray characteristics.

Recommended: Standard commercial spray gun equipment, such as Binks Model 2001 (Conventional) or Mach 1 (HVLP), or equal. Separate air & fluid pressure regulators, and moisture & oil trap in main air supply line, are recommended. A mechanical pot agitator can be used. With conventional spray, use adequate air pressure/volume to ensure proper atomization (i.e. portable: 5- to 11-h.p. compressor with 10- to 20-gallon tank). Recommended fluid nozzle: .046" (.055" ave.) to .070" orifice.

- 1.) Using a drill-mounted impeller, thoroughly mix clear **KrystalKote™ Curing Agent** into clear **KrystalKote™ Base Compound** until uniform, as outlined on *Base* label and **KrystalKote™ Data Sheet**. To avoid excess bubbles in product, do not mix by shaking. Up to 5% by weight (nearly 10% by volume) of M.E.K. or Acetone may be added as a thinning agent, if needed, to facilitate flow of sprayed **KrystalKote™**.
- 2.) Mix no more CalTrans Formula than can be easily applied within @ 3-hours. Normal pot life is 3½- to 4-hours at 77°F. A cold weather "accelerator" is available to shorten cure time, but will also shorten pot life. A hot weather "retarder" is also available to lengthen pot life, but will also lengthen cure time. Additives and instructions are available from **TradeWinds International, Inc.**

KrystalKote™ (CalTrans Formula)

Application to Traffic Signs

(continued)

- 3.) Clean and flush equipment with approved, standard solvent before use.
- 4.) A properly "prepped" *reflective sheetings* should be slightly "tacky", with light swirl marks. To prepped reflective sheeting sign, apply **CalTrans Formula** at 3½- to 5-mil WFT in even parallel passes, overlapping 50% each pass, and cross spray at right angles, to avoid pinholes and thin areas (aka "holidays"). For optimum results, **DO NOT APPLY TOO SLOWLY**, nor **TOO HEAVILY**.
- 5.) Check wet coating thickness with WFT Gauge: 6-mil WFT will dry to @ 5-mil DFT; 5-mil WFT will dry to @ 4-mil DFT; 4-mil WFT will dry to @ 3-mil DFT, and 3-mil WFT will dry to @ 2.5-mil DFT
- 6.) Use caution when applying **CalTrans Formula** to avoid excessive WFT, which may cause clouding of clarity, due to trapped micro-bubbles. Two thin coats may be easier to apply than one heavy coat. A second coat should be applied when the first coat is "tack dry" (tacky, but not wet) or "dry-to-touch". See CURE TABLE.
- 7.) Clean all equipment with Acetone, Lacquer Thinner, M.E.K., Toluene, or similar solvent, immediately after use.
- 8.) Allow at least 8-hours dry time at 77°F before stacking newly **KrystalKote™**-protected signs.
- 9.) Allow at least 24-hours at 77°F before field-mounting newly **KrystalKote™**-protected signs.
- 10.) Allow at least 72-hours cure time at 77°F before attempting to remove graffiti from newly **KrystalKote™**-protected signs

KrystalKote™ is a registered trademark (pending) of:

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