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www.roll-on.com

ROLL-ON® SKATE FLOOR COATING ONE-PART URETHANE

Preparation and Application Instructions

- Store indoors only.
- Keep from freezing.
- Store all containers at room temperature for 48 hours prior to application.
- Approximate storage shelf life: 12 months from date of manufacture
- MSDS for this product is available at www.roll-on.com.
- Fire Rating Reports for this product are available at www.roll-on.com.
- DOT Hazardous Spill information available at www.roll-on.com.

 **STOP! READ INSTRUCTIONS ON ALL PAGES!**

Skate floor surface MUST BE absolutely free of dirt, surface oils and contaminants of any kind before proceeding.

Regardless of your previous experience with our products, please read before coating. This brochure is a thorough review of preparation and application procedures. We are also including some important tips to improve your coating experience and shorten the duration of your coating time.

Materials and Tools Needed:

- 1 or more floor polisher(s)
- #80 Grit Screen back pads or #80 Grit Sand paper
- Push Brooms
- Wide area or other vacuum cleaner(s)
- 2 gallon plastic watering can with shower head
- 1 – 2 foot square piece of window screen as a strainer
- Terrycloth bath towels
- Mineral Spirits for clean up
- 1 or more 18” – 3/8” Nap industrial roller(s) and Frames(s)

 **STOP!** Using a T-bar or Padco Applicator may void all warranties associated with this product.

Results using a T-bar or Padco Applicator can vary depending on the person using it. As one pulls the bar, the speed and force of the pull can cause the bar to float (hydroplane) over the coating being applied increasing the amount of the coating that is being laid down, leading to unsatisfactory results. Thinning and thickening of the final coating may result. **DO NOT APPLY when ambient humidity is above 50%.**

PRECAUTIONS WHEN PREPARING OR APPLYING THIS PRODUCT

Roll-on® 340 VOC g/L **HIGHER SOLIDS EFFECT DRYING TIMES:**

Roll-on® 340 g/L contains a lower volume of drying agents than Regular Roll-on® Skate Floor Coating. The reduction in drying agents increases the thickness of the product and **naturally slows its drying time by about 20%** when compared to Regular Roll-on®. Please note this fact in this brochure.

AVOID COATING DURING ELEVATED HUMIDITY OR RAINY CONDITIONS:

**DRYING TIMES CAN BE CRITICALLY EXTENDED
DUE TO HIGHER HUMIDITY ABOVE 50%.**

PROPER VENTILATION IS A MUST! All air-dried products use oxygen to cure and harden. Humid conditions reduce oxygen levels in the building, but so too does closing up the building after application of the coating.

- It is suggested to stop venting and close the building while coating and 4 to 6 more hours allowing the coating a slow cure. Open and ventilate the building for the duration of the curing process 4 to 6 hours after completion of the coating.
- Air **MUST NOT** be applied directly down onto the floor's surface.
- Proper ventilation is allowing outside air to enter the building while air within the building is vented back outside.
- Some air conditioning systems are **circulating systems** and do not draw air from the outside while operating.
- Locate and activate the "vent" settings on air conditioning systems while the floor coating is curing.
- **Open doors and windows when possible after 4 hours.**
- Do not allow air flow to be directed down at the floor coating – air rushing across the floor, not down on it, balances the drying process.

**NO MATTER HOW FAMILIAR YOU ARE WITH OUR PRODUCTS,
ALWAYS CHECK THE LABELS ON THE CANS AS WELL AS THE
BROCHURES SUPPLIED WITH YOUR PRODUCTS TO BE CERTAIN YOU
HAVE ALL THE LATEST INFORMATION TO COMPLETE PREPARATION AND
APPLICATION OF THIS PRODUCT SUCCESSFULLY.**

This methods bulletin is to be used only by appropriately trained persons in conjunction with such training. IMPROPER USE OR OPERATION OF CHEMICALS OR EQUIPMENT POSES RISK OF PHYSICAL INJURY OR PROPERTY DAMAGE. Specific risks include, but are not limited to, burns, and improper application of chemical products (e.g. wrong product, wrong product combinations, improper applicator use, and improper curing.) Because successful and safe application is the responsibility and obligation of the trained applier, the manufacturer disclaims any and all warranties, express or implied, including warranties of MERCHANTABILITY or FITNESS OF PURPOSE. The manufacturer shall have no obligation except to replace repair, or pay for, in its sole discretion, any chemical product or equipment shown to be defective.

No person has authority to waive these disclaimers or make any representations or warranties on behalf of the manufacturer, except in writing signed by the manufacturer.

If you have not had training with the particular product or equipment discussed in these guidelines that you intend to use, please call: Roll-on Floor Systems, LLC 817-571-2438 to discuss and arrange training.



VENTILATION SUGGESTION:

Close all open flames and ventilate until application. Cease ventilation for the duration of application. Allow 4 hours and then

STEP 1 SANDING/ABRADING

Before applying **Roll-on® Skate Floor Finish**, abrade the existing skating surface to a dull finish with #80 grit mesh screens or #80 grit sand paper under large **rotary floor polishers**. An **automatic floor scrubber may be used** for this procedure. If using an automatic floor scrubber abrade the surface with heaving pressure setting DRY - **do not use water or cleaners in the scrubber**.



NOTE Change your paper or screens! If using sandpaper, Change paper after 500 square feet per disk. Mesh should be turned over after 500 square feet and discarded after 1,000 square feet per disk. Failure to change paper or screens at this rate usually results in polishing the surface even when it appears to be abrading it. Peeling or chipping may result when over-extending the intended life of the discs.

STEP 2 REMOVING DUST – TACKING THE FLOOR



NOTE NEVER USE STRING MOPS OR TREATED DRAG MOPS TO PREPARE, CLEAN OR MAINTAIN YOUR SKATE FLOOR!

- Vacuum the abraded skating surface with a drum or canister vacuum.
- Drag the surface carefully by soaking a large terrycloth towel in a bucket of **CLEAR WATER. (DO NOT USE DETERGENTS OR SOLVENTS.)**
- Wring out the towel of excess water
- **Be prepared to change the water frequently.**
- Using a 24" or 36" push broom or squeegee, push the towel across the width of the skating surface (**NOT THE LENGTH**). Upon reaching the other side, turn the towel over. The clean damp side is now face-down to the surface. Push it back to the other side. Overlap a little for a cleaner surface.
- Soak the used towel in clean water, wring out and repeat the process

Your floor MUST BE CLEAN AND DUST FREE TO CONTINUE

Repeat Step 2 – Cleaning until the sanded skating surface is dust free.

STEP 3 PREPARING ROLL-ON® SKATE FLOOR FINISH

IMPORTANT: Apply at room temperature - 68 to 74 degrees (F). Allow good ventilation 4 HOURS AFTER COMPLETION. Avoid flames and prolonged contact with skin. Wear disposable gloves to keep hands clean.

DO NOT DILUTE OR ADD THINNERS TO ROLL-ON® COATINGS!

CLEAR Roll-on®

- Pour the *Roll-on®* skate floor finish from the container through a fine mesh wire strainer into a two-gallon garden-type sprinkling can to remove any impurities formed during storage.

TIP● Pouring the Roll-on® Skate Floor Finish from the container through a strainer made from window screen into the two gallon garden-type sprinkling can removes impurities formed during storage.

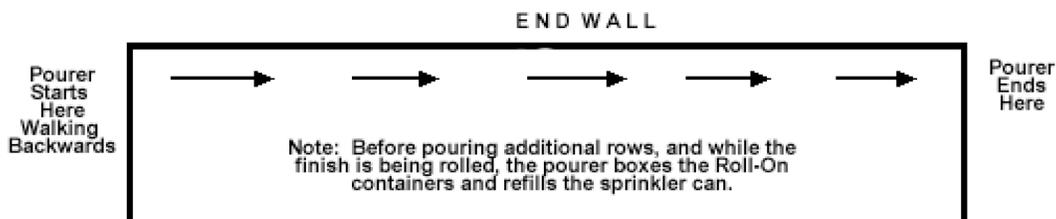
STEP 4 APPLYING ROLL-ON® SKATE FLOOR FINISH

1. Using the garden type sprinkler can, start at one side of the rink approximately 36 inches from the end wall or railing.
2. Walk backwards at a normal pace across the width (not the length) of the skating surface while pouring Roll-on® in an 18 - 24 inch wide zigzag pattern.
3. Pour evenly and steadily. Average use is between 1 and 1 ½ gallons per 60 to 70 feet of width. It is important to pour only enough material to maintain 500 square feet per gallon coverage.

TIP ● CONTROLLING THE RATE OF APPLICATION

Divide the rink by the number of pails expected to be applied. **For example:** If a floor measures 170' x 70 = 5 pails (25 gals.) should be applied. Divide the 170' length by the 5 pails. The result is 34. Mark each 34 feet along the length the rink with a piece of easily seen tape on the wall. Each time a pail becomes empty, check your progress compared to the markings.

DIAGRAM A



STEP 5 ROLLING ROLL-ON® SKATE FLOOR FINISH

Use 3/8" or 1/2" nap, 18" Wide commercial rollers with long handles.



NOTE Applicators made from Lamb's wool such as EZ-WAY brand and Weighted Applicators such as Padco brand, present certain risks: The EZ-WAY (or other Lambs Wool Applicators) may leave thick ridges of material trailing off one edge or another –as a squeegee does. A Weighted Applicator leaves the material too thin – often spreading at 1,000 square feet per gallon causing the dried material to loose strength and integrity. The weighted applicator may also “bridge” a low spot in the floor leaving a surplus of material which dries poorly. Thinning the material or application by squeegee is never recommended.

- While *Roll-on*® is being poured, **Roller Person 1** begins at the same side of the rink as the pourer. Roll the material at an easy pace, using five to six foot long strokes until reaching the center of the floor. The pourer, walking backwards, passes the center of the floor where **Roller Person 2** is waiting. Roller Person 2 completes the second half of the floor using the same technique as roller person 1. It is not necessary for one roller person to wait for the other to begin rolling. The two persons rolling, in this example complete the line while the person pouring returns to the pails to reload his sprinkler can.

ROLLING TIPS ● Do not “over-roll” the material – passing the rollers often over the same area may cause air bubbles to dry in place. Roll with Light Pressure only. All persons rolling **MUST** end at the same straight line with each pour. To achieve uniform coverage while rolling, overlap each roller pass 3 to 4 inches using smooth, even and steady strokes.

STAFFING TIPS ● If coating 10,000 square feet and using one person mixing the pails, one person pouring for the rollers and 2 persons rolling – a total of 4 persons, the entire task should take no more than 1 ½ hours. Adding one more person rolling can reduce the application time up to 20%.

STEP 6 - CLEAN UP

Use mineral spirits or paint thinner immediately after coating. The large 18” rollers hold so much material it is often most economical to properly dispose of them.

STORAGE TIP ● After application, transfer excess Roll-on® to new, one-gallon paint containers with lids. Reducing air space in the storage containers extends the shelf-life of the material. Shelf life is approximately 12 months, properly stored.

For traffic circles, numbers, lines and graphics, we recommend *Roll-on*® Circle and Line paint, Oil Based Rust-Oleum® Professional High Performance Protective Enamel, Sherwin Williams® All Surface Enamel.



Firefly black-light responsive additive is available for all coatings we produce. It enhances black light effects in any skating center. Ask your distributor about **FIRE-FLY floor coating additive**.

Roll-on® Coverage per Gallon . . . 450 sq. ft.

Coating Time average 2 hours

Drying Times: To walk on 12 – 24 hours

To skate on 24 hours

Applying additional coats: 24-48 hours

Drying Times Depend On:

Floor and material temperature (68-72 degrees)

Air exchange, circulation and humidity Levels.

FOR NEWLY INSTALLED OR COMPLETELY SANDED - VIRGIN - HARDWOOD SKATE FLOOR COATING, WE RECOMMEND TWO COATS OF OIL MODIFIED URETHAN SEALER FOR WOOD SPORT FLOORS SUCH AS:
Bona Sport® Sport Seal 350

PRIOR TO TWO FINISH COATS OF ROLL-ON®



\$? Why spend more money? When recoating **One coat is often enough for one skating season.** **Two coats do not last twice as long!**

MAINTENANCE

For a durable, slip-resistant surface, skating floors must be kept clean. Poor maintenance will result in a slippery skating surface.



NOTE – Never use string mops or treated drag mops

to prepare, clean or maintain your skate floor coating. **Nearly ALL floor cleaners sold leave oily residues!** Please contact your Roll-on® distributor for recommendations for **nonresidue** skate floor finish cleaners.

- Clean floor weekly with an Automatic Floor Scrubber using Traction Skate Floor Cleaner non-residue concentrate.
- **Drag floor daily with an *UNTREATED* dry mop.**
- If an Automatic Scrubber is not available: clean floor as needed by soaking a large towel in a bucket of clear water or Traction non-residue skate floor cleaner. Wring out and wrap the towel around a 36" push broom. Push the towel across the Width of the skating surface (NOT THE LENGTH). Upon reaching the other side, turn the towel over so that the clean side is face down to the surface and push it back to the other side. Overlap a little for cleaner surface. Soak and wring the towel again and repeat this process until the floor has been cleaned.

We control our mixtures in the factory and issue certificates of compliance and quality with each batch. We cannot control the environment where it is prepared and applied.

PROBLEM OBSERVED	POSSIBLE CAUSES
ALLIGATOR SKIN	Additional coating applied too soon
ALLIGATOR SKIN	Excessive coating upon application
ALLIGATOR SKIN	Material was allowed to puddle
ALLIGATOR SKIN	Too much air flow directly on to or across the surface
BLACK STREAKS - over time	Moisture has been present - possibly mold
BUBBLING	Aggressively shaking before application
BUBBLING	High temperatures during application
BUBBLING	Mixing the product with a high-speed mixer before application
BUBBLING	Repeatedly passing over the product with rollers
FINE DIRT PARTICLES	Distributed from ventilation system
FINE DIRT PARTICLES	Enter from open doors or windows
FINE DIRT PARTICLES	Lint from applicator
FISH EYES	Contaminated surface; Likely oil, grease, soap film or silicone
FISH EYES	Room or Surface Temperature too high
FISH EYES	Too much air flow across surface
HAZY FINISH	Presents of moisture - possible high humidity
PEELING - immediate	Improper floor preparation
PEELING - immediate	Screens or sand paper not changed frequently during preparation
PEELING - immediate	Surface not properly sanded and cleaned
PEELING - over time	Contamination causing gradual delaminating
PEELING - over time	Contamination prior to coating
PEELING - over time	Improper floor preparation
PEELING - over time	Introduction of sub-surface moisture
PUDDLING	See wrinkling or alligator skin or Streaking
SLOW DRYING	High humidity
SLOW DRYING	Lack of ventilation after application
SLOW DRYING	Low Surface temperatures
STREAKING	High surface or room temperature
STREAKING	Product applied too thick
STREAKING	Product applied too thin
STREAKING	See also Puddling
STREAKING	Vents or fans discharging air directly onto the surface
SWIRL MARKS BELOW	Coating too thin
SWIRL MARKS BELOW	Scuffing pads too heavy
WRINKLING	Excessive coating upon application
WRINKLING	Material was allowed to puddle
WRINKLING	Puddling in a low spot on the floor surface
WRINKLING	Recoating too soon
WRINKLING	Too much air flow directly on to or across the surface

Never use steel wool to abrade the previous coating during preparation. Follow suggestions in this brochure for proper clean-up after preparations. Never use string mops and buckets or drag mops to tack the surface before application. Never use treated drag mops on skate floors. We recommend frequent use of larger untreated micro-fiber drags.

WHAT ARE THE DIFFERENCES?

	OIL BASED ROLL-ON®	WATER BASED TRACTION
VOC Compliance	ALL solvent based products from Roll-on® are <340 g/L VOC and compliant in all States. Check with your distributor to determine which product is permitted for use in your state.	<u>Traction®</u> <240 g/L VOC - Compliant in all US states and all countries with similar coefficient of friction of Roll-on®. <u>There is nothing like it.</u>
Durability	One season durability.	Proven one season or more durability. Leaning toward two-season durability.
Adhesion	Excellent adhesion. Forms weak bonds with latex paints and unregulated oil base paint substrates.	Excellent adhesion to most substrates; better elasticity than oil.
Color Retention	Colors limited due to amber cast of the tongue-oil in the coating.	Superior resistance to chalking and fading when exposed to ultra-violet light. Clear coat only. Applied over any color.
Ease of Application	Goes on with greater film thickness for good one-coat hiding and coverage.	Goes on thin, smooth and evenly, with little applicator drag - two coats are usually required. Total quantity applied in two coats is the same as Roll-on quantity in one coat.
Mildew Resistance	Oil bases can provide nutrients for mildew growth; most products contain mildewcide to minimize growth.	Less likely to grow mildew; mildewcide additives discourage mildew growth, help maintain fresh appearance.
Versatility	Can be used on most materials. For new concrete and other substrates a primer or pre-treatment is required.	Can be used on most materials. Pre-treatment or primer often less aggressive, can over-coat less costly sealants and primers more easily.
Odor	Odor can linger for days when coating with solvent based products.	Water based products are very low odor, clearing from clothing and a building's interior quickly.
Cleanup	Turpentine, paint thinner or other solvent.	Simple water cleanup.
Drying Time	Eight to 24 hours. Can usually be skated on within 24 hours.	One to six hours, permitting quick recoating. Can be skated on within 24 hours.
GREEN	YES	YES
Color Options	Clear (amber), Light Aqua Blue.	A great many custom colors from factory recommended paint suppliers only.
Coefficient of Friction (Grip)	Roll-on® is Highest of all solvent based coatings manufactured in the world. <u>Excellent for Competitive Skating.</u>	Matches Roll-on® using James Friction Machine. 30% higher than average Water-based Gym finishes. <u>Excellent for Competitive Skating.</u>
Preparation	Light screening between coats of the same product. Heavier sanding when coating over dissimilar products.	Light screening when coating over MOST previous coatings.
Spread Rate	450 square feet per gallon per coat.	Total Two Coats: 450 square feet per gallon.