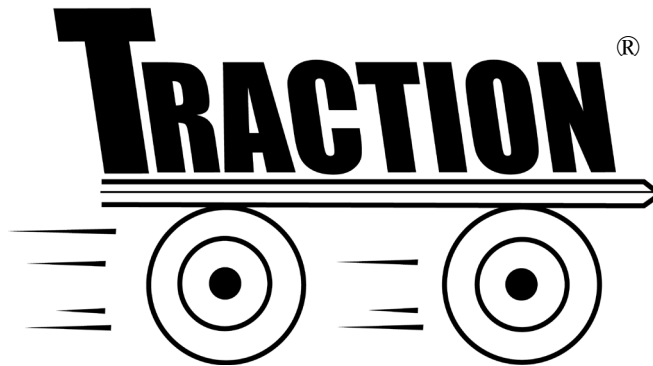


RECOATING

SKATE FLOOR RECOATING

Preparation and Application Methods



STOP!

READ THIS ENTIRE BULLETIN BEFORE PROCEEDING

EASIER PREPARATION

- ENDS SANDING AND SCREENING BETWEEN COATS!

MORE ECONOMICAL APPLICATION

- SHORTER PREPARATION AND APPLICATION TIMES
- FEWER PEOPLE INVOLVED IN ALL PHASES

NO OFFENSIVE ODOR

- LEAVES THE BUILDING WITH A "JUST CLEANED" SMELL!

DO NOT APPLY IF THE FOLLOWING CONDITIONS EXIST

New or freshly sanded wood: Traction® Skate Floor Coating is a finish and should not be applied directly to new, unsealed wood floors or floors that have been sanded to bare wood. Refer to Traction® Sealer Bulletin.

Peeling or poorly bonded finishes: If the previous finish is peeling, flaking or otherwise not adhering, Traction® should not be applied.

Floors less than 2 years old: Manufacturers and installers of hardwood flooring typically do not recommend using automatic scrubbers on newly installed hardwood flooring.

Heavy finish build-up and soiled: If the floor exhibits a heavy buildup of finish and dirt and marks have been "sealed in," Traction® should not be applied.

Damaged floors with large gaps: Floors that are warped or have gaps greater than 1/8 inch.

Parquet floors: Not recommended for parquet floors.

Contaminated floors: Floors that have been treated with oil or coated with wax, including paste or dance wax.

Extremes of heat or humidity: Temperatures above 85 degrees Fahrenheit or relative humidity above 50% are known to adversely affect drying performance and appearance of dried films.

Re-coating Floors with Traction® Skate Floor Coating

This Method Bulletin covers all aspects of the annual re-coating of flooring with Traction®. Preparation of flooring is the most critical step ensuring the success of your recoating process. Each procedure has its benefits/drawbacks. Read each procedure carefully to decide which method is best.

The procedure you choose must be followed exactly.....no shortcuts. Failure to follow each step completely can cause product failure and will void any warranty.

If you have questions, please call Roll-on® at 817-571-2438.

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STOP! READ BEFORE PROCEEDING

This method bulletin is to be used **only** by appropriately trained persons in conjunction with such training. **IMPROPER USE OR OPERATION OF Traction® 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 (wrong product, wrong product combinations, improper applicator use, and improper curing.) Because a successful and safe application is the responsibility and obligation of the 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 you intend to use, please call:

Roll-on® at (817) 571-2438 to arrange training.

DO NOT APPLY Traction® if any of the Following Conditions Exist:

Floors Less than 2 Years Old: Manufacturers and installers of hard flooring typically do not recommend using automatic scrubbers on newly installed flooring. **Check the Manufacturers Warranty before Starting the Re-Coat Process.**

New or Freshly Sanded: Traction® is a finish and should not be applied directly to new, unsealed floors or floors that have been sanded to bare hardwood.

Peeling or Poorly Bonded Finishes: If the previous finish is peeling, flaking or otherwise not adhering, Traction® should not be applied.

Heavy Finish Build-Up and Soiled: If the floor exhibits a heavy build-up of finish and soils and marks have been "sealed in."

Damaged floors with large gaps: Floors that are warped or have large gaps greater than 1/8 inch.

Parquet Floors: Not recommended for use on parquet floors.

Contaminated Floors: Floors once treated with oil or coated with wax, including dance or paste wax.

Equipment / Supplies for Methods 1-4:

- ___ Putty Knife
- ___ 5 gallon pails
- ___ # 120 Sanding Screens (1 per 1,000 sq. ft.)
- ___ Floor Machine with Pad Driver/Backing Pad
- ___ Scotch Brite Surface Preparation Pads (SPP) (1 per 500 sq. ft.)
- ___ Red, Blue or Green Pads for Floor Machine
- ___ Padco 24" Weighted Applicator(s)
- ___ Cotton Bath Towels
- ___ Traction® Cleaner
- ___ Push Broom
- ___ Mop-Bucket with Ringer
- ___ Garbage Bags for Clean-Up
- ___ Microfiber Drag Mop

Optional Preparation Using The Wet Screen Method

This is the recommended method when re-coating floors previously coated with: Traction® Floor Finish (**and do not wish to use Crimp Coat™**). Wet screen and **Crimp Coat™** methods keep dust from entering the air causing air quality issues as well as potential dust residues on the floor coating.

Wet Screen Method using 175 RPM Floor Machine

- Step 1:** Dust mop floor to remove dust, sand and debris. Use a putty knife to scrape up gum, labels, or tape adhesive left on the floor. Remove any gum or adhesive residue. Rinse area with fresh water thoroughly.
- Step 2:** Divide floor into smaller sections so Traction® solution does not dry out before being picked up. 250 square feet sections are suggested.
- Clean and screen the floor using a solution of Traction® Cleaner diluted at 8 oz/gallon. Apply the Traction® Solution to the floor with a mop and then scrub the floor with a 175 RPM floor machine and a 120 grit sanding screen.
- One screen is required for every 500 square feet (250 square feet/side). Screen floor two times in opposite directions for uniform results.
- Step 3:** Pick-up spent solution after screening with wet-vac or an autoscrubber.
- Step 4:** Rinse floor thoroughly with fresh water. Scrub floor with floor machine and red pad. Vacuum the rinse water; allow floor to dry.
- Step 5:** Tack floor with cotton towels to pick up any residual dust. See tack procedure on page 5. Repeat until no dust is found on floor.

Note: If the floor is scheduled to be recoated the day following the preparation steps (Steps 1-4), secure or do what is needed to prevent anyone from walking on or using the floor overnight.

Wet Screen Method using Autoscrubber

- Step 1:** Dust mop floor to remove dust, sand and debris. Carry a putty knife to scrape up gum, labels, or tape adhesive left on the floor. Remove any gum or tape adhesive residue. Rinse area with fresh water thoroughly.
- Step 2:** Clean and screen the floor using a solution of Traction® diluted at 8 oz/gallon in the solution tank of the autoscrubber. Use 120 grit sanding screens on pad drivers.
- One screen is required for every 1,000 square feet (500 square feet/side).** Screen two times in opposite directions for uniform results.
- Step 3:** Rinse out solution tank and fill tank with fresh water. Rinse floor thoroughly with fresh water using a red pad on the scrubber. Rinse two times in opposite directions for uniform results. Allow floor to dry.
- Step 4:** Tack floor with cotton towels to pick-up any residual dust. See Tack Procedure on page 5. Repeat until no dust is found on floor.

Note: If the floor is scheduled to be recoated the day following the preparation steps (Steps 1-4), secure facility or do what is needed to prevent anyone from walking on or using the floor overnight.

Apply two coats of Traction® with catalyst in both coats using the PADCO Professional Floor Coater. See page 5 for specific directions on applying the Traction® Floor Coating.

NOTE: If a large amount of existing coating has been removed during the screening process, as noted by a very dull looking floor or if the liquid in the recovery tank of the autoscrubber or wet-vac is very cloudy or opaque, it is recommended to re-scrub the floor.

OPTIONAL PREPARATION WITH CRIMP COAT™

Bonding Agent

Crimp Coat™ Floor Recoating Sealer allows Traction® Floor Coating to bond to most sports floors* without the need to “screen” existing coatings. Traditionally, screening existing floor coatings is required to ensure that the top coat will bond to the existing coating and will not peel or flake off of the floor over time. This screening step is labor intensive and expensive when factoring in time/labor and costs of the screens.

Crimp Coat™ saves time, labor & money and ensures that our Traction® will bond to most existing coatings*, with no risk of peeling or flaking issues. Just remove any marks on floor, clean floor, rinse and apply one thin coat of Crimp Coat™.

* May not work on some epoxy-based sports floor coatings.



Crimp Coat™ Method using a 175 RPM Floor Machine

Step 1: Dust mop floor to remove dust, sand and any debris. Use a putty knife to scrape up gum, labels and tape adhesive left on the floor. Remove any gum or adhesive residue. Rinse area with fresh water thoroughly.

Step 2: Clean and scrub the floor using a solution of [Traction® Cleaner](#) diluted at 8 oz/gallon. Apply the Traction® solution to the floor with a mop and scrub the floor with 175 RPM floor machine and a blue or green pad (3M SPP Pads are also acceptable).



Note: Divide floor into smaller sections so the Traction® solution does not dry out before being picked-up. 10 x 20 feet sections are suggested.

Pick-up spent solution after scrubbing with a wet-vac or an autoscrubber. Rinse with fresh water.

Step 3: Rinse Floor thoroughly with fresh water. Scrub floor with floor machine and red or blue pad. Vacuum the rinse water; allow floor to dry.

Step 4: Immediately before applying the “Crimp Coat™”, tack floor with clear water and cotton towels to remove any residual dust. See page 5 for detailed instructions on “Tacking a Floor”. Wait for floor to dry.

Step 5: Apply one thin coat of Crimp Coat™ Floor Recoat Sealer using a microfiber finish mop. Allow to dry one hour. If humidity is high (above 40%) a slightly longer dry time may be required. Floor should not be sticky or tacky.

Step 6: Apply Traction® according to instructions found on page 5.

Crimp Coat™ Method using an Autoscrubber

Step 1: Dust mop floor to remove dust, sand and debris. Use a putty knife to scrape up gum, labels and tape adhesive left on the floor. Remove any gum or adhesive residue. Rinse area with fresh water thoroughly.

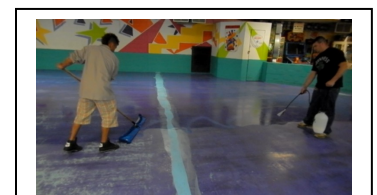
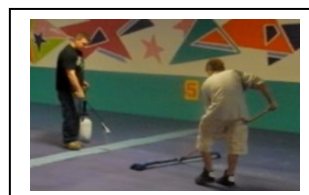
Step 2: Clean and scrub the floor using a solution of [Traction® Cleaner](#) diluted at 8 oz/gallon in the solution tank of an autoscrubber using Blue or Green Pads (3M SPP Pads are also acceptable). Scrub floor two times in opposite directions for best results.



Step 3: Dispose of cleaning solution in solution tank of autoscrubber and fill with fresh water. Rinse floor thoroughly with fresh water using a red or blue pad on the autoscrubber. Rinse floor two times in opposite directions for best results. Allow floor to dry.

Step 4: Immediately before applying the “Crimp Coat™”, tack floor with clear water and cotton towels to remove any residual dust. See page 5 for detailed instructions on “Tacking a Floor”.

Step 5: Apply one thin coat of Crimp Coat™ Floor Recoat Sealer using a microfiber finish mop. Allow to dry one hour. If humidity is high, a slightly longer dry time may be required. Floor should not be sticky or tacky.



Application of Crimp Coat with sprayer and microfiber mop.

Note: Do not wait over 3 hours before applying the Traction® or you will be required to repeat steps 4 & 5.

Optional Preparation using Dry Screen Method

Preparation of floor by the Dry Screen Method is recommended if the existing coating cannot be prepared for coating by Crimp Coat™ or when the floor surface has deep scratches or the surface is uneven.

This method will generate a level of dust. Special care must be taken to control dust and to make sure the dust does not settle into Traction® while coating later. Additional tacking may be required.



120 Grit Sanding Screen

Step 1: Dust mop floor to remove dust, sand, and debris. Carry a putty knife to scrape up gum or adhesive residue.

Screen floor with 175 RPM Floor Machine. Be sure to use a red pad between pad driver and sanding screen.

Step 2: Pre-clean the floor with Traction® at 8 oz/gal. A sealed floor can be pre-cleaned with an automatic scrubber. Alternatively use Traction® as a cleaning solution and tack-clean the floor. Let floor dry.

Step 3: Rough up and dull the old finish by using a single disc machine (175 rpm) and a 120 grit screen. One screen is required for every 500 sq. ft (250 sq. ft. /side). Screen two times in opposite directions for uniform results.

Step 4: Vacuum the dry residue (dust). The dust can also be cleaned up by rinsing floor using an autoscrubber with red pad and fresh water.

Tack the floor to completely remove all traces of dust. Continue tacking the floor until towels are completely clean and no more dust residue is present on floor. See panel at right for details.

Note: If the floor is scheduled to be recoated the day following the preparation steps (steps 1-4), lock the facility or do what is needed to prevent anyone from walking on the floor overnight.

Tack floor immediately before applying Traction®. Dust in the air will settle overnight.

Step 5: Apply two coats of Traction® with catalyst in both coats using the PADCO Professional Floor Coater. See page 5 for details.

NOTE: If a large amount of existing coating has been removed during the screening process, as seen by a very dull looking floor or if the liquid in the recovery tank of autoscrubber or wet-dry vacuum is very cloudy or opaque, it is recommended to re-screen the floor a second time with 120 grit screens.

Tacking Procedure

Tacking is the final step for removing all traces of dry matter (dust) from the floor.

If the prepared floor is left for several hours or overnight prior to coating, the floor must be tacked immediately before applying Traction®.

Fill a mop bucket with fresh water. Place 1 to 2 large white cotton (Turkish) towels in the mop bucket. Wring out a towel so that it is damp, not saturated or dripping.

Wrap damp towel around a broom and push across the floor to remove any residue. After every lap or so, rinse out towel in mop bucket. Replace water in mop bucket when water becomes visually dirty.

Repeat until no dust is found on floor. After floor dries, wipe floor with fingers in several places to determine if any residue remains. If any dust is found, tack floor again.



Tacking floor with cotton towels and push broom.

Marking Enamels

Roll-on® recommends Benjamin Moore Impervex Latex Gloss Enamels.

Apply game line enamel. Allow to dry overnight (12 hours minimum). Lightly roughen surface with a used 120 grit screen or green pad. Clean dust residue and then apply Traction® as directed.

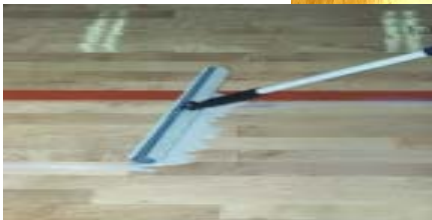
TIP: If possible, shut off the ventilation system during application of finish to minimize air borne dust settling into wet finish. Turn ventilation on when the finish begins to set so as to aid drying.

Application of Traction® Floor Finish

Padco Professional Floor Coater

The Padco Professional Floor Coater is ideal for applying Traction® finishes.

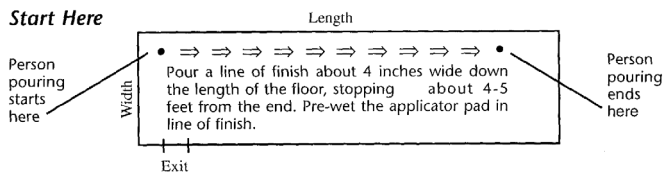
The application is fast and results in uniform coverage. The Padco Professional Floor Coater is available in 24 inch width.



Preliminary:

Plan your start point on the farthest side of the floor and your end point at the most convenient exit.

Start Here



Having two people applying Traction® is most efficient. One will pour the product on floor and the other person will apply coating using the Padco Floor Coater.

Assemble all equipment and chemicals needed:

Supplies

- ___ Padco Heavy Weight Floor Coater 24"
- ___ Cardboard or protective floor cover
- ___ Floor coater refill pads
- ___ Garden Sprinkling Can (No Spout)
- ___ Clean-up rags
- ___ Garbage bags (for clean-up)
- ___ Traction® (with catalyst)

Application of Traction® Floor Coating

Step 1. Pour container of Traction® Catalyst (approx. 14 oz) into a 5 gallon container of Traction® Coating. If measuring the full Catalyst container for single gallons, divide the contents into 5 parts (approx. 2.9 oz) per gal.

Replace cap on each container of Traction® and gently invert the container of Traction® 20 times to mix catalyst. Allow the catalyzed Traction® to sit for 10 minutes before applying to floor and invert five additional times.

Pour Traction® into a plastic garden sprinkling can or other devices or methods that will dispense/pour a line of Traction® along the floor without splashing, creating bubbles or foam are acceptable.

Step 2. Begin applying a line of Traction® along the length of the floor starting about 6 inches from the far wall.

Step 3. Pre-wet the Padco applicator pad in the line of finish then begin applying by pulling the excess finish toward the opposite side of the floor (snowplowing). Continue pouring and applying product across floor. Overlap wet area 50% each pass.



Do not to allow excess product to flow beyond the opposite end of the applicator at the end of each run. If this happens, gently squeeze out excess product from the applicator, then gently feather out the excess material on floor.

Step 4. About 4 to 5 passes from the planned exit, pour product unto the floor sparingly. Streaks will result if the applicator dries out, so take caution.

On the very last run, if excess product is on floor, collect it near the exit point and soak up with towels or rags. Do not attempt to feather this excess product on floor.

Step 5. Allow the floor to dry 3-6 hours depending on air flow and humidity. DO NOT re-coat in less than three hours, even if the floor feels like it is dry.

Step 6. Apply a second coat of Traction®. Follow steps 1 through 4. Be sure to catalyze the second coat of Traction® as well.

Allow floor to dry for 24 hours before returning to 24 – 36 hours for normal/heavy use.

Important: Do not allow dry time to exceed six hours between coats, otherwise you must repeat the last three steps of Crimp Coat™ or Dry Screen preparation.

Note: Once Traction® is catalyzed, it is useful for 24 hours. The catalyzed Traction® must be disposed of if not used after 24 hours.

Recoat Calculator

PRODUCT ESTIMATER FOR YEARLY RECOAT

STEP 1:

MEASURE FLOOR SURFACE

(Multiply length x width for square footage)

Length ___ ft X Width ___ ft = _____ sq. ft.

STEP 2:

MATERIALS CHECKLIST OF EQUIPMENT AND PRODUCTS NEEDED

- A. Products
- ___ Traction® Floor **Cleaner** (no residue)
 - ___ Crimp Coat™ Floor Recoat Sealer
 - ___ Traction® Floor **Finish** w/ catalyst

STEP 3:

PRODUCT ESTIMATER

A. Traction® Cleaner - diluted at 1:16 (2 oz/gal.)

Traction non-residue commercial floor cleaner is HIGHLY CONCENTRATED. 1 gallon is expected to clean up to 100,000 square feet of coated skate floor surfaces. That's equal to 10 floor treatments for a 10,000 square foot floor!

B. Crimp Coat™ Floor Recoat Sealer

(_____ ft²) / (1,000 ft² *) = _____ Total Gallons

Example: 10,000 Square Foot, 1 Coat of Crimp Coat™

10,000 ft² / 1,000 = 10 Total Gallons

C. Traction® Floor Finish

_____ Total
((_____ ft²) / (900 ft² *)) X (2 coats) = _____ Gallons

Example: 10,000 Square Feet - 2 Coats:

10,000 / 900 = 10+ gallons x 2 coats = 20 Total Gallons.

Maintaining Floors

To keep finished floors looking their best and maintaining a high traction surface, use Traction® floor cleaner. Safe for sealed floors, Traction® cleaner is effectively cuts oily residue causing slippery conditions.

Daily/Weekly

Dust with an untreated mop daily to remove debris, abrasive dirt and soil. This should be done as often as possible.

Clean floor using **Traction® Cleaner** at 2-4 oz. /gallon by: Autoscrubbing, towel tacking or damp drag mopping. Never use a janitor's string mop.

Monthly

Deep scrub to remove oily deposits, black marks, etc. using **Traction®** at 2-4 oz./gallon. Use an autoscrubber or 175 rpm floor machine with a wet-dry vacuum.



Equipment Check List

- ___ Low Speed Single disk floor machine with pad driver.
- ___ Red, Blue Pads for use with floor machine.
- ___ Wet/dry Vacuum
- ___ Mop bucket with wringer
- ___ Cotton Mops with Handles
- ___ 120 grit Sanding Screens (1 per 500 sq. ft.)
- ___ Scotch Brite Surface Preparation Pads (1/500 sq. ft)
- ___ Microfiber Frame and Handle
- ___ Microfiber pads (designed for applying floor finish)
- ___ Extension cords
- ___ Putty knife
- ___ Cotton Towels
- ___ ¾ Inch masking tape.
- ___ 2" paint brushes
- ___ Padco Professional Floor Coater
- ___ Padco Floor Coater Refill Pads
- ___ Garden Sprinkling Cans

We can control our mixtures in the factory and issue certificates of compliance with each batch. Unfortunately, we cannot control the environment or preparation procedures where it is applied.

PLEASE READ ALL DIRECTIONS IN THIS BULLETIN CAREFULLY!

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
DISCOLORING STREAKS	Contaminated surface; Likely oil, grease, soap film or silicone
DISCOLORING STREAKS	Improper floor preparation
DISCOLORING STREAKS	Material Not Boxed or Boxes improperly
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