



Implementation instructions

SUBSTRATE PREPARATION

T SIGN can be applied directly to hydrocarbonated surfaces or with a primer to concrete, pavement or an asphalt with a low proportion of binding material.

To ensure a good adherence, the surface must be:

- flat or only slightly sloping
- mechanically sound: any dirt and rubble must be got rid of through sweeping, scraping and/or blasting
- oil and other chemicals free
- at a temperature > 5°C
- with a hygrometry <80%. Do not apply if there is a likelihood of rain. To make sure the substrate is really dry, it must be first heated up with a gas burner.

To apply T SIGN in order to refresh old markings, please contact our technical support (orest@ore-peinture.fr).

STORAGE AND HANDLING

T SIGN must:

- be stored at a temperature ranging from 1°C to 30°C.
- be handled carefully, especially in freezing temperatures less than 0°C.
- be kept free of moisture all through its storage life and use.
- be laid flat and not stacked up in piles of more than 25 units.
- preferably be used within a year of the manufacturing date as printed on the packing.

SAFETY PRECAUTIONS

- The worker applying T SIGN must wear heat-protecting trousers and footwear (safety boots, leather ...) and must not wear synthetic fabrics
- He will have to move in a protected environment, free of any undue movement within his working area
- If possible, wind direction should be taken into account (from upwind to downwind) so as to avoid a flashback from the gas burner.

TOOLS

- Gas burner with hose equipped with a regulator of 3-4 bar.
- Propane cylinder.
- Trush (yard broom) and/or blower.
- Infra-red Thermometer for measuring temperatures >200°C.

APPLYING ON HYDROCARBONATED SURFACES

On a new substrate, the application must not be carried out before at least one month after its being laid and not before the complete elimination of all foot oils. With these conditions fulfilled, T SIGN can then be applied without having to use a primer.

1. Apply markers on the surface, with chalk lines or other means, so as to facilitate the placing and alignment of the T SIGN symbols.
2. Sweep the surface so as to get rid of any dirt and other substances with a broom or any other tool as prescribed in the first part "substrate preparation".
3. Pre-heat the surface with a gas burner to ensure complete dryness.
4. Carefully position T SIGN on the surface, bead-coated side up, referring if necessary to the markers previously applied (step 1). If several pieces must be joined together, position them side by side without leaving any space between them.

Note: though no space should be left between individual pieces, a small gap can be tolerated as the liquefaction of T SIGN will later make it invisible

5. Heat T SIGN with a propane-gas burner equipped with a pressure regulator of at least 3 bars. Heat up slowly with a regular sweeping movement of the gas burner, 10 to 30 cm over the product, so as to ensure uniform heating.

6. T SIGN's melting temperature ranges between 180°C and 200°C.

After heating:

- the edges of T SIGN must have melted and the product has liquefied.
- gaps between pieces of T SIGN must no longer be visible.

- FMR* indicators must have vanished.



*Located on the upper surface of T SIGN, the FMR indicator is a 20x3 mm visual mark which disappears when the minimal recommended fusion has been reached.

This ensures an excellent adhesion to the substrate.

7. 5 to 20 minutes' drying time is necessary, depending on ambient temperature. Re-opening of areas to traffic can be made when the product has reached a temperature below 40°C. If the heating has not been high enough, T SIGN might lift up or become distorted, there is a risk of unbonding to take place as well if the substrate was not dry enough before application. In that case, T SIGN should be lifted up delicately and the process renewed from step 1. In case of overheating, the product can become too brown. If necessary, cold water or sprinkling glass beads/aggregates can be used to speed up cooling.
8. When the product is back to ambient temperature, check that it is correctly bonded to the substrate by trying to lift up pieces with a blade or a chisel. Thin particles of the substrate remaining on T SIGN are proof of good adherence. Make sure the bonding is satisfactory before leaving the work site.

APPLYING ON OLD HYDROCARBONATED SURFACES

On old hydrocarbonated surfaces with a low proportion of bind material, a layer of T PRIM must be applied.

1. Steps 1-2-3 are the same as those carried out on hydrocarbonated surfaces (see previous part).
2. Apply a layer of T PRIM with a roller or a machine on the surface to be treated with a dosage of 150 to 200 g/m².
3. Let T PRIM dry completely before applying T SIGN (about 30min). **Note:** the primer is inflammable: do not use the gas burner on the primer to speed up drying.
4. To apply T SIGN, follow steps 4 to 8 from the previous part about hydrocarbonated surfaces.

APPLYING ON CONCRETE OR OTHER SUBSTRATES

Make a shot-blasting then apply a layer of TX PRIMER. A new screed should be left to dry at least 3 weeks before starting the shot-blasting and applying TX PRIMER.

1. Steps 1-2-3 are the same as those carried out on hydrocarbonated surfaces (see previous part «applying on hydrocarbonated surfaces»).
2. Mix the base with the hardener for about 1 minute. **Caution:** since the TX PRIMER kit is pre-measured, it must be used entirely. Do not decondition.
3. Apply the mixture regularly over the entire surface of the area to be treated. Use a short-haired roller (max 10 mm). Consumption will be about 150-250 g/m² depending on the type of substrate.
4. Immediately place T SIGN on the not yet dry TX PRIMER, then heat. **Caution:** the primer must be still liquid or sticky when setting up T SIGN.
5. Follow steps 4 to 6 from the previous left part about hydrocarbonated surfaces.
6. Complete grip with the substrate has been reached when the TX PRIMER is completely hard. The polymerization time is 24 hours at 20°C. Re-opening of areas to traffic can be made at least one hour after.

Find all the information, documentation and videos on our [website](http://www.ore-peinture.fr).

For any further advice or information concerning T SIGN, please contact our technical department at +33 2 41 21 14 10 or e-mail us: orest@ore-peinture.fr