



**CROWN  
USA INC**

**TuffLine®**  
White Thermoplastic

**TuffLine® Standard Application Procedure**

- 1) Road must be clean and dry to maximize bonding. Sweep or blow debris from the road.
- 2) When applying on new concrete, all curing compound should be removed before sealer application. Apply Crown's recommended Sealer Primer to PCC and aged asphalt with a significant amount of exposed aggregate according to manufacturer's recommended procedures. Make certain all solvent has evaporated and sealer has dried. Solvent left in the sealer will cause obstructions in the line commonly referred to as blistering and pin holing. If a sealer is applied at a heavier mil thickness, solvent can be trapped beneath the top dry film resulting in the same type of problem.
- 3) Crown USA, Inc. recommends that new asphalt be allowed to cure for 3 to 5 days before applying alkyd thermoplastic. However, tracking may still occur based on the condition of the asphalt. Using temporary paint for traffic control and giving the asphalt time to cure before applying thermoplastic will reduce tracking of the asphalt liquid onto the thermoplastic line.
- 4) Do not mix hydrocarbon and alkyd.
- 5) Heat material to 400 - 440°F in equipment with agitation. At ambient temperatures of 50 – 60°F, apply materials at 420 – 440°F. At ambient temperatures of 85 – 90°F, apply materials at 400 – 420°F. For inlaid, recessed applications, when ambient temperatures are 50 – 90°F, materials can be extruded at 390 – 420°F, due to the increased application thickness.
- 6) Do not apply material when road surface and ambient temperatures are below 50°F. Wind will cause material cooling in spray and ribbon gun applications. To compensate for this, apply material at upper end of the application range (420 – 440°F). During high road and ambient temperatures greater than 85°F, apply material at lower end of the application range (400 – 420°F) to facilitate cooling. Set times may increase slightly when temperatures exceed 85°F.
- 7) Avoid contact with hot material. Do not breathe hot fumes. Heating material above 440°F may cause material to flash or ignite (refer to SDS for details).
- 8) Apply glass spheres uniformly using pressurized or gravity devices. Optimal rates of application range from 8 – 10 lbs./100 ft<sup>2</sup> depending on application method and glass spheres used. Flooding of glass beads results in reduced retro-reflectivity.
- 9) Hot molten thermoplastic will burn skin. Do not attempt to remove the thermoplastic from the skin. Cool under running water and seek medical attention immediately (refer to SDS).
- 10) Always store material in a cool dry place. If stored outside, always cover material to prevent damage, which may be caused by moisture.

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