Specification Guide

Amusement and Theme Parks
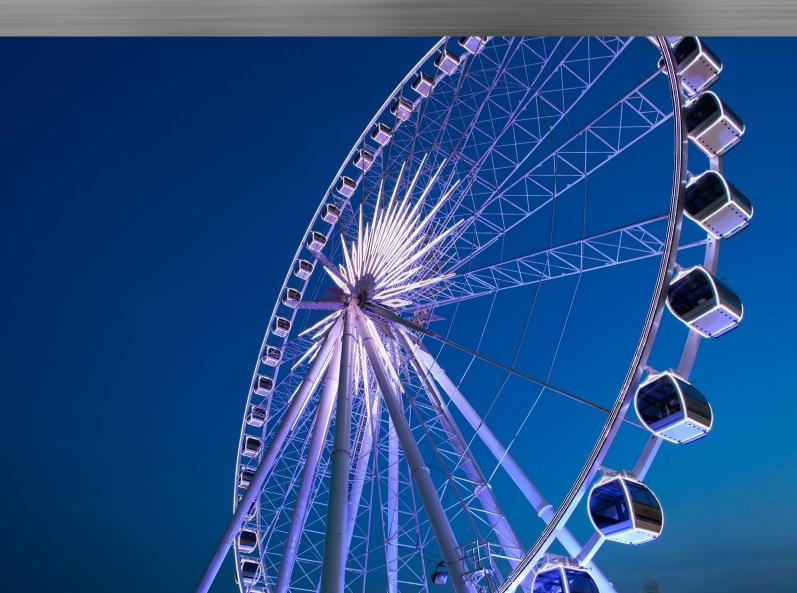
SPECIFICATION GUIDE
AMUSEMENT AND THEME PARKS

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Introduction

We have prepared this specification guide for Amusement and Theme Parks based on our analysis of your new construction and maintenance painting needs. In studying your industry, we have found that you would prefer a simplified approach to painting. An approach that would keep your Amusement and Theme Park in good condition, easy to clean and maintain, simplify your paint selection, minimize painting problems, and above all, give you the greatest value for your painting dollars.

Axalta's approach also addresses your health, safety, and environmental permitting needs. In addition to the systems mentioned in this guide, custom designed systems that meet and/or exceed your local air regulatory agency requirements are also available. Detailed information may be obtained by contacting your authorized Axalta Coating Systems distributor for evaluation. Your authorized Axalta Coating Systems distributor stands ready to work with you in handling all your paint and painting problems. If, however, you prefer to manage your own maintenance program, you can by following the information given in this guide.

The topics covered in this specification guide include selecting the right paint for each job, preparing surfaces for painting, simplified painting techniques and helpful ways to use color.

Copies of product literature for all the products specified in this guide are available from Axalta on our web site, axalta.us. This information, plus that given in Section II (Paint Selection), will help you in ordering the right products for your painting.

To use these specifications, simply refer to the appropriate Section. All information normally required for maintenance painting can be found there. Should you need further information, please contact your authorized Axalta Coating Systems Distributor, who is ready to assist you in all phases of your painting. The authorized distributor in your area can be found on our website, axalta.us or by calling toll-free:

1 855 6 AXALTA

> ****NOTE: The information contained in this guide supersedes any prior product recommendations.****

Paint Selection - The "Paint System" Approach

A basic feature of the simplified approach to painting Axalta has developed for Amusement and Theme Parks is the use of "paint systems" designed for specific areas and substrates.

By a "paint system" we mean the proper combination of (1) surface preparation, (2) paint products and (3) application for a given surface. Each of the three elements plays an important role in the final and most economical performance of paints and finishes for your theme park.

We have selected the proper combination for each type of application you are likely to encounter. The paint systems for <u>Exterior Exposure</u>, listed by substrate, are listed in Table I. Paint systems for <u>Interior Exposure</u>, listed by substrate, are listed in table II. Then after you have selected the appropriate system for the area or structure you want to paint, you can find out what paints are necessary for each system by referring to Table III- <u>Product Selection</u>. This table provides you with a brief description of each of the products specified in Table I and II as well as application information and dry times for each of the products. Both tables will allow you to readily determine which is the recommended system for each area or item to be painted or type of substrate encountered. Your authorized Axalta Coating Systems distributor will be happy to work with you on all of your painting specifications tailored to your specific requirements.

For additional information on these products, you may also wish to consult the product data sheets for each of the products referred to in this Section. Product data sheets and Material Safety Data Sheets may be obtained through our website at <u>axalta.us</u>**.**

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TABLE I
PAINT SYSTEMS
EXTERIOR EXPOSURE

AREA TO BE PAINTED	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Buildings, Arcades, Amphitheater, Hotels, Restaurants, Benches Doors, Railings, Gates, Fences, Roofs, Trash Containers, Signs, Sign Posts, Light Posts, Mail Boxes, Concession Stands	Carbon Steel	**Good**	**Primer:** Tufcote® 3.3 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2)	Fast dry alkyd primer **New** high gloss polyurethane
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ **+** (1.5-2)	High solids productive epoxy primer **New** high gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (4-5) **Topcoat:** Imron® Industrial Strength Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane
Buildings, Walls, Rest Rooms, Storage Areas, Garages	Concrete Block	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Corlar® 2.1 ST™ (to fill)	Satin epoxy mastic
		Best	**Primer:** Corlar® 2.1 ST™ (to fill) **Topcoat:** Imron® Industrial Strength Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane
Buildings, Walls	Concrete, Masonry, Stone	**Good**	**Primer:** Tufcote®1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Best	**Primer:** Corlar® 2.1 ST™ (4-5) **Topcoat:** Imron® Industrial Strength Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane
Signs, Sign Posts, Railings, Roof Deck, Supports, Vents, Ducts	Galvanized Steel	**Good**	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	High solids productive epoxy primer **New** High gloss polyurethane
		Better	**Primer:** Corlar® 2.1 PR-P™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry productive epoxy primer **New** high gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (2-3) **Topcoat:** Imron® Industrial Strength Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane
Sign, Sign Posts, Trash Containers, Railings, Storage Containers	Aluminum	**Good**	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3) Or Imron® 2.1 HG-D™ **+** (3-4)	Urethane copolymer primer High gloss urethane copolymer **New** high gloss polyurethane DTM
		Better	**Primer:** Corlar® 2.1 PR-P™ (3-4) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry productive primer **New** high gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (3-4) **Topcoat:** Imron® Industrial Strength Or Imron® 2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane

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TABLE I (Continued)
PAINT SYSTEMS
EXTERIOR EXPOSURE

AREA TO BE PAINTED	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Ducts, Siding, Pipes, Screens	Fiberglass	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	High gloss acrylic latex **New** high gloss polyurethane
		Best	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron®2.1 HG™ **+** (2-3)	High gloss acrylic latex Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane
Line marking	Asphalt, Poured concrete	**Good**	**Primer:** Tufcote®1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	High gloss acrylic latex High gloss urethane copolymer
		Best	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron®2.1 HG™ **+** (2-3)	High gloss acrylic latex Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high Gloss Polyurethane
Parking & stopping curbs	Concrete	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	High gloss acrylic latex **New** high gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (3-4) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron®2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane
Buildings, Doors, Gates, Benches	Wood	**Good**	**Primer:** Imron® 1.5 ST-D™ (3-4) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer High gloss urethane copolymer
		Better	**Primer:** Corlar® 2.8 PR™ (2-3) **Topcoat:** Imron® 2.1 HG™ **+** (2-3)	Fast dry smooth epoxy primer **New** high gloss polyurethane
		Best	**Primer:** Corlar® 2.1 ST™ (2-3) **Topcoat:** Imron® Industrial Strength (2-3) Or Imron®2.1 HG™ **+** (2-3)	Satin epoxy mastic Ultra Low VOC High & Reduced Gloss Polyurethane Enamel **New** high gloss polyurethane

Note: Imron® 3.5 HG™ **+** may also be used where Imron® 2.1 HG™ **+** is listed.

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TABLE II
PAINT SYSTEMS
INTERIOR EXPOSURE

AREA TO BE PAINTED	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Buildings, Arcades, Hotels, Amphitheaters, Restaurants, Benches, Doors, Door Frames, Fences, Ceilings, Railings, Light Posts, Sign Posts, Storage Racks, Lockers, Containers	Carbon Steel	**Good**	**Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex
		Better	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer
		Best	**Topcoat:** Imron® 2.1 HG-D™ **+** (3-4)	**New** DTM high gloss polyurethane
Sign Posts, Signs, Railings, Roof Deck, Vents, Ducts, Pipes	Galvanized Steel	**Good**	**Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex
		Better	**Topcoat:** Imron® 1.5 ST-D™ (2-3)	Waterborne urethane copolymer
		Best	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer
Walls, Buildings, Rest Rooms, Storage Areas, Warehouses, Garages	Concrete Block	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (to fill) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Imron® 1.5 ST-D™ (to fill) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer
		Best	**Primer:** Corlar® 2.1 ST™ (to fill) **Topcoat:** Corlar® 2.8 HG-D™ (2-3)	Satin epoxy mastic High gloss epoxy
Walls	Dry Wall Plaster	**Good**	**Primer:** Tufcote® 1.9 HG-D™(2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Best	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Imron® 1.5 ST-D™ (2-3)	High gloss acrylic latex Waterborne urethane copolymer
Signs, Sign Posts, Trash Containers, Railings, Storage Containers	Aluminum	**Good**	**Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex
		Better	**Topcoat:** Imron® 2.1 HG-D™ **+** (2-3)	**New** DTM high gloss polyurethane
		Best	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer

TABLE II (Continued)
PAINT SYSTEMS
INTERIOR EXPOSURE

AREA TO BE PAINTED	SURFACE	RATING	COATING SYSTEMS PRODUCTS (DFT)	COMMENTS
Walls, Buildings	Concrete	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Better	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer
		Best	**Primer:** Corlar® 2.8 HG-D™ (2-3) **Topcoat:** Corlar® 2.1 HG-D™ (2-3)	High gloss epoxy High gloss epoxy
Ducts, Siding, Screens, Pipe	Fiberglass	**Good**	**Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex
		Better	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Best	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Imron®1.2 HG™ (2-3)	High gloss acrylic latex Waterborne urethane copolymer
Buildings, Frames. Benches, Gates	Wood	**Good**	**Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex
		Better	**Topcoat:** Imron® 1.5 ST-D™ (2-3)	Waterborne urethane copolymer
		Best	**Topcoat:** Corlar® 2.8 HG™ (2-3)	High gloss epoxy
Line marking	Poured concrete	**Good**	**Primer:** Tufcote® 1.9 HG-D™ (2-3) **Topcoat:** Tufcote® 1.9 HG-D™ (2-3)	High gloss acrylic latex High gloss acrylic latex
		Best	**Primer:** Imron® 1.5 ST-D™ (2-3) **Topcoat:** Imron® 1.2 HG™ (2-3)	Waterborne urethane copolymer Waterborne urethane copolymer
Special Applications	High temperature surfaces up to 450°F continuous/ 500°F intermittent	**Best**	Corlar® 2.1 HTA™ (4-5)	High temperature aluminum epoxy mastic

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TABLE III - PRODUCT DESCRIPTIONS

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® Industrial Strength Ultra Low VOC Polyurethane Enamel	Next generation polyurethane with **High Gloss**, 0.3 VOC, improved adhesion & productivity with outstanding gloss & color retention.	Imron® 9TXX 9T00-A™ Activator See PDS for application thinner details.	4 Parts 9TXX Color 1 Part 9T00-A Activator	Brush, roll or spray 3-5 mils wet 2-3 mils dry	Dry to touch 1 hr. Dry to handle 2 hr. Dry to Recoat 2 hr.
Imron® Industrial Strength Ultra Low VOC Polyurethane Enamel	Next generation polyurethane **Reduced Gloss**, 0.3 VOC, improved adhesion & productivity with outstanding color retention.	Imron® 9TXX 9T00-A™ Activator See PDS for application thinner details.	8 Parts 9TXX Color 1 Part 9T00-A™ Activator	Brush, roll or spray 3-5 mils wet 2-3 mils dry	Dry to touch 1 hr. Dry to handle 2 hr. Dry to Recoat 2 hr.
				Note: See PDS for application thinner details.	
Imron® 1.2 HG™ Waterborne polyurethane copolymer topcoat	A high performance, low VOC, no HAPS, quick dry waterborne polyurethane copolymer topcoat.	Single component	No reduction required	Spray is preferred. 5-7 mils wet 2-3 mils dry	Dry to touch 20-30 minutes Dry to handle 1 hour Dry to recoat 30 minutes with itself; 1 hour with solvent borne
Imron® 1.5 ST-D™ Waterborne polyurethane copolymer satin finish direct-to-metal coating	A high performance, low VOC, no HAPS, quick dry waterborne polyurethane copolymer designed for use as a satin finish DTM or primer under Imron® 1.2 HG-C™ or Imron® 1.2 HG™	Single component	No reduction required	Spray is preferred. 8-12 mils wet 3-5 mils dry	Dry to touch 20-30 minutes Dry to handle 1 hour Dry to recoat 30 minutes with itself; 1 hour with solvent borne
Imron® 2.1 HG™ + High Gloss Polyurethane	**New Imron® technology** delivering a high solids, **high gloss** two-package, 2.1 lbs/gal VOC, extremely durable finish with outstanding chemical resistance, abrasion resistance & flexibility as well as outstanding gloss & color retention.	Imron® 2.1 HG™ **+** Color 9T00-A™ Activator See PDS for application thinner details. Brush & Roll Additive: 9M05™	3 Parts Color 1 Part Activator 0 to 10% Reducer. Roll Additive 1 oz. 9M05™ per RTS Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 2 - 3 mils wet 1.5 - 2.0 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805™ *See product data sheet.

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® 2.1 + Reduced Gloss Polyurethane Available in variable gloss levels: semi gloss, satin and flat.	**New Imron® technology** delivering a high solids, **reduced gloss** two-package 2.1 lbs/gal VOC, extremely durable finish with outstanding chemical resistance, abrasion resistance & flexibility as well as outstanding gloss & color retention.	Imron® 2.1 **+** Color 9T00-A™ Activator 9T20™ Flattener See PDS for application thinner details. Brush & Roll Additive: 9M05™	6 Parts Color 1 Part Activator 0 to 10% Reducer. Roll Additive 1 oz. 9M05™ per RTS Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 2 - 3 mils wet 1.5 - 2.0 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805™ *See product data sheet.
Imron® 2.1 HG-D™ + High Gloss DTM	**New Imron® technology DTM** high gloss, high build, two-package, low HAPS, acrylic polyurethane.	Imron® 2.1 HG-D™ **+** 9T00-A™ Activator	6 Parts Imron® 2.1 HG-D™ **+** 1 Part 9T00-A™ Activator	Brush, roll or spray 10 mils wet 5 mils dry	Dry to touch --- Dry to handle --- Dry to Recoat ---
Imron® 3.4 HG-C™ High gloss clear- Brush and Roller	A high performance, low VOC, clear topcoat	Imron®3.4 HG-C™ VG-610	3 parts 1 part	4 mils wet 2 mils dry	Dry to touch 6 hours Dry to handle 10 hours Dry to recoat 10 hours With 2 oz. VG-805 Dry to touch 2 hours Dry to handle 8 hours Dry to recoat 4 hours
Imron® 3.5 HG™ + High Gloss Polyurethane	**New Imron® technology** delivering a high solids two-package, **high gloss**, 3.5 lbs/gal VOC with low HAPS polyurethane enamel. Extremely durable finish delivers outstanding chemical resistance, abrasion resistance & flexibility with outstanding gloss & color retention.	Imron® 3.5 HG™ **+** Color 9T00-A™ Activator See PDS for application thinner details. Brush & Roll Additive: 9M05™	4 Parts Color 1 Part Activator 0 to 5% Reducer Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 3 - 5 mils wet 2 - 3 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805. *See product data sheet.

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Imron® 3.5 + Reduced Gloss Polyurethane Available in variable gloss levels: semi gloss, satin and flat	**New Imron® technology** delivering a high solids two-package, **reduced gloss**, 3.5 lbs/gal VOC with low HAPS polyurethane enamel. Extremely durable finish delivers outstanding chemical resistance, abrasion resistance & flexibility with outstanding gloss & color retention.	Imron® 3.5 + Color 9T00-A™ Activator 9T20™ Flattener See PDS for application thinner details. Brush & Roll Additive: 9M05™	8 Parts Color 1 Part Activator 0 to 5% Reducer Roll Additive 1 oz. 9M05™ per Ready to Spray Gallon	Apply by spray for Maximum Appearance. Brush & roll optional. Film Build: 3 - 5 mils wet 2 - 3 mils dry	Dry to touch: 3 hours Dry to handle: 7 hours Dry to recoat: 5 hours May be accelerated with VG-805. *See product data sheet.
Imron® 3.5 HG-C™ High gloss clear-Spray	A high performance, low VOC, clear topcoat	Imron® 3.5 HG-C™ VGY-611	3 parts 1 part	Spray is preferred. 4 mils wet 2 mils dry	Dry to touch 6 hours Dry to handle 10 hours Dry to recoat 10 hours With 2 0z. VG-805 Dry to touch 2 hours Dry to handle 8 hours Dry to recoat 4 hours
Corlar® 2.1 ST™ Amido amine modified polyamide epoxy	A two-package high solids/build multi use epoxy mastic coating. Use over tight rust/blasted steel.	Corlar® 2.1 ST™ VF-525 activator Y-32035 for spray, 5%	1 Part 1 Part	Brush, roll or spray Primer: 3-8 mils dry Mid-coat: 4-6 mils dry	Dry to touch 2-3 hours Dry to handle 4 hours Dry to recoat 3 hours
Corlar® 2.1 PR-P™ Modified polyamide epoxy primer	High solids two component VOC conforming low HAPS productive primer.	Corlar® 2.1 PR-P™ FG-040 activator Use T-1025 on hot or windy days and T-1021 normal conditions	2 Parts 1 Part	Brush, roll or spray 6 mils wet 3 mils dry	Dry to touch 60 minutes Dry to sand 5 hours Dry to recoat 45 minutes
Corlar® 2.1 HTA™ Amido amine modified polyamide epoxy – aluminum filled	A two package, high solids, high build, VOC conforming multi-use epoxy mastic coating used for high temperature applications up to 450°F continuous, 500°F intermittent.	1HTA25P™ FG-2HTA™ activator Y-32035 for airless spray, 2-5%; conventional spray, 7-10%. Use T-8054 on hot or windy days. RT001P for brush/roll, 10-15%.	1 Part 1 Part	Brush, roll or spray Single coat: 5-8 mils dry non-corrosive envr. 10-12 mils corrosive envr. Primer: 3-8 mils Mid coat: 4-6 mils Immersion:10-12 mils	Dry to touch 2-3 hours Dry to handle 4 hours Dry to recoat 3 hours

TABLE III - PRODUCT DESCRIPTIONS (Continued)

Product	Description	Components	Mix Ratio	Application	Dry Times @ 70°F
Corlar® 2.8 HG-D™ Modified polyamide epoxy	Excellent choice for industrial, commercial, institutional for durability & ease of use (colors will chalk/fade in UV)	Corlar® 2.8 HG-D™ VF-026 (HB DTM activator)	1 Part 1 Part 1 hour induction	Brush, roll or spray 8 mils wet 5 mils dry	Dry to touch 3 hours Dry to handle 16 hours Dry to recoat 16 hours
Corlar® 2.8 PR™ Epoxy modified polyamide	A two package smooth epoxy primer easily applied without dry overspray. Mix 1:1 with your choice of 7 activators. No induction time and long pot life.	Corlar® 2.8 PR™ Activators FG-33011 Lt Salmon FG-33272 Gray FG-33269 White Thinners T-8805 or T-8245	1 Part 1 Part	Apply by spray only 6 mils wet 3 mils dry No reduction is necessary	Dust free 1 hour Tack free 2-3 hours To touch 1 hour To recoat 2-3 hours Hand dry 4 hours
Tufcote® 1.9 HG-D™ Waterborne acrylic DTM enamel	High quality, chalk-resistant acrylic interior/exterior finish for wood and galvanized metal. Self priming on bare wood and metal surfaces.	Single component	No reduction required	Brush, roll or spray 5.5 mils wet 2 mils dry	Dry to touch 1 hour Dry to handle 3 hours Dry to recoat 3 hours
Tufcote® 3.3 PR™ High Solids Fast Dry Alkyd Primer	A single package, fast drying primer	Single component	Ready to Spray No reduction	Spray is preferred 4 mils wet 2 mils dry	Dry to touch 30 minutes Dry to handle 2 hours Dry to recoat 1 hour

Surface Preparation

As part of Axalta's simplified approach to painting for Amusement and Theme Parks, we have analyzed the various types of surface preparation most likely needed in your facilities. If you follow the recommendations presented below for each of the different types of surfaces you will be painting, you will get the best results from your painting investment.

It is important to remember that some surface preparation is nearly always required; whatever the surface or whatever the paint you use. Even if surface preparation means only dusting the surface and removing any loose material, **DO NOT OMIT THIS STEP**. All paint products are designed to perform at their best when used correctly; unless the surface is correctly prepared to receive the paint, it will not adhere properly and may fail very early in its lifetime.

STEEL (except galvanized)
►Wire brush or spot sand to remove all loose rust, failing material and foreign matter. Tightly adhering paint and mill scale may remain.

GALVANIZED STEEL
►Remove all oil and grease. Remove all white rust by washing with soap and water and rinsing thoroughly.

WOOD
►*New Wood:* Sand lightly and remove all loose sawdust, dirt and sand grit. Fill nail holes and cracks with suitable putty or filler.
Previously Finished Wood: Remove all loose and failing material by sanding or scraping. Fill nail holes and cracks with suitable putty or filler, except when finishing floors.

CONCRETE, MASONRY & MASONRY BLOCK
► Remove all loose dirt, failing material, foreign (Note: All new concrete and mortar joints should be aged a minimum of 30 days before painting.)

Note: Mildew must be removed from all surfaces by scraping followed by a thorough washing with a solution composed of

► 2/3 cup trisodium phosphate (e.g. Soilax®)
► 1/3 cup detergent (e.g. Tide®)
► 1 qt. household bleach (e.g. Clorox®)
► warm water to make 2 gallons

Rinse thoroughly with clear water and allow to dry before painting.

Application

Doing a good painting job also depends on how well you apply the paint. No matter how well the surface is prepared, or how good the paint product, you will get the best results by applying the paint properly.

Conditions During Painting

Generally speaking, the best temperatures for painting are normal room temperatures. About the only time you need worry about ambient temperature for indoor painting is when it is hotter than 95°F. When painting outdoors on a cool day, wait until the air temperature is at least 50°F; don't paint outdoors if the temperature is near 100°F.

Humidity can affect your painting, too. If it is too humid, it will slow the drying of most paints. Likewise, don't paint outdoors when it's raining, or just about to. Rain can quickly spoil a paint job.

Finally, watch out for winds when painting outdoors. Wind can blow dust and dirt onto the wet paint, and can also interfere with spray painting. If it's windy, wait until the wind dies down or paint areas that are protected from the wind.

Application Methods

The method you select for painting depends on the type of surface being painted, the size of the job, what paint you are using and your labor costs for painting.

Spray →All things considered, spray painting is usually the most economical painting method. Conventional air spray is most commonly used, but for very large, flat surfaces, you should consider using airless spraying. Airless spraying will be able to double your painting productivity as compared to conventional air spraying. There are several types of spray equipment, all designed to do particular jobs. Be sure your equipment is in good operating condition, fluid lines and pressure pots clean, pressure gauges and diaphragm valves operating, and spray guns clean and properly adjusted. See that effective traps for water and oil are in the air feed side of each pressure pot and are bled before use. Properly adjusted equipment can save you money, for every stroke of the gun uses up paint and labor. Wrong settings can double your spraying costs. Follow the correct spraying techniques for the job you are doing. Hold the spray gun at the right angle, keep the gun the right distance from the surface and move it correctly across the surface.

Application (Continued)

Roller → Roller application is the next most economical method of painting, indoors and outdoors, and may be necessary to use a roller in those areas where spray painting is not possible. As with spray equipment, use the right equipment for the job. Today there are special rollers for flat surfaces, corners and rounded objects. The roller cover you use is determined by the paint. A general rule of thumb is, "the smoother the surface, the shorter the nap". Again, be sure that your rollers and other equipment are clean before using.

Brush → Brushing paint is ordinarily the slowest and most expensive way of applying a coating, although it is most commonly used for woodwork and trim, and for applying primers or undercoats to lap joints, deep pits, rivets or hand-cleaned steel. Brushes should be clean, of good quality and the right size and shape for the surfaces to be painted. Some of today's newer brush filament materials may improve your painting, speed up your work and save you money. Should you have any questions about brush selection or brushing techniques, consult with your Axalta Representative.

Material Selection & Color

Putting Color & Material Selection to Work For You

Many of our customers believe that keeping their Amusement and Theme Park looking clean and freshly painted is vital to the success of their company. Color selection can help you in many ways. Maintaining corporate identity is vital in today's economy to differentiate one Theme Park from another. Painting has proven to be the most valuable, yet inexpensive method of satisfying your customer's expectations of your Theme Park. Many of our customers have surveyed their guests and found that their customer base has been developed from people that visit their facility and see a well-maintained, clean Amusement Park, and based on this positive experience, return again and again. This leads to the fundamental question "*How can I best maintain my Amusement and Theme Park and do this economically?*" The answer is Material Selection.

Axalta has long been recognized as a leader in long term performance of Industrial Coatings and the concept of reduced life cycle painting costs. The long-term durability of Axalta's general industrial products has been proven through our customer base, many independent studies, and Axalta owned assets. Axalta features a variety of industrial coatings providing long term gloss retention, long term color retention, coatings to resist the wear and tear of your guests, and easy to clean products resulting in reduced maintenance cost over the lifetime of the coating.

To increase the life cycle of coatings, and to reduce maintenance costs many Amusement and Theme Parks today are using an Imron® Polyurethane clear topcoat to further protect their painted surfaces from strong UV exposure, and the wear and tear of guests. Your authorized Axalta Coating Systems distributor is trained to evaluate your facility, recommend coatings systems and coating application methods to meet your long term needs as well as local regulatory agency's.

To find the authorized Axalta Coating Systems distributor in your area, log onto our website, axalta.us or call 1 855 6 AXALTA.

Safety Colors, Piping & Equipment Color Codes

Color	Axalta Ordering No.	Use
Yellow	1663 Safety Yellow	Gas lines, safety guards, yellow & black stripes for moving machinery
Orange	1662 Safety Orange	Oil lines, grease fittings, inside cover of electrical switch boxes
Red Pressure	1664 Safety Red	Fire protection equipment, high-pressure sprinkler valves and lines
Blue Breakers	1665 Safety Blue	Electrical switch boxes, controls breakers
Green	1666 Safety Green	Water lines
Black	1640 Black	Drain lines, waste water
White	1632 White	Electrical conduit, beams and hanger rods
Medium Gray	1633 Shale Gray	Walls and columns
Light Gray motors, fans	1637 Cirrus Gray	Machinery-compressors, pumps, motors
Light Brown	1635 Clay Tan	Low pressure air line 40 psi or less
Dark Blue	1014 Dark Blue	Hot water and boiler feed water line
Dark Brown	1288 Bark Brown	High-pressure air lines over 40 psi
Light Green	1062 Spotlight Green	Chilled water lines
Medium Green	1642 Meadow Green	Control cabinets and panels
Light Blue	1638 Falls Blue	Cooling water lines
Aluminum	1HTA25P Aluminum	Steam and condensate lines, hot surfaces, boilers, stacks, cooling fins on air compressors, hot equipment to 500°F

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