

V&Staunton Galvanizing

823 John Hancock Rd.
Taunton, MA 02780

COATING PROCEDURE FOR:

ITEM 525.15
WARREN VT BHF 0188 (7)
GALVANIZE + PAINT BLACK
COLOR # 27038

September 7, 2004

Highway Safety Corp.
239 Commerce St.
Glastonbury, CT 06033

Dear Marita Sniezko:

The following is a description of the process and protocol we use at the Taunton paint shop.

Taunton Coating Room Process.

- Product is brought directly over from the galvanizing plant and hung on racks. Storage and staging is all under enclosed roof. The prime coat will be applied within 12 hours of the galvanizing process.
- Final inspection is made to address any remaining irregularities in the galvanized surface. Air sensors and hand files are used to carefully remove irregularities if present. Any required repairs are completed according to ASTM A-780 Standard practice for Repair of Damaged and Uncoated Areas of Hot Dip Galvanized Coatings.
- The racks are loaded into the manual blast room.
 - o Blasting pressure is low so as to not to damage the zinc.
 - o Appropriate surface condition is 1.0 to 1.5 mil of profile and complete cleaning of the surface.
 - o When blast is complete, the operator uses straight air to blow down the racks.
- After the blast room, racks are manually staged before the primer booth. Additional quality control is performed here to confirm smoothness of the surface and thoroughness of the blast. Racks are automatically introduced to the primer booth by a timed conveyor system.
- **INTERMEDIATE COAT**
 - o The epoxy primer is spray applied, using an airless sprayer, to achieve a dry film thickness of 4.0 - 5.0 mils. Wet film gauges are used to monitor the application.
- After the primer booth, racks are automatically stored in the next buffer area and inspected for completeness of coverage and appearance.
- Primed racks of material are now loaded by transfer cart into the primer cure oven and allowed to dwell until primer has completely cured per the coating manufacturer's schedule.
 - o There is high airflow in the oven to promote thorough cure of the primer.
- After the cure oven, racks are manually staged in the buffer zone before the finish booth. Additional quality control is performed here to confirm smoothness, specified thickness and quality of the primed surface.
- Cured primer racks are next introduced to the finish coat booth via a timed conveyor similar to the primer booth system.