COLOR CHIP
27038

- The aliphatic polyurethane finish is spray applied, using an airless sprayer, to achieve a dry film thickness of ~~1.5 - 2.0~~ mils. Wet film gages are used to monitor the application. 3.0 -5.0

- After the finish booth, racks are automatically stored in the next buffer area.
  - Additional inspection and repair is done at this stage while the finish is still semi-fluid.
- The racks are now loaded by transfer cart into the finish cure oven and allowed to dwell until finish has completely cured per the coating manufacturer's schedule.
  - The oven provides sufficient curing of finish to allow immediate packing of the product once the surface has cooled to ambient temperatures (< 90° F).
  - There is high airflow in the oven to promote thorough cure of the finish.
- The last stage is final inspection and packing using soft foam to protect the finish.

After painting, finished product is stored inside until shipment.

Additional Notes:

Environmental conditions are monitored and recorded throughout the day. All production parameters are recorded and become part of the permanent job record.

Please call me at (717) 821-3088 if you need any additional information.

Sincerely,

Peter C. Kohler
Special Coatings Project Manager
V&S Taunton Galvanizing, LLC

VTRANS
RECEIVED
CK'D BY _____ OK'D BY JWC
JUL 2 6 2007
RESUBMIT _____ APPROVED ✓
BY _____ 8-2-07

060 HR