



## APPLICATION INSTRUCTIONS

For HotTape™ 2-Layer Preformed Thermoplastic Pavement Markings

*First-time applicators should contact Flint Trading, Inc. for product support and on-site training.  
For Application of single layer HotTape™ markings contact your Flint Trading, Inc. representative.*



### SURFACE APPLICATION, GENERAL REQUIREMENTS:

- Equipment:**
- Magnum Torch or equivalent propane fueled torch with pressure regulator and 25 ft. of hose
  - Infrared Thermometer
  - Tape Measure
  - Adequate Supply of Propane
  - Leather/ heat resistant gloves
  - Gas Powered Blower or Broom
  - Chalk Sticks and Chalk Snap Line
  - Utility Knife, Putty Knife
  - Water sprayer (optional)
- Surface:** Must be free of dirt, dust, chemicals and significant oily substances. Portland cement concrete must be free of all curing compounds. Any residual salts or other deicing chemicals must be removed prior to application. HotTape™ can be applied on new or old thermoplastic. **Concrete substrates should be moisture free for 24 hours prior to application for best results.** When applying on old thermoplastic scrape off any loose material. Ensure that the remaining thermoplastic surface is clean. If the old thermoplastic is oxidized (powdery surface), grind or heat it and scrape the top surface so fresh material is exposed. **Do not apply on top of paint or cold plastic.**
- Material:** HotTape™ 2-layer markings consist of a solid base layer and a top layer usually of a contrasting color. HotTape™ shall be kept dry at all times. Avoid extreme storage temperatures. HotTape™ should be stored indoors at temperatures between 35° F. and 90° F. Packages should be stored flat and stacked a maximum of 25 high. HotTape™ should be handled with care in temperatures below 50° F, as it will be less flexible in colder weather. Shelf life is 12 months. Note: HotTape™ rolled goods will uncoil best when ambient temperature is above 55°F.
- Temperature:** HotTape™ can be applied at ambient and surface temperature above 32°F.

### SAFETY PRECAUTIONS:

Protective clothing, consisting of leather boots, or work shoes, long pants, leather gloves, and either safety goggles or a face shield, and a safety vest should be worn while applying HotTape™. **Note: portland cement concrete surfaces may spall when heated with the torch; therefore safety glasses must always be worn when applying HotTape™ onto portland cement concrete surfaces.** Avoid all contact with the molten HotTape™ material and heat torch flame. If you do get molten material on your skin, flush the area immediately with plenty of water and then seek medical attention. Do not attempt to pull the molten material off of your skin.

**INSTRUCTIONS FOR APPLICATION ON ASPHALT OR NON-BITUMINOUS SURFACES:**

1. Clean intended application area thoroughly. All loose particles, sand, dust, etc. must be removed. Utilize a power blower or compressed air if available, otherwise sweep completely.
2. Position all connecting parts of the base layer of HotTape™ onto the pavement surface. There should be no gaps between the adjoining segments. Delineate the area to receive the HotTape™ using a chalk line, chalk or crayon. You may overlap the edges slightly. Check to ensure that proper layout and alignment is obtained before moving to step 3. Once the marking has been traced, or the area delineated, remove the base layer from the pavement.
3. Prepare to pre-heat the pavement by positioning yourself with the wind at your back as you face the delineated area. This will allow the wind to move the heat over the unheated portion of the pavement while at the same time keeping the heat away from your feet. Using a Magnum Heat Torch, or similar heat source, utilize the pre-set pilot valve setting to get a blue flame with an orange or yellowish tip. Then squeeze the torch handle to achieve maximum output. Hold the torch nozzle 8 to 10 in. above the pavement. Using the torch in a circular motion pre-heat the surface to a minimum temperature of 300° F. Extend the heating 3 to 6 in. outside the pre-marked area.



**Do not attempt to pre-heat an area larger than 2 ft. x 4 ft. at any one time.** Properly heated, asphalt should turn a deep, solid black. **Note: concrete surfaces may spall when heated with the torch; therefore safety glasses must always be worn when applying HotTape™ onto portland cement concrete surfaces.** Use the infrared thermometer to check the surface temperature for a minimal reading of 300°F across the entire target area.

4. Once the surface temperature of the targeted area reaches 300° F immediately position the base layer of HotTape™ with the top coating of slip resistant elements side up. **Do not apply HotTape™ in pieces larger than 2 ft. x 4 ft. at any one time.** If using a torch similar to the Magnum, the applicator should utilize the pre-set pilot valve setting (do not squeeze the handle) to get an orange tipped flame to heat the material. **Do not operate the Magnum torch at maximum output while heating the HotTape™ material.** Hold the torch so that the torch nozzle is 6 to 8 in. over the HotTape™ material. If material is splattering with the introduction of the torch, the flame is too close to the material or the pilot valve needs to be adjusted to lower the intensity and eliminate the splattering.



5. Begin heating the HotTape™ by moving the flame from your torch slowly, but steadily over the material. The HotTape™ material must be heated to its melting temperature to achieve a bond with the pavement. **Insufficient heat will result in inadequate bonding and failure.** To ensure that heat is evenly applied to the entire marking, move the torch in a sweeping motion, approximately 2 ft. wide, keeping the nozzle of the torch about 6 to 8 in. above the material. **Caution: Maintain a minimum distance of 6 in. between the torch nozzle and the material. Any closer will cause superficial scorching of the material without adequate melting throughout. Note that 125 mil thick materials will require a longer heating period than 90 mil and 90 mil longer than 75 mil.**



During heating, the HotTape™ should soften and begin to conform to the pavement surface to which it is applied. Additionally the material may bubble, and may change color, turning slightly darker or pale. If the material does change color move the torch to another section to avoid scorching the material. HotTape™ material will exhibit a soft, “chewing-gum” appearance when properly heated. Inspect the recently applied HotTape™ to ensure that complete bonding has occurred over the entire area.

6. While the base layer is still molten, immediately place the overlay segment on top. **Caution: Leather gloves or other heat resistant gloves should be worn while positioning the top layer of material.**



7. Immediately apply *light* heat over the entire overlay segment using the same technique described in Step 5 until the material conforms to the lower segment. Note: If the top layer of your marking is a “stencil design”, allowing portions of the base layer to show through, then it is important that you do not overheat the top layer as you will lose the detail in the “stencil design”. Do not attempt to re-align the top layer once it has made contact with the base layer.



8. HotTape™ will cool and set rapidly within a couple of minutes of application. If desired, setting time can be accelerated with a spray of cool water.



#### NOTES:

- HotTape™ is compatible with asphalt and concrete surfaces and can be applied on special surfaces, i.e., bricks and cobble stones.
- Do not allow 2 pieces of non-beaded HotTape™ to remain in direct contact with each other, as they will bond together especially in hot weather. Use the plastic separation sheets to avoid this situation.
- You can "cut and paste" with HotTape™. Use a knife to score the material and carefully break it along the score. In warm weather you can use scissors.

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