

Crossfield Products / Dex-O-Tex

Terrazzo M (Fine) Kit

PRODUCT DESIGNATIONS

0544

MIL-PRF-24613

If this product is to be applied as part of a coating system, all components of the system must be as listed on the QPL.

This NAVSEA-REVIEWED ASTM F-718 data sheet is the only data sheet approved for use when utilizing this coating for U.S. Navy preservation projects. NAVSEA's review covers only the application process for the material. The review does not denote the material as a qualified product, nor does it constitute an approval for purchase/procurement of the material. For products on the Qualified Products List (QPL) for this MILSPEC, please refer to <https://assist.daps.dla.mil/quicksearch/>

Questions regarding modifications or updates of this ASTM F-718 shall be directed toward:

NSWC-PD

nswccd_astm_f718@navy.mil

I. GENERIC TYPE AND DESCRIPTION: Interior Deck Covering Epoxy Resin Kit Unit ½
Specification Number, Type, Class and/or Grade (If Applicable): MIL-PRF-24613

II. MANUFACTURERS DATA:

- (a) MANUFACTURER: CROSSFIELD PRODUCTS CORP.
DEX-O-TEX MARINE PRODUCT LINE
- (b) PRODUCT DESIGNATION: 0544 -Terrazzo M (Fine) Kit
- (c) COLOR(S): CLEAR, straw to pale yellow
- (d) USES: CLEAR SEALER
- (e) TECHNICAL SERVICE REPRESENTATIVE
(Include Telephone Nos.): STEVEN SCHROEDER 310-886-9100
- (f) NOT RECOMMENDED FOR: Sealing Polymeric Deck Covering

III. PROPERTIES:

- (a) % VOLUME SOLIDS (ASTM D 2697): 88.0%
- (b) % WEIGHT SOLIDS (ASTM D 1475): 90.0%
- (c) FLASH POINT (ASTM TEST METHOD D 93 OR D 56 OR D 3278): 45°C (114°F)
- (d) WEIGHT PER VOLUME: (FTMS 141a4184.1): 32.1 lbs/gal
- (e) % EDGE RETENTION (IF REQUIRED BY APPLICABLE SPECIFICATION): N/A
- (f) SHELF LIFE: One year from date of manufacture
- (g) VISCOSITY (STATE TEST METHOD TO BE USED: ASTM D445): COMPONENT A: >1000 cps.
COMPONENT B: >100 cps
MIXED: >250 cps.
- (h) PACKAGING: 6 gallon kit (A-1/2 Terrazzo M Fine Basecoat, B-1/2 Terrazzo M Fine Basecoat & Terrazzo M Fine Aggregates).
- (i) NUMBER OF COMPONENTS: Three (3)
- (j) GLOSS (ASTM D 523): N/A
- (k) STORAGE REQUIREMENTS: TEMP. MIN. 60°F MAX. 80°F
ADDITIONAL PAINT STORAGE REQUIREMENTS: Dry area, not in direct sunlight.
- (l) VOLATILE ORGANIC COMPOUND (EPA TEST METHOD 24): 74 g/L for mixed components
- (m) WEIGHT OF DRY FILM (WEIGHT/FT² AT 1 MIL THICKNESS): 0.005 lbs
- (n) SPECIAL PROPERTIES (e.g., STAIN RESISTANCE, LOW SOLAR ABSORBANCE, MOISTURE TOLERANCE): None

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS (USE SPECIFIC STANDARD NUMBERS):

After overnight drying period the Terrazzo M Bondcoat may, due to the atmospheric conditions, still be slightly tacky. This tacky condition does not prohibit the application of the Terrazzo M (Fine) Basecoat.

- (a) INITIAL – Clean and solvent-wipe with acetone, xylene, or isopropanol
- (b) TOUCH-UP – Lightly sand and solvent-wipe with acetone, isopropanol, or xylene.
- (c) PROFILE (INCLUDE METHOD USED) – N/A
- (d) SPECIAL INSTRUCTIONS - None
- (e) PRIMER REQUIREMENTS (IF APPLICABLE): Terrazzo M Bondcoat
- (f) MAXIMUM ALLOWABLE CONDUCTIVITY (BRESLE PATCH METHOD): Refer to NAVSEA Standard Item 009-32
- (g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWABLE (LIST COMMERCIAL STANDARD): N/A

SPECIAL SAFETY PRECAUTIONS:

Provide good ventilation and always obtain and read Manufacturers MSDS before handling polymeric materials.
See MSDS for Terrazzo M (Fine) Basecoat Resin C, D and Terrazzo M (Fine) Aggregates

V. MIXING PROCEDURES:

- (a) MIXING RATIOS BY WEIGHT – 5 parts Component C : 1 part Component D : 50 lb. bag TM Fine Aggregates
BY VOLUME – 4.8 parts Component C : 1 part Component D : 50 lb. bag TM Fine Aggregates
- (b) INDUCTION TIME - N/A
- (c) RECOMMENDED SOLVENT – THINNING – NO THINNING ALLOWED
 CONFINED AREAS - NO THINNING ALLOWED
 NON-CONFINED AREAS - NO THINNING ALLOWED
 CLEAN UP – Xylene or Acetone
- (d) THINNING REQUIREMENTS (RATIO) – NO THINNING ALLOWED – N/A
- (e) POT LIFE - 25 minutes at ambient temperature of 70°F TO 75°F (21°C TO 24°C)
- (f) SPECIAL INSTRUCTIONS – MIXING: Pour contents of Basecoat can D into can C. Blend thoroughly with a Jiffy Blade until the mix is homogeneous. Terrazzo M (Fine) Basecoat has a pot life of approximately 25 minutes.

VI. APPLICATION:

- (a) ENVIRONMENTAL LIMITATIONS -

SUBSTRATE TEMPERATURE: MIN. 60°F MAX. 80°F

MINIMUM SUBSTRATE TEMPERATURE DIFFERENCE ABOVE THE DEW POINT - 5°F

MAXIMUM PERCENT RELATIVE HUMIDITY: Refer to NAVSEA Standard Item 009-32

AMBIENT TEMPERATURE: MIN. 50°F MAX. 95°F

- (b) FILM THICKNESS (SSPC-PA 2):

PER COAT:

WET MIN. 20 mils

WET MAX. 22 mils

DRY MIN. 19 mils

DRY MAX. 21 mils

TOTAL SYSTEM: MIN: 62.5 mils MAX: 125 mils

- (c) **DRY TIMES (ASTM D 1640):** Dry-to-touch in 12 hours. Underlayment can be applied when Terrazzo M Bondcoat is tacky (3 –6 hours after initial application).

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|----|---|---|
| 1) | DRY TO RECOAT: | 14 Hrs @ 65°F
10 Hrs @ 75°F
8 Hrs @ 85°F |
| 2) | DRY TO HANDLE (I.E., TIME UNTIL PERSONNEL CAN WALK ON, INSPECT, TOUCH-UP COAT): | 14 Hrs @ 65°F
10 Hrs @ 75°F
8 Hrs @ 85°F |
| 3) | MAXIMUM RECOAT: | 48 Hrs @ 65°F
44 Hrs @ 75°F
40 Hrs @ 85°F |
| 4) | CURE TO FULL SERVICE: | 52 Hrs @ 65°F
48 Hrs @ 75°F
44 Hrs @ 85°F |

- (d) EQUIPMENT REQUIREMENTS (INCLUDE PREFERRED, SUITABLE, NOT SUITABLE REQUIREMENTS) – Jiffy Blade (small size) and Short Nap Roller.

IF PLURAL COMPONENT EQUIPMENT IS REQUIRED, STATE SO - N/A

IF HEATED LINES ARE REQUIRED, STATE SO - N/A

- (c) SPECIAL INSTRUCTIONS – Spread the blended Terrazzo M (Fine) Basecoat materials evenly and fairly liberally over the entire surface using a short nap roller. This material will flow out in approximately 5 to 7 minutes, filling any minor voids or depressions. The Basecoat surface must be uniform, wet and free of ridges. A unit of Terrazzo M (Fine) Basecoat will cover approximately 50 square feet.

REPAIR PROCEDURES IF THE OVERCOAT WINDOW HAS BEEN EXCEEDED: Prep in accordance with SSPC-SP 1 & SSPC-SP 2. Lightly sand and solvent wipe with Xylene or Acetone.