

## Randolph Products

# Randogrip Metal Primer- Epoxy Primer for Nonskid

### PRODUCT DESIGNATIONS

Part A: 600D02 (Gray); 600D30 (Light Gray) and 600T04 (Buff)

Part B: 610C02

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MIL-PRF-24667

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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://qpldocs.dla.mil/search/default.aspx>.

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

NSWCPD

[NSWCPD\\_ASTM\\_F718.fct@navy.mil](mailto:NSWCPD_ASTM_F718.fct@navy.mil)

# ASTM F 718

## SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

<p>I. GENERIC TYPE AND DESCRIPTION: Randogrip Metal Primer- Epoxy Primer for Nonskid          Specification Number: MIL-PRF-24667          NOTE: For Type/Grade/Class/Application information see QPD-QPL-24667</p>	<p>Date: 10/14/2021</p>
<p>II. MANUFACTURERS DATA:</p> <p>(a) MANUFACTURER: Randolph Products 33 Haynes Circle Chicopee, MA 01020</p> <p>(b) PRODUCT DESIGNATION: Part A: 600D02 (Gray); 600D30 (Light Gray) and 600T04 (Buff) Part B: 610C02</p> <p>(c) COLOR(S): Gray, Light Gray and Buff</p> <p>(d) USES: Primer for Nonskid Deck Coating</p> <p>(e) TECHNICAL SERVICE REPRESENTATIVE: Carol Rosler Phone: 413-592-4191; Fax: 413-594-7321; E-mail: crosler@randolphproducts.com; Website: www.randolphproducts.com</p>	
<p>III. PROPERTIES:</p> <p>(a) PERCENT VOLUME SOLIDS (ASTM D2697): 72 +/- 2 %</p> <p>(b) PERCENT WEIGHT SOLIDS (ASTM D2369): 86 +/- 2 %</p> <p>(c) FLASH POINT (ASTM D3278 ):</p> <p style="padding-left: 40px;">Base Component, Part A: &gt;102 °F (&gt;38.9 °C)</p> <p style="padding-left: 40px;">Hardener Component, Part B: &gt;102 °F (&gt;38.9 °C)</p> <p style="padding-left: 40px;">Mixed: &gt;102 °F (&gt;38.9 °C)</p> <p>(d) WEIGHT PER VOLUME (ASTM D1475):</p> <p style="padding-left: 40px;">Mixed: 13 +/- 0.2 lb/gal (1558 +/- 24 g/L)</p> <p>(e) PERCENT EDGE RETENTION, IF REQUIRED BY APPLICABLE SPECIFICATION (N/A): N/A %</p> <p>(f) SHELF LIFE: 12 Months</p> <p>(g) VISCOSITY ( ASTM D2196, Method A ):</p> <p style="padding-left: 40px;">Base Component, Part A : 3000 – 5000 cps @ 23.9 °C ( 75 °F)</p> <p style="padding-left: 40px;">Hardener Component, Part B : 150 – 400 cps @ 23.9 °C ( 75 °F)</p> <p style="padding-left: 40px;">Mixed : 2000 – 2750 cps @ 23.9 °C ( 75 °F)</p> <p>(h) PACKAGING: 5 gallon pail kits: 3.2 gallons Part A; 0.8 gallons Part B; 6 ½ gallon pail kits: 4 gallons Part A; 1 gallon Part B</p> <p>(i) NUMBER OF COMPONENTS: 2</p> <p>(j) GLOSS (ASTM D523): N/A GU</p> <p>(k) STORAGE REQUIREMENTS: TEMPERATURE: 40 °F ( 4.4 °C) MIN. 100 °F ( 37.8 °C) MAX.</p> <p style="padding-left: 40px;">ADDITIONAL PAINT STORAGE REQUIREMENTS: 24 hours prior to mixing: Min: 50 °F (10 °C); Max: 90 °F (32.2 °C)</p> <p>(l) VOLATILE ORGANIC COMPOUNDS (VOCS- EPA TEST METHOD 24): 1.9 lb/gal ( 229 g/L)</p>	

(m) WEIGHT PER AREA OF DRY FILM AT 1 MIL THICKNESS: 0.0095 – 0.0097 lb/sq. ft. ( 4.31 – 4.4 g/m<sup>2</sup>)

(n) SPECIAL PROPERTIES: N/A

#### IV. SURFACE PREPARATION MINIMUM REQUIREMENTS:

- (a) INITIAL CLEANLINESS: Remove grease, oil and dirt (SSPC-SP 1) or other approved method followed by abrasive blasting or water jetting/blasting. Abrasive Blasting: MIN: SSPC-SP 10/ NACE 2 ; MAX: SSPC-SP 5/NACE 1: Water jetting: SSPC-SP WJ-2/NACE WJ-2
- (b) TOUCH-UP CLEANLINESS: For hard to reach areas and for areas not to receive nonskid, use power tool cleaning to bare metal, SSPC-SP 11. A minimum anchor profile of 2 mils is required.
- (c) PROFILE (ASTM D4417 Method B or C): 3 mils MIN. 6 mils MAX.
- (d) SPECIAL INSTRUCTIONS: N/A
- (e) PRIMER REQUIREMENTS: N/A
- (f) MAXIMUM ALLOWABLE CONDUCTIVITY (ISO 8502-9):  
70 micro-siemens/cm
- (g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWED: Light (SSPC-SP WJ-2/NACE WJ-2)

#### SPECIAL SAFETY PRECAUTIONS:

CAUTIONS TO BE TAKEN IN HANDLING AND STORING: Read MSDS before use. Do not get in eyes. Avoid contact with skin and clothing. Avoid inhalation of vapors or mist. Use with adequate ventilation. Wash hands thoroughly before handling and before eating, drinking or smoking. Remove contaminated clothing and wash before use. OTHER PRECAUTIONS: Keep away from flame or other ignition source. Avoid extreme heat.

#### V. MIXING PROCEDURES

- (a) MIXING RATIOS BY WEIGHT: 6.78:1 (Base Component, Part A to Hardener Component, Part B)  
BY VOLUME: 4:1 (Base Component, Part A to Hardener Component, Part B)
- (b) INDUCTION TIME: None Minutes
- (c) RECOMMENDED CLEANING SOLVENT (NO THINNING ALLOWED): Propylene Glycol Monomethyl Ether (PM Solvent) Aromatic Naphtha or MAK.
- (d) POT LIFE: see below  
2 Hours @ 90 °F ( 32 °C)  
4 Hours @ 70 °F ( 21 °C)  
8 Hours @ 50 °F ( 10 °C)  
Graphs included on page: 5
- (e) SPECIAL INSTRUCTIONS: Premix the base component, Part A, to ensure all materials which may have settled during shipment and storage are lifted from the bottom of the container. A jiffy blade or vortex paddle should be used for mixing. Mix Part A and Part B together for a minimum of 3 minutes or until the mixed material is uniform in color and appearance. Scrape the sides of the container to ensure the material is thoroughly mixed. Warning: Improperly mixed material will not cure or perform properly.

## VI. APPLICATION:

## (a) ENVIRONMENTAL LIMITATIONS:

SUBSTRATE TEMPERATURE: 40°F (4.4°C) MIN. 120°F (48.9°C) MAX.  
 AMBIENT TEMPERATURE: 55°F (12.8°C) MIN. 100°F (37.8°C) MAX.  
 DIFFERENCE ABOVE THE DEW POINT: 5 °F ( 2.78 °C)  
 MAXIMUM PERCENT RELATIVE HUMIDITY: 85 %

## (b) FILM THICKNESS (SSPC PA2-73T): PER COAT:

5 mils WET MIN. 10 mils WET MAX.  
 4 mils DRY MIN. 7 mils DRY MAX.

## TOTAL SYSTEM:

N/A mils DRY MIN. N/A mils DRY MAX.

## (c) DRY TIMES (ASTM D1640):

## Minimum Overcoat Window:

36 Hours @ 50 °F (10°C)  
 12 Hours @ 70 °F (21.1°C)  
 2.5 Hours @ 120 °F (49°C)

## Maximum Overcoat Window:

336 Hours @ 50 °F (10°C)  
 168 Hours @ 70 °F (21.1°C)  
 72 Hours @ 120 °F (49°C)

## Dry to Handle:

36 Hours @ 50 °F (10°C)  
 12 Hours @ 70 °F (21.1°C)  
 2.5 Hours @ 120 °F (49°C)

## Dry to Service:

336 Hours @ 50 °F (10°C)  
 168 Hours @ 70 °F (21.1°C)  
 72 Hours @ 120 °F (49°C)

Graphs included on page 5 thru 7 or additional information included on page N/A

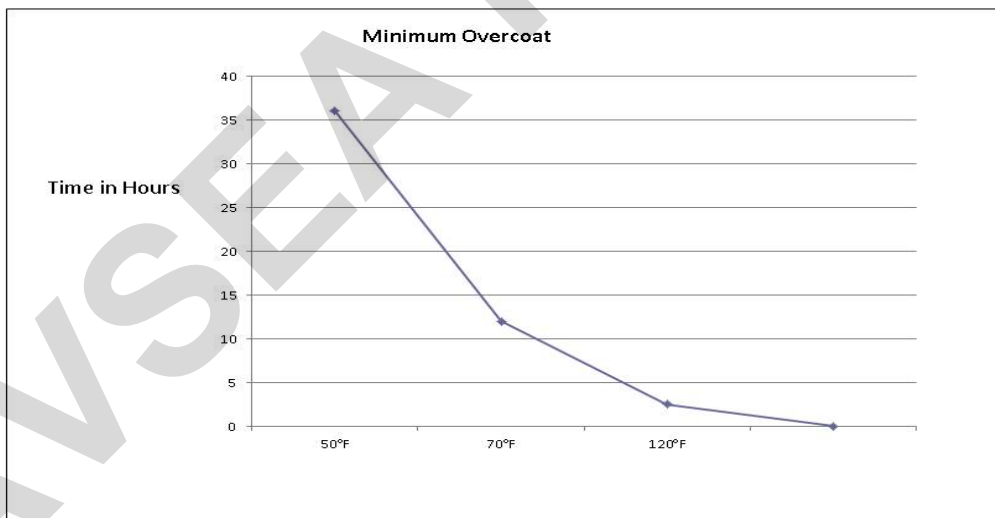
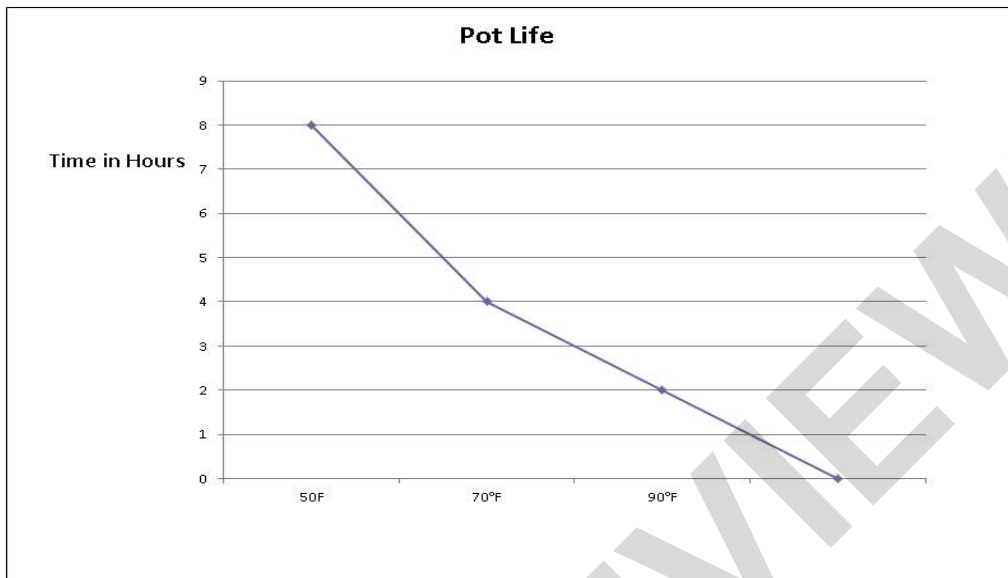
## (d) EQUIPMENT REQUIREMENTS: Spray application preferred using airless equipment. May be rolled or brushed.

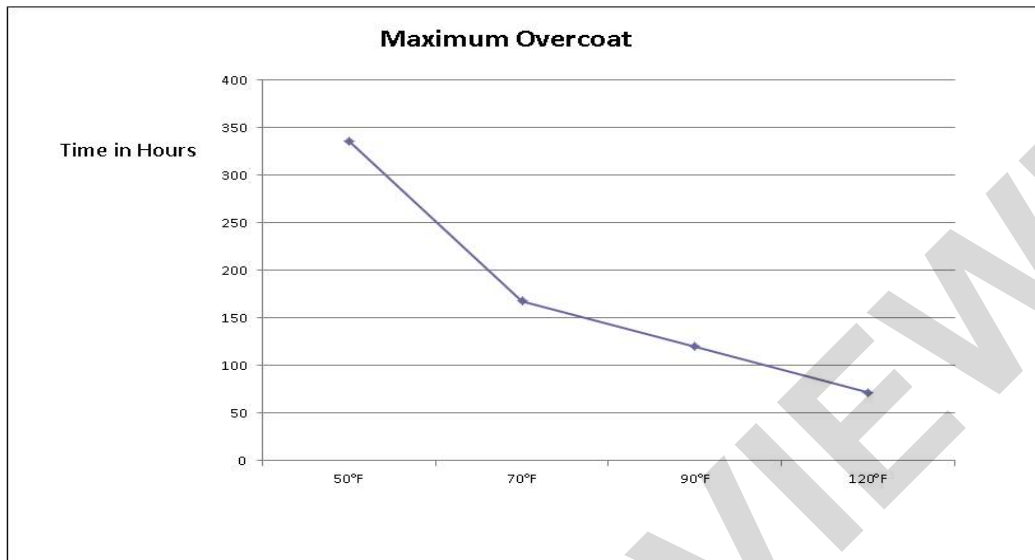
## (e) SPECIAL INSTRUCTIONS: see below

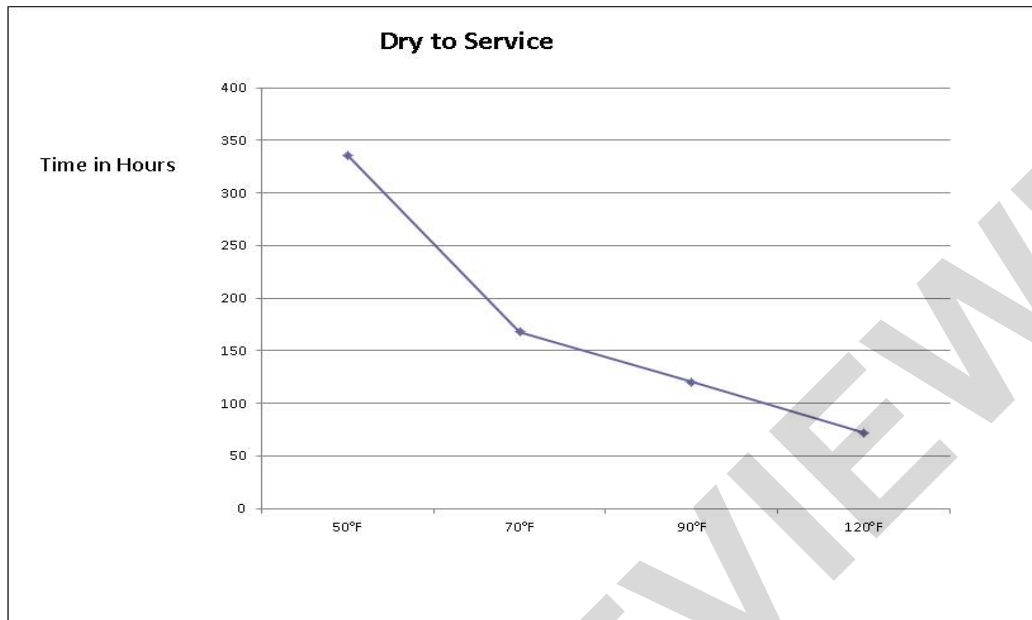
IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR CRITICAL APPLICATIONS: Refer to NAVSEA Standard Item 009-32.

IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR NON-CRITICAL APPLICATIONS: The entire surface shall be cleaned in accordance with SSPC-SP 1 and then lightly abraded with abrasive blast power sanding or by hand sanding. The surface should then be solvent cleaned SSPC-SP 1 again and allowed to dry. A tack coat of 2 – 3 mil wet film thickness of primer should then be applied. Minimum dry time for overcoating of the tack coat shall follow the dry time schedule given in Section VI (c).

GRAPHS FOR POT LIFE AND CURE TIMES:







## ADDITIONAL DATA/INSTRUCTIONS:

I. GENERIC TYPE AND DESCRIPTION: N/A

II. MANUFACTURERS DATA: N/A

III. PROPERTIES: N/A

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS: N/A

V. MIXING PROCEDURES: N/A

VI. APPLICATION: N/A