Randolph Products Company

Randogrip Color Topping, Acrylic Epoxy for VLA Markings

PRODUCT DESIGNATIONS

Part A: 865W01 White; 865R01 Red; 865D01 Gray; 865Y01 Yellow; 865D02 Haze Gray; 865G01 Green; 865K01 Black

Part B: 860C01

MIL-PRF-24667

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

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

I. GENERIC TYPE AND DESCRIPTION: Acrylic Epoxy for VLA Markings Date: 4/20/2020
Specification Number: MIL-PRF-24667
NOTE: For Type/Grade/Class/Application information see QPD-24667

II. MANUFACTURERS DATA:

(a) MANUFACTURER: Randolph Products Company

(b) PRODUCT DESIGNATION: Randogrip Color Topping: Part A: 865W01 White; 865R01 Red; 865D01 Gray; 865Y01 Yellow; 865D02 Haze Gray; 865G01 Green; 865K01 Black; Part B: 860C01

(c) COLOR(S): (SAE-AMS-595 – 37875; 31136; 36076; 33538; 36270; 14062; 37038 respectively)

(d) USES: Color Topping for Non Skid

(e) TECHNICAL SERVICE REPRESENTATIVE: Carol Rosler Phone: 413-592-4191; Fax: 413-594-7321; E-mail: crosler@randolphproducts.com

III. PROPERTIES:

(a) PERCENT VOLUME SOLIDS (ASTM D2697): 61 +/- 2 %

(b) PERCENT WEIGHT SOLIDS (ASTM D2369): 74 +/- 2 %

(c) FLASH POINT (ASTM D3278):

Part A: >102 °F (>39 °C)

Part B: 103 °F (39.4 °C)

Mixed: 103 °F (39.4 °C)

(d) WEIGHT PER VOLUME (ASTM D1475):

Part A: 10.87 +/- 0.5 lb/gal (1303 +/- 60 g/L)

Part B: 8.4 +/- 0.2 lb/gal (1007 +/- 24 g/L)

Mixed: 10.6 +/- 0.5 lb/gal (1270 +/- 60 g/L)

(e) PERCENT EDGE RETENTION, IF REQUIRED BY APPLICABLE SPECIFICATION (N/A): N/A %

(f) SHELF LIFE: 12 Months

(g) VISCOSITY (ASTM D2196):

Part A: 1500 – 3000 cps @ 25 °C (77 °F)

Part B: 300 – 500 cps@ 25 °C (77 °F)

Mixed: 1000 - 2000 cps@ 25 °C (77 °F)

(h) PACKAGING: 6 ½ gallon pail kits and gallon kits

(i) NUMBER OF COMPONENTS: 2

(j) GLOSS (ASTM D523): N/A GU

(k) STORAGE REQUIREMENTS: TEMPERATURE: 40 °F (4.4 °C) MIN. 100 °F (37.8 °C) MAX.

ADDITIONAL PAINT STORAGE REQUIREMENTS: N/A

(l) VOLATILE ORGANIC COMPOUNDS (VOCS- EPA TEST METHOD 24): 2.65 lb/gal (317.6 g/L)

(m) WEIGHT PER AREA OF DRY FILM AT 1 MIL THICKNESS: 0.008 lb/sq. ft. (40.3 g/m²)

(n) SPECIAL PROPERTIES:N/A

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS:

(a) INITIAL CLEANLINESS: Remove grease, oil, and dirt by solvent cleaning (SSPC-SP 1). Apply over recommended anticorrosive primer.

(b) TOUCH-UP CLEANLINESS: Remove grease, oil, and dirt by solvent cleaning (SSPC-SP 1). In hard to reach areas, use power tool, chipping, sanding, descaling, and grinding (SSPC-SP 2).

(c) PROFILE (N/A): N/A mils MIN. N/A mils MAX.

(d) SPECIAL INSTRUCTIONS: N/A

(e) PRIMER REQUIREMENTS: Apply over recommended anticorrosive primer or nonskid.

(f) MAXIMUM ALLOWABLE CONDUCTIVITY (ASTM ISO 8502-9):

70 micro-siemens/cm

(g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWED: N/A

SPECIAL SAFETY PRECAUTIONS:

CAUTIONS TO BE TAKEN IN HANDLING AND STORING: Read SDS 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 after handling and before eating, drinking or smoking. Remove contaminated clothing and wash before use. Keep away from flame or other ignition source. Avoid extreme heat.

V. MIXING PROCEDURES

(a) MIXING RATIOS BY WEIGHT: 12.3:1 (Part A to Part B)
BY VOLUME: 9:1 (Part A to Part B)

(b) INDUCTION TIME: Zero Minutes

(c) RECOMMENDED CLEANING SOLVENT (NO THINNING ALLOWED): Propylene Glycol Monomethyl Ether; Aromatic Naphtha or Methyl n-Amyl Ketone

(d) POT LIFE:

1 Hr @ 100 °F (37.8 °C)
4 Hrs @ 70 °F (21 °C)
6 Hrs @ 50 °F (10 °C)

Graphs included on page: 4

(e) SPECIAL INSTRUCTIONS: Pre-mix 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. Use a high torque drill suitable for mixing heavy materials. A jiffy blade or vortex paddle should be used for mixing. Mix Part A and Part B together for a minimum of 3 – 5 minutes or until the mixed material assumes a uniform color and appearance. Scrape the sides of the pail 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 (48.8°C) MAX.
AMBIENT TEMPERATURE: 55°F (12.8°C) MIN. 100°F (37.8°C) MAX.
DIFFERENCE ABOVE THE DEW POINT: 5 °F (-15 °C)
MAXIMUM PERCENT RELATIVE HUMIDITY: 85 %

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

3 mils WET MIN. 5 mils WET MAX.
2 mils DRY MIN. 3 mils DRY MAX.

TOTAL SYSTEM:

2 mils DRY MIN. 3 mils DRY MAX.

(c) DRY TIMES (ASTM D1640):

Minimum Overcoat Window:

18 Hours @ 40 °F (4.4°C)
12 Hours @ 70 °F (21.1°C)
6 Hours @ 120 °F (48.8°C)

Maximum Overcoat Window:

720 Hours @ 40 °F (4.4°C)
336 Hours @ 70 °F (21.1°C)
100 Hours @ 120 °F (48.8°C)

Dry to Handle:

12 Hours @ 40 °F (4.4°C)
5.5 Hours @ 70 °F (21.1°C)
1.5 Hours @ 120 °F (48.8°C)

Dry to Service:

336 Hours @ 40 °F (4.4°C)
168 Hours @ 70 °F (21.1°C)
72 Hours @ 120 °F (48.8°C)

Graphs included on page 4, 5 and 6 or additional information included on page N/A

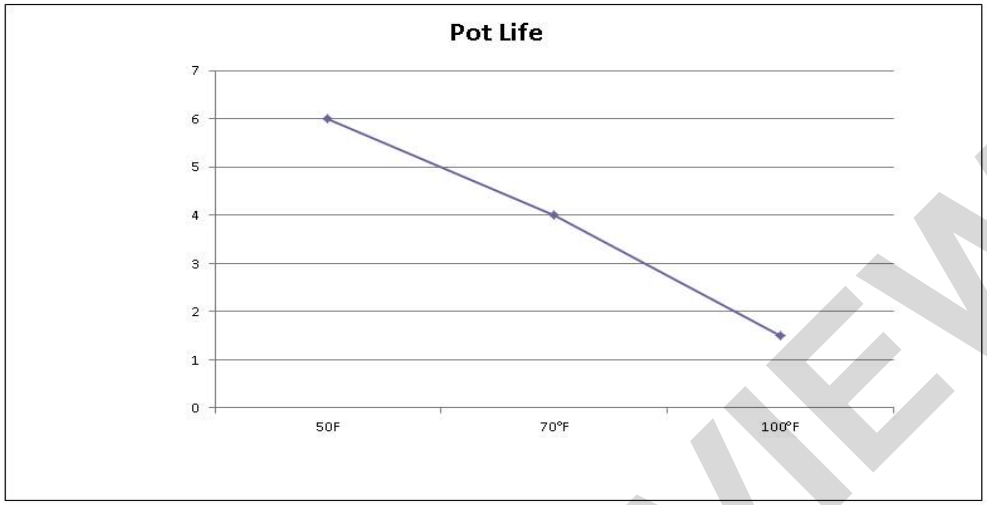
(d) EQUIPMENT REQUIREMENTS: Roller, brush or spray for application.

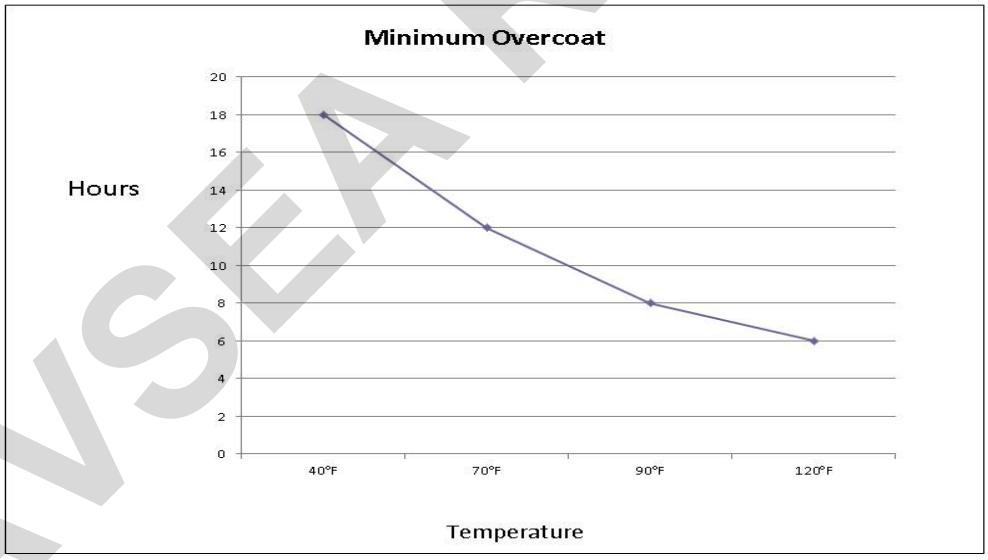
(e) SPECIAL INSTRUCTIONS: Do not apply if the humidity exceeds 85%. Ensure that the surface temperature is a minimum of 5 degrees F above the dew point prior to application.

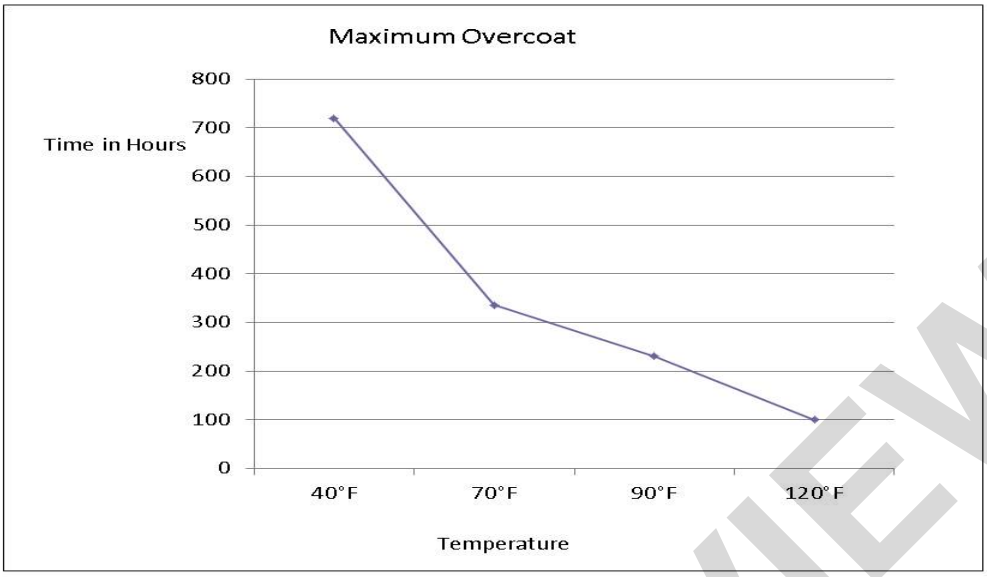
IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR CRITICAL APPLICATIONS: Clean surface of coating per SSPC-SP 1. Abrade the surface with 80 grit sandpaper or equivalent to promote adhesion, clean surface to SSPC-SP 1 again prior to applying coating.

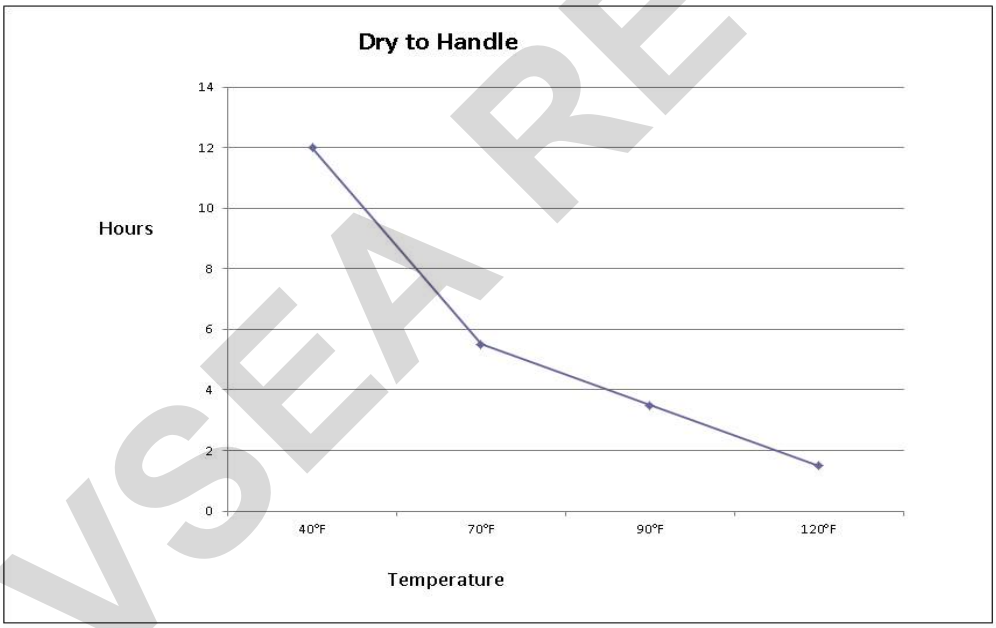
IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR NON-CRITICAL APPLICATIONS: Clean surface of coating per SSPC-SP 1.

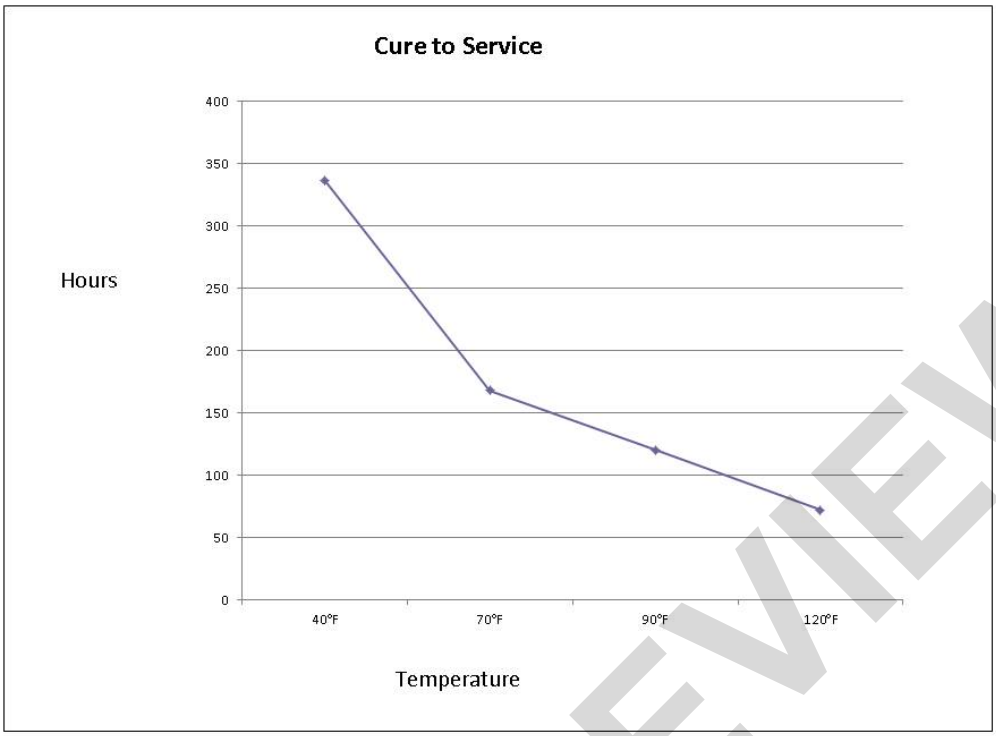
GRAPHS FOR POT LIFE AND CURE TIMES:











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: Dry times are normally a function of humidity, ventilation and temperature. The information given is to be used as a guideline only.