

ASTM F 718

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED:  YES  NO

Date: 6/29/2009 Rev.010-1

I. GENERIC TYPE AND DESCRIPTION: **COLORFLAKE M CHIPS**  
(IMO/Blended Colors/Solid Colors)

Specification Number, Type, Class and/or Grade (If Applicable): **MIL-PRF-24613 TYPE I, CLASS 2**

II. MANUFACTURERS DATA:

- (a) MANUFACTURER: **CROSSFIELD PRODUCT CORPS.**  
**DEX-O-TEX MARINE PRODUCT LINE**
- (b) PRODUCT DESIGNATION: **0443 / 0443-50 / 0443-CF / 0443-CF-50 / 0443-IMO / 0443-IMO-CF**
- (c) COLOR(S): **Assorted**
- (d) USES: **Use with Colorflake M System, Colorflake VP System and Elastaflake System.**
- (e) TECHNICAL SERVICE REPRESENTATIVE  
(Include Telephone Nos.): **STEVEN SCHROEDER 310-886-9100**
- (f) NOT RECOMMENDED FOR: **N/A**

III. PROPERTIES:

- (a) % VOLUME SOLIDS (ASTM D 2697): **100%**
- (b) % WEIGHT SOLIDS (ASTM D 1475): **100%**
- (c) FLASH POINT (ASTM TEST METHOD D 93 OR D 56 OR D 3278): **N/A**
- (d) WEIGHT PER VOLUME: (FTMS 141a4184.1): **N/A**
- (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): **NA**
- (h) PACKAGING: **25 lb Bag / 50 lb Bag**
  - (i): NUMBER OF COMPONENTS: **Three (3) in Colorflake M System**
- (j) GLOSS (ASTM D 523): **N/A**
- (k) STORAGE REQUIREMENTS: TEMP. MIN. **65°F** MAX. **80°F**  
ADDITIONAL PAINT STORAGE REQUIREMENTS: **Dry Area, No in direct sunlight.**
- (l) VOLATILE ORGANIC COMPOUND (EPA TEST METHOD 24): **0 g/L**
- (m) WEIGHT OF DRY FILM (WEIGHT/FT<sup>2</sup> AT 1 MIL THICKNESS): **N/A**
- (n): SPECIAL PROPERTIES (e.g., STAIN RESISTANCE, LOW SOLAR ABSORBANCE, MOISTURE TOLERANCE): **N/A**

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

**After the Colorflake M Basecoat has cured for at least twelve (12) hours, mix and apply one (1) coat of Colorflake M Grout/Sealer (E & F Components).**

- (a) INITIAL - **N/A**
- (b) TOUCH-UP - **N/A**
- (c) PROFILE (INCLUDE METHOD USED) - **N/A**
- (d) SPECIAL INSTRUCTIONS - **None**
- (e) PRIMER REQUIREMENTS (IF APPLICABLE): **N/A**
- (f) MAXIMUM ALLOWABLE CONDUCTIVITY (BRESLE PATCH METHOD): Refer to NAVSEA Standard Item 009-32 - **N/A**
- (g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWABLE (LIST COMMERCIAL STANDARD): **N/A**

SPECIAL SAFETY PRECAUTIONS:

**See MSDS for IMO Colorflake M Chips**

V. MIXING PROCEDURES: Pour Colorflake M Grout/Sealer Component F into Component E and blend thoroughly with a Jiffy blade, taking care not to stir air into the mix (do not lift the Jiffy blade out of the combined materials while blending). Pour blended Colorflake M Grout/Sealer into a large paint pan (to lengthen pot life and allow entrained air to escape). Spread the blended materials over the cured Colorflake M Basecoat using a medium nap Mohair roller, evenly spreading the coating.

As the Grout/Sealer coat levels, broadcast the Colorflake chips into the wet material. As an area is "chipped", it should be back-rolled with Colorflake M Grout/Sealer to flatten and Encapsulate the chips.

- (a) MIXING RATIOS BY WEIGHT - **N/A**  
BY VOLUME - **N/A**
- (b) INDUCTION TIME - **N/A**
- (c) RECOMMENDED SOLVENT – THINNING – NO THINNING ALLOWED – **N/A**  
CONFINED AREAS - NO THINNING ALLOWED – **N/A**  
NON-CONFINED AREAS - NO THINNING ALLOWED – **N/A**  
CLEAN UP - **N/A**
- (d) THINNING REQUIREMENTS (RATIO) – NO THINNING ALLOWED – **N/A**
- (e) POT LIFE - **N/A**
- (f) SPECIAL INSTRUCTIONS – Care must be take to uniformly broadcast the Colorflake chips into the Grout/Sealer while it is still wet. Shoes with **golf spikes MUST** be used to walk on the Grout/Sealer during this operation. **Do not walk on areas** once they have been covered with Colorflake chips.

VI. APPLICATION:

- (a) ENVIRONMENTAL LIMITATIONS -

SUBSTRATE TEMPERATURE: MIN. **45° F** MAX. **95° F**

MINIMUM SUBSTRATE TEMPERATURE DIFFERENCE ABOVE THE DEW POINT - **5%**

RELATIVE HUMIDITY: Refer to NAVSEA Standard Item 009-32 - **N/A**

MAXIMUM PERCENT RELATIVE HUMIDITY – **90%**

AMBIENT TEMPERATURE: MIN. **45° F** MAX. **100° F**

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

PER COAT:

WET MIN. **62.5 mils** WET MAX. **125 mils**

DRY MIN. **62.5 mils** DRY MAX. **125 mils**

TOTAL SYSTEM: **N/A**

- (c) DRY TIMES (ASTM D 1640) – **12 hours**

PROVIDE EITHER A GRAPH OR A CHART PER PARAGRAPH 3.9.1 SHOWING THE FOLLOWING CURE TIMES AT A MINIMUM:

- 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

THE GRAPH OR CHART SHALL HAVE AT A MINIMUM EACH OF THESE TIMES AT THE STATED MINIMUM AND MAXIMUM AMBIENT TEMPERATURES, AND AT LEAST ONE DATA POINT IN BETWEEN (E.G., IF A PRODUCT CAN BE APPLIED AS LOW AS 40 F, AND AS HIGH AS 100 F, THE CHART OR GRAPH MAY HAVE DRY TO RECOAT, DRY TO HANDLE, MAX RECOAT AND CURE TO FULL SERVICE TIMES FOR 40 F, 100 F, AND 70 F. FOR PRODUCTS WHERE HUMIDITY AFFECTS CURE TIMES, ADDITIONAL CHARTS AND/OR GRAPHS WILL BE REQUIRED FOR DIFFERENT AMBIENT RELATIVE HUMIDITY CONDITIONS.

- (d) EQUIPMENT REQUIREMENTS (INCLUDE PREFERRED, SUITABLE, NOT SUITABLE REQUIREMENTS) – **N/A**

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

IF HEATED LINES ARE REQUIRED, STATE SO – **N/A**

- (e) SPECIAL INSTRUCTIONS – **N/A**

REPAIR PROCEDURES IF THE OVERCOAT WINDOW HAS BEEN EXCEEDED: **N/A**

ASTM F 718 CONTINUATION SHEET FOR

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

Date: 6/21/2009 Rev.010-1

I. GENERIC TYPE AND DESCRIPTION: N/A  
Specification Number (If Applicable): N/A

ADDITIONAL DATA/ INSTRUCTIONS: N/A

II. MANUFACTURERS DATA: N/A

ADD ADDITIONAL COMMENTS FROM PART II HERE: N/A

III. PROPERTIES: N/A

ADD ADDITIONAL COMMENTS FROM PART III HERE: N/A

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

ADD ADDITIONAL COMMENTS FROM PART IV HERE: N/A

V. MIXING PROCEDURES: N/A

ADD ADDITIONAL COMMENTS FROM PART V HERE: N/A

VI. APPLICATION REQUIREMENTS: N/A

ADD ADDITIONAL COMMENTS FROM PART VI HERE: N/A