

---

**NAVSEA REVIEWED ASTM F-718**

Crossfield Products Corp.

Terrazzo M Bondcoat Unit 1

---

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:

NST Center  
(502) 638-4400  
[F718Admin@nstcenter.com](mailto:F718Admin@nstcenter.com)



I. GENERIC TYPE AND DESCRIPTION: Epoxy Bondcoat (1 gallon)  
 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: 0565 – Terrazzo M Bondcoat Component A  
0566 – Terrazzo M Bondcoat Component B
- (c) COLOR(S): CLEAR, straw to pale yellow
- (d) USES: CLEAR BONDCOAT
- (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): 1.25 lbs/ft<sup>2</sup> at 1/16"
- (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: 1 Unit – Supplied as a unit in two separate containers (A & B)
- (i) NUMBER OF COMPONENTS: Two (2)
- (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/FT<sup>2</sup> AT 1 MIL THICKNESS): 0.005 lbs
- (n) SPECIAL PROPERTIES (e.g., STAIN RESISTANCE, LOW SOLAR ABSORBANCE, MOISTURE TOLERANCE): Moisture Absorption: 1.4%

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

Metal decks surface should be cleaned free of rust, loose scale, and dirt. Grease and oil should be removed with approved solvents and clean rags. The resulting surface should be clean and bright and protected against corrosion before Dex-O-Tex materials are applied. Terrazzo M may be applied to a cured Navy Formula 150 Primer, MIL-DTL-24441.

- (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:

Use good ventilation, avoid breathing vapors and use a fan to circulate fresh air. Always obtain, read & observe Manufacturer's Material Safety Data Sheet before handling polymeric resin materials.

V. MIXING PROCEDURES:

- (a) MIXING RATIOS BY WEIGHT – 3.5 parts Component A : 1 part Component B  
BY VOLUME – 3 parts Component A : 1 part Component B
- (b) INDUCTION TIME - 10 minutes
- (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
- (e) POT LIFE - 30 minutes at ambient temperature of 70°F TO 75°F (21°C TO 24°C)
- (f) SPECIAL INSTRUCTIONS – MIXING: The Bondcoat A & B Components are supplied as a unit in two separate containers. Combine A & B Components into a clean can and stir until thoroughly blended. Working time of this mixture is approximately two hours at (70°F). Allow blended Bondcoat to stand ten minutes before using.

VI. APPLICATION:

(a) ENVIRONMENTAL LIMITATIONS -

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

MINIMUM SUBSTRATE TEMPERATURE DIFFERENCE ABOVE THE DEW POINT - 5%

MAXIMUM PERCENT RELATIVE HUMIDITY: Refer to NAVSEA Standard Item 009-32 – 90%

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

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

PER COAT:

WET MIN.: 5 mils

WET MAX.: 6 mils

DRY MIN.: 4.5 mils

DRY MAX.: 5.4 mils

TOTAL SYSTEM: MIN: 4.5 mils MAX: 5.4 mils

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

- 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) – Wallpaper Smooth Brush or Rubber-Edged Plaster's Squeegee

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

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

- (e) SPECIAL INSTRUCTIONS – Apply Terrazzo M Bondcoat by trowel, brush or hand squeegee. Apply only a thin coating. Apply evenly and remove all excess; leave no puddles. A unit of Terrazzo M Bondcoat will cover approximately 300 sq ft. (27.87 sq. meters) on steel decking when applied with squeegee.

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.