



Application Specification

P-61 TERRAZZO

Purpose and scope

Instructions for the application and dry-grind finishing of P-61 Terrazzo over a prepared surface. P-61 Terrazzo is manufactured to meet the requirements of MIL-D-3134, Type I, Class 1.

Thickness..... 1/4” – 3/8” (6.35mm-9.53mm)

Approximate Quantity of Materials Required

To Cover ONE HUNDRED SQ. FT (9.3 sq. Meters)

Bonding Coat

Magnabond Paste (5 – gal. can).....0.20 cans
Magnabond Powder (40 – lb. bag)..... 1.00 bags

<u>THICKNESS</u>	
1/4 inch (6.35 mm)	3/8inch (9.53mm)

P-61 Terrazzo Deck Covering

Terrazzo Mix (36 lb. bag).....	4.0 bags	12.0 bags
P-61 Paste (5 – gal. can).....	1.12 cans	1.66 cans
P-61 Grout Powder (5 – gal. can)8 bags8 bags
No. 6 Clearseal (1 or 5 – gal. can)3 gal.3 gal.

Required Equipment

Visqueen Sheeting
 Rectangular Steel Trowels (4”x14”) (10cm x 35cm)
 Dex-O-Tex Drill Mixing Equipment
 Terrazzo Sanding Machine
 Spinner
 Calcimine Brush
 Flat, thin sponges
 Industrial vacuum with wet and dry pick-up
 One gallon measure (U.S. Liquid Standard)
 Terrazzo Grinder (Handy Grinder or Border Machine)*

*Required for wet grinding only.

STEP ONE – Bonding and Leveling

The area to be covered with P-61 Terrazzo should be cleaned of all dirt, dust, grease, oil, paint, rust and scale. Any leveling of the surface required in excess of 1/8” (3.18 mm) thickness should be filled with Subkote 1 (Military Specification MIL-PRF-3135, Type I). All other surfaces, including vertical surfaces, must receive the bonding coat of Magnabond 3.

Mix together the following materials to form the Bond Coat:

Magnabond Paste	1 gallon
Magnabond Powder	1 bag, (40 lbs.)

Thoroughly blend the above materials by Dex-O-Tex Drill Mixing. Trowel apply to all surfaces.

The above materials should cover approximately 100 sq. ft. (9.3 m²) of surface. Allow to dry overnight.

STEP TWO – Terrazzo Body Coat

- A. Pour the contents of one bag of Terrazzo Powder into a clean, dry mixing pail (10 gallon capacity) and thoroughly “dry mix”. This is necessary in order to achieve good marble chip distribution.
- B. Mix together the following materials to form the Terrazzo Mix:

P-61 Paste.....	1 gallon
Terrazzo Powder	2 bag, (36 lbs.)

CAUTION:

The resulting mix must be dry enough so that it can be troweled into a dense, compact mass. A mix that is sloppy and will not “close up” when troweled is too wet and must not be used. To get a dry mix, it may be necessary to hold back a small amount of the P-61 Paste in the above mix.

Thoroughly blend the above materials by Dex-O-Tex Drill mixing. It is most important that the Terrazzo is completely and thoroughly blended to insure uniform dispersion of the chips. The above



Application Specification

P-61 TERRAZZO

quantity will cover about 20 sq. ft. (1.86 m²) in ¼” (6.35 mm) thickness. Workability time is approximately 20 minutes.

- C. The Terrazzo should be applied by first “placing the material by edge troweling and then flat troweling the Terrazzo into a dense, compact mass. Care must be taken to do the smoothest and densest trowel job possible as it is impossible to make an attractive floor if the troweling is poor. Smooth, dense troweling is best achieved by working to a guide strip and by frequently checking the level of the Terrazzo with a straight edge. In the event the Terrazzo material should be sprinkled over the “open” area and then troweled flat.
- D. Each batch must be carefully worked into the previous batch so that no “cold joints” will show. To keep an edge fresh while doing other areas or when working under fast drying conditions, cover the old edge with a damp burlap to keep the material from setting. As you join a new batch to the old line, remove the damp burlap and cut back the edge of the old material about an inch and work the new material into the fresh edge.

STEP THREE - Rough Cut Sanding

NOTE

Wet grinding using a small Terrazzo grinder (Handy Grinder or small Border Machine) may be preferable to dry grinding, depending on working conditions.

- A. Rough cut sanding should be done with a disc-type floor, sanding machine mounting 1½ closed-coat sandpaper. Keep the sander moving continuously to avoid scoring the floor with the drum or creating excessive heat (which will fracture the marble chips). Make several “passes” over the same area then move on. Make another series of passes at 45° angles to the first.

At the conclusion of each “pass”, tilt the machine back to prevent a score mark from showing on

the floor. Edges should be sanded with an edger or spinner – take care to keep these tools moving continuously so as not to cut too deeply. All small pits and pores in the surface will be filled in later by grouting.

An alternative to this is to wet grind the floor using adequate air-powered grinding tools.

- B. Flush the floor with water and slowly pass the nozzle across the floor so that all slopes are removed from the small pores in the surface. Allow the floor to dry completely.

STEP FOUR – Grouting and Final Grinding

- A. Grouting Mix:

P-61 Paste 2 gallons
 Grout Powder 1 bag, (40 lbs.)

The grout is mixed as follows: Pour a small quantity of grout onto the surface and scrape-trowel it into all pits and pores. Grouting can also be accomplished by scrubbing grout into all pits and pores using a piece of clean burlap. Remove all excess grout from the surface by scrape – troweling. Allow the grout to dry overnight.

- B. Do the final sanding with a Disc Machine mounting ½ grit sandpaper. Do no more grinding than necessary to remove the grout film off the top of the marble chips.
- C. Thoroughly wash floor, clean of all dust. Allow the floor to dry completely and keep traffic off the floor until after sealing.

STEP FIVE – Sealing

Apply Clearseal No. 6 using a flat, thin sponge. The sealer should be spread in thin, even coats with the sponge wrung fairly dry. Apply two coats, allowing previous coat to dry before proceeding with the next. Apply the second coat across the direction of the first. For easier application, use a sponge mop with a



Application Specification

P-61 TERRAZZO

wide head. Consult “Sealer and Dressing Guide” for other types of Dex-O-Tex Clearsealers compatible with this system.

Cautions

1. In storage, keep powders dry. Do not let paste freeze. Storage life – one year.
2. Do not install if temperature is under 50°F in the area.



DOT MARINE PRODUCT LINE
Crossfield Products Corp.

West Coast Office
3000 E. Harcourt Street
Rancho Dominguez, CA
90221
310-886-9100
310-886-9119 fax

East Coast Office
140 Valley Road
Roselle Park, NJ
07204
908-245-2800
908-245-0659 fax

www.dexotexmarine.com