



Application Specification

TERRAZZO M

Purpose and Scope

To outline instructions for application of Dex-O-Tex Terrazzo M, a terrazzo-like interior deck covering. This material is manufactured to meet the requirements of MIL-D-3134, Type I, Class 2, and MIL-PRF-24613(SH), Type I, Class 3, Deck Covering Materials, Interior, Cosmetic Polymeric.

Thickness..... 1/4” (6.35 mm)

Approximate Quantity of Materials Required

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

Thickness
1/4 inch (6.35 mm)

Terrazzo M Basecoat Topping

Terrazzo M Bondcoat
(A & B Components) 33 unit

Terrazzo M Basecoat
Topping Kit3.85 units
(C & D Components and Aggregates),
Packed in 6-gallon container) or 56 lbs. of Aggregate, with C & D Components packed in cartons)

Terrazzo M Grout Resins

E & F Components..... 1.00 unit

Terrazzo M Sealer Resins

G & H Components.....22 units

NOTE: For Small Areas:

Terrazzo M Bondcoat (Components A & B) and Terrazzo M Grout Resins (Components E & F) and Sealer Resins (Components G & H) are available in ½ or ¼ units.

Terrazzo M Basecoat Topping (Components C & D and Aggregate) is available in ½ unit kit, packaged in 3.5-gallon container.

Equipment Required

Dex-O-Tex mixing blade mounted in slow speed
(275 RPM), ¾” (19 mm) drill “Jiffy” Blade
(small size)

Rubber-Edged Plasterer’s squeegees; one 12” (30 cm) and one 6” (15 cm)

Steel Trowel (3” x 12”) (8 cm x 30 cm)

Plasterer’s Trowel (4” x 16”) (10 cm x 40 cm)

Industrial Vacuum

Disc and/or Spinner Sander with No. 1-1/2 closed-coat sanding disc

Good lighting, preferably deck level drop lights

Approved solvent for cleaning tools

Protective gloves and handcream

Surface Preparation

Metal deck surfaces 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 or to Terrazzo M Underlayment installed in accordance with Dex-O-Tex Application Specification S-108M (Marine). Consult Crossfield Products Corp. when wood or other deck surfaces are involved.

Material Temperature

The temperature of the materials should be between 65°F to 80°F (18°C to 27°C) for best mixing and application properties.

Application Temperature

Deck surface and room temperature of 65°F to 75°F (18°C to 24°C) must be maintained for at least 24 hours for proper curing after installation.

Application Procedure

Separate the following materials so that they will not be intermixed:

Terrazzo M Bondcoat (A & B Components packed in cartons).

Terrazzo M Basecoat Topping (C & D Components and Aggregate packed in 6-gallon pails) or 56-lb. bags of Aggregate with C & D Components packed in cartons).

Terrazzo M Grout Resins (E & F Components packed in cartons).

Terrazzo M Sealer Resins (G & H Components packed in cartons).



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STEP ONE – Terrazzo M Bondcoat

The Bondcoat A & B Components are supplied as a unit in two separate containers.

After the surface to be covered has been properly prepared, pour the contents of the can containing Terrazzo M Bondcoat Component B into the can containing Component A. Blend thoroughly with the “Jiffy” blade or other mechanical means for two (2) minutes. Terrazzo M Bondcoat has a pot life of approximately 1/2 hour at ambient temperature of 70°F to 75°F (21°C to 24°C). The working time of the material will be lengthened if it is poured out of the mixing pail and either onto the surface and then worked from there, or else poured into a wide receptacle (such as a paint roller tray) and then worked from that.

A unit of Terrazzo M Bondcoat will cover approximately 300 sq. ft. (27.87m²) on steel decking when applied with squeegee.

Apply Terrazzo M Bondcoat by trowel, brush, or hand squeegee. Apply only a thin coating. Apply evenly and remove all excess; leave no puddles.

Terrazzo M Bondcoat may be applied in any one of the following techniques listed below:

1. Apply to small area in a very thin coat with squeegee or trowel immediately prior to application of Terrazzo M Basecoat Mix. **LEAVE NO PUDDLES.**
2. Apply as to above to large area and subsequently install Terrazzo M Basecoat Mix over wet Terrazzo M Bondcoat with mechanics working on kneeboards. Be careful not to bring the Bondcoat up into the Terrazzo M Basecoat Mix.
3. Apply to large area and sprinkle a small amount of dry Terrazzo M Aggregate on the wet Bondcoat surface. Apply Terrazzo M Basecoat the next day. The aggregate will produce “tooth” which will keep the Basecoat from sliding on the dried Bondcoat surface.

STEP TWO – Terrazzo M Basecoat Topping

Apply the Terrazzo M Bondcoat as described in Step One to a prepared steel surface or to the Terrazzo M Underlayment. The somewhat open texture of the surface of the underlayment may reduce the spread rate of the Bondcoat required to approximately 150 sq. ft. (13.94m²) per unit (1 gallon).

The Terrazzo M Basecoat, C Component (1 gal. can) and the D Component (1-qt. can), are normally packaged in a 6-gallon pail along with the measured quantity of colored marble aggregate to provide proper proportions.

Remove the cans containing Components C and D from the 6-gallon pail and “pre-blend” the colored marble aggregate using the Dex-O-Tex mixing blade mounted in a slow-speed ¾” (19 mm) drill.

Pour the D Component into the can containing the C Component (be sure to scrape out all the D Component to mix into the Component C. Blend thoroughly with a “Jiffy” blade for two to three (2-3) minutes to insure complete blending of the resins.

Then, into a clean 6-gallon (or larger) container, pour the thoroughly blended resins. Add the pre-blended aggregate portion to the resin mix and with the Dex-O-Tex mixing blade, blend the aggregates and resins thoroughly for two to three (2-3) minutes. “Box” the mixed terrazzo material into another clean pail and re-blend to be sure resin binder liquid is uniformly coating the aggregate particles.

Terrazzo M Topping Mix will give a workable composition with a pot life of one hour at 70°F to 75°F (21°C to 24°C), capable of being troweled to an even, dense surface in a minimum thickness of ¼” (6.35 mm). It can be installed in thicknesses greater than 1/4” (6.35mm) when desired. Place the necessary amount of Terrazzo M Basecoat Topping Mix in several small piles onto the area previously coated with Terrazzo M Bondcoat (see Step One above) and spread out with trowel or float to the thickness and plane desired. Following this, compact



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the material into a dense surface with a 4" x 16" (10 cm x 40 cm) rectangular trowel. Be sure when Dex-O-Tex Basecoat Topping is applied that good light at deck level is available for the observation and correction of "drags", trowel "ridges" or "opens". Opens should be corrected by applying additional material on the surface and compacting into place. The finish should be worked to provide as uniformly dense and smooth a surface as possible. Do not over-trowel, as "trowel-burns", or a metallic staining from the trowel, can result.

A 6-gallon kit of Terrazzo M Basecoat Topping Mix should cover approximately 26 sq. ft. (2.42m²) at 1/4" thickness.

Working time in the container is approximately one hour at room temperature, 70°F to 75°F (21°C to 24°C).

Overnight cure is desirable before application of Terrazzo M Grout Coat.

STEP THREE – Terrazzo M Grout Application

Before grouting, when the Terrazzo M Basecoat is hard enough to be walked on, the surface should be scraped with the edge of the trowel, or, for best results, lightly sanded with a disc or spinner type sander using No. 1-1/2 closed-coat sanding discs, and then vacuumed. The sanding operation will cut down minor trowel licks and any droppings from the trowel application. **DO NOT** concentrate on one spot to eliminate troweling errors. Vacuum up all dirt and dust after sanding.

Take particular care to keep the surface clean of stains, otherwise they will be permanently sealed in. Attention must be given to the cleanliness of the applicators' shoes and kneepads. Mechanics' shoes should be covered with clean polyethylene before they walk on the Terrazzo M surface.

Pour Terrazzo M Grout Resin Component F into Component E and blend together slowly but thoroughly with a "Jiffy" blade. With squeegee,

apply the resulting mix to an even minimum thickness, taking care to leave no puddles or streaks from flow-off from squeegee. A unit should cover approximately 100 sq. ft. (9.3 m²). Allow to cure 8 to 12 hours, or until dry, before re-coating. If the Terrazzo M Basecoat is not properly compacted and "closed-up", an additional coat of Terrazzo M Grout might be necessary. Pot life is 30 minutes maximum.

STEP FOUR – Terrazzo M Sealer Coat

Pour the H Component of the Terrazzo M Sealer Resin into the G Component. Blend slowly but thoroughly for two (2) minutes with a "Jiffy" blade so as not to beat air into mixed material. Pour some of the well-stirred blend onto the surface of the Terrazzo M Basecoat Topping and spread out the material to a minimum thickness, using a squeegee as the applicator. Care should be taken not to leave puddles. A light "back-roll" with 1/4" (6.35 mm) nap roller is recommended to even out ridges in the Sealer coat. Allow to cure overnight. One unit will cover approximately 450 sq. ft. (41.81m²). Working time in the container is approximately 30 minutes.

NOTE: If additional Terrazzo M Sealer coats are desired or required, follow STEP FOUR. Coverage per unit will increase to approximately 600 sq. ft. (55.75m²).

Cautions

1. For proper workability it is important the Dex-O-Tex materials be stored and mixed at a temperature of 65°F-80°F.
2. The substrate temperature should be between 65°F-80°F. A warm substrate will decrease the pot life and make the materials sticky. A cooler substrate will retard the cure and may cause a blush of the polymeric resins. Deck surface and room temperature of 65°F or slightly higher must be maintained for proper curing.
3. When mixing the polymeric resin components, be sure to use all of the provided resins. The resins are pre-measured to the correct ratios. Scrape all of the hardener from the container into the resin.



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4. Do not turn mixing vessels upside down to drain on the flooring surface. Unmixed resin from the side may produce soft or uncured spots on the flooring surface.
5. Keep the unfinished flooring surface clean. Do not track dirt, grease, or any other contaminate onto the unfinished flooring surface. Any contaminate could effect the aesthetics of the finished flooring.
6. Good ventilation must be provided during application, particularly in confined spaces.
7. Always obtain, read and observe Manufacturers Safety Data Sheets (MSDS) before handling polymeric materials. Become familiar with the products on paper before you open the cans.
8. Do not turn mixing vessels upside down to drain on the flooring surface. Unmixed resin from the side may produce soft or uncured spots on the flooring surface.
9. In the event of eye contact, flush immediately with plenty of water for at least 15 minutes. Consult a physician immediately.
10. Mix and apply polymeric resin materials only in conditions of good ventilation. Avoid breathing vapors. A fan to circulate fresh air may be needed. Certain polymeric resin products and/or certain working conditions require use of NIOSH/MSA organic vapor respirator. Consult MSDS.
11. First Aid for inhalation: if effects occur, remove patient to fresh air. If not breathing, give artificial respiration, preferably mouth-to-mouth. If breathing is difficult, give oxygen. Get immediate medical attention.

General Conditions for Safe Handling of Polymeric Resinous Flooring Systems

1. Read and observe precautionary statements on product labels.
2. Keep containers tightly closed.
3. Keep out of reach of children.
4. For industrial use only. Do not allow application by untrained workers.
5. Remove contaminated clothing and shoes. Wash clothing before re-use.
6. Use of safety goggles and chemical resistant gloves is recommended. Wear only full length trousers and long-sleeve shirts. Apply protective creams to exposed skin areas.
7. In general, prolonged contact of polymeric resins with skin may cause irritation. Contact with curing agents may cause skin burns. Products may cause skin sensitization or other allergic responses. Avoid all contact with eyes.
8. In case of contact with skin, immediately remove the material with soap and water. Upon completion of work at lunch time or end of day, carefully check all skin surfaces for any traces of polymeric resins. Wash with soap and water. If wash facilities are not located nearby, establish water washing station at work site. **DO NOT** use solvents to remove polymeric resins from skin as solvents will drive polymeric resins



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