



# Application Specification

# ELASTAFLAKE

## Purpose and Scope

Instructions for the application of Dex-O-Tex Elastaflake decorative deck covering over properly prepared surfaces. This system meets the requirements of MIL-PRF-24613 (SH) Type II, Class 2, Deck Covering Materials, Interior and Cosmetic Polymeric.

**Thickness**..... 1/8” (3.25 mm) Nominal

**Approximate Quantity of Materials Required To Cover ONE HUNDRED SQ. FT (9.3 sq. Meters)**

## Colors

See Dex-O-Tex Color Chart. Other selected Type II, Class 2 colors upon request.

**NOTE:** Decorative colorflakes are not shown on Dex-O-Tex Color Chart. Actual product samples can best illustrate selected deck covering appearance.

Thickness: 1/8” (3.25 mm)

<u>Description/ Packaging</u>	<u>Amount Required</u>
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Terrazzo “M” Underlayment (see “Surface Preparation” below) .....	As required
Terrazzo M Bondcoat, 1 Gal Unit .....	.33 unit
Elastaflake Basecoat Resin, 5 gal. unit .....	1.12 units
Elastaflake Colorcoat, 1 gal. Unit .....	1.33 units
Colorflake Chips, 25 lb. Box .....	As required
T/M Clearseal, 1 Gal Unit .....	1.50 units

**NOTE:** Where Dex-O-Tex Terrazzo M Underlayment is installed to “fair” a deck, it will be necessary to apply a coat of Terrazzo M Grout Resin to the (overnight cured) Underlayment surface before proceeding with application of Elastaflake Basecoat. Terrazzo M Grout Coat should cure at least eight to twelve (8-12) hours at 65°F - 75°F (18°C - 24°C) before application of Elastaflake Basecoat. Coverage for Terrazzo M Grout over Underlayment is approximately 1.15 units per one hundred square feet.

## Equipment Required

- 1/4” or 3/8” Drill
- Jiffy Blade
- Masking Tape
- 1/4” Notched Trowel
- Dex-O-Tex trowel, 3” x 12” (8 cm x 30 cm)
- Rubber-Edged Squeegees (white or red)
- Medium/Heavy Nap Mohair Rollers, Sleeves and Handles
- Wallpaper Smoothing Brushes (natural bristle - not nylon)

## 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. Dex-O-Tex Elastaflake may be applied to a cured Navy Formula 150 Primer, MIL-DTL-24441 or to Dex-O-Tex 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- 85°F (18°C-29°C) for best mixing and application properties.

**Application Temperature:** Deck surface and room temperature of 65°F - 75°F (18°C-24°C) should be maintained for at least 24 hours for proper curing after installation.

**Application Procedure:** Separate materials as follows so they will not be intermixed:

- Terrazzo M Bondcoat (A & B components packed in cartons)
- Elastaflake Basecoat (A component 5 gal. can, B component 1 gal. can packed in cartons)
- Elastaflake Colorcoat, (A & B components packed in cartons)
- Colorflake Chips, (packaged in 25-lb. Boxes)
- T/M Clearseal, (G & H components packed in cartons)



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## STEP ONE – Terrazzo M Bondcoat Application

**NOTE:** Terrazzo M Bondcoat is not necessary over properly grouted Terrazzo M Underlayment.

A. 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 to a homogenous mixture with a power drill motor and jiffy-type mixing blade for approximately 3 minutes. Terrazzo M Bondcoat has a pot life of approximately 1/2 hour at 70°F. The pot life may be extended by pouring the material out of the container onto the surface or into a wide receptacle (such as a paint roller tray).

A unit of Terrazzo M Bondcoat will cover approximately 300 square feet over suitable underlayment or properly prepared surface.

- B. Apply Terrazzo M Bondcoat by brush, roller, trowel, or squeegee. Apply only a thin coating. Apply evenly and remove all excess material. Do not allow excess material to puddle.
- C. Terrazzo M Bondcoat may be applied in three techniques:
1. Apply Terrazzo M Bondcoat to small areas immediately prior to application of Elastaflake Basecoat into the wet Bondcoat.
  2. Apply Terrazzo M Bondcoat to large areas immediately prior to application of Elastaflake Basecoat into wet Bondcoat with trowel mechanics working on kneeboards.
  3. Apply Terrazzo M Bondcoat to the entire area and allow to cure. Apply the Elastaflake Basecoat the following day.

## STEP TWO – Basecoat Application

A. Pre mix the Elastaflake Basecoat urethane resin binder component A for approximately two minutes to properly disperse the material into a homogenous blend. Pour the contents of the can containing Elastaflake Basecoat urethane resin binder component B into the can containing component A. Blend thoroughly to a homogenous mixture with a power drill motor and jiffy type mixing blade for approximately 3 minutes. Allow the mixed material to set a few minutes to allow any excess entrapped air to migrate out of the material.

**NOTE:** This material is a gray color when mixed, but will cure to a brownish color.

- B. Pour Elastaflake basecoat mix onto deck and spread evenly over surface with a 1/4" V-notch trowel. Trowel surface in all directions to produce an even surface and allow material to self-level. Lightly flat trowel if necessary.
- C. A 5-gallon unit of Elastaflake Basecoat urethane resin binder will cover approximately 90 square feet (8.4m<sup>2</sup>) of decking area at 5/64 inch (1.984mm) thickness.
- D. After material has been applied, out gassing will begin to occur (out-gassing is the action which occurs when the volatile compounds which are contained in the resin binder evaporate or migrate out of the material as it cures). Once this out-gassing begins, roll the wet basecoat with a spiked roller to allow an entrapped air or gasses to escape. Continue to roll the basecoat until all entrapped air or gasses are released. Golf shoes or spiked shoes may be worn to walk out on the wet basecoat to roller the basecoat.
- E. The Elastaflake Basecoat urethane may be used to form a cove base. Dex-O-Tex thickener powder will be required to achieve a pasty type mix suitable for vertical application.
- F. Elastaflake Basecoat urethane resin binder has a pot life of approximately 30 minutes 70°F and will achieve initial cure in approximately 6 hours



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at 70°F. Allow to cure 6-8 hours before proceeding.

## **NOTES:**

1. AVOID COLD JOINTS. Lay out job so that cold joints are minimized.
2. TAKE CARE DURING MIXING to avoid blending in excess air into the basecoat.
3. CONDITION MATERIAL to 75°F for a 48 hour period before application.

## **STEP THREE – Color Coat Application**

- A. Remove any trowel marks or other imperfections in the Elastaflake Basecoat. Lightly sand with 80-grit open coat sandpaper if necessary. Wipe the entire surface with a damp cloth to remove all particles or dust just prior to application of the colorcoat. Surface must be thoroughly dry.
- B. Pour the contents of the can containing Elastaflake Colorcoat component B into the can containing component A. Blend thoroughly to a homogenous mixture with a power drill motor and jiffy-type mixing blade for approximately 3 minutes.
- C. Apply the Elastaflake Colorcoat by pouring the mixed resin onto the surface and spread liberally. The approximate coverage is 75 square feet per 1 gallon mix. Spread the material with a high quality short nap roller. Allow to cure approximately 12-16 hours before proceeding.

## **STEP FOUR - Colorflake Application**

After Elastaflake Colorcoat has cured for at least twelve (12) hours, mix and apply one (1) coat of T/M Clearseal (G & H Components) as follows:

1. Pour T/M Clearseal component H into component G 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 material while blending). Pour blended T/M Clearseal into a large paint pan (to lengthen pot

life and allow entrained air to escape). Spread the blended materials over the cured Elastaflake Colorcoat using a medium nap mohair roller, evenly spreading the coating.

2. As the T/M Clearseal coat levels, broadcast the Colorflake chips into the wet material. As an area is “chipped” it should be back-rolled to flatten and “encapsulate” the chips. One unit of T/M Clearseal should cover approximately 150-175 sq. feet. For vertical surfaces, chips are cast against the wet T/M Clearseal and immediately back-rolled to flatten and encapsulate the chips. Care must be taken to uniformly broadcast the Colorflake chips into the T/M Clearseal while it is still wet. **DO NOT WALK ON AREAS** once they have been covered with Colorflake Chips. One bag (25 lbs) of Colorflake chips will be sufficient to “chip” approximately 400 sq. ft. at 40%-60% coverage.

## **STEP FIVE – Clearseal Finish Coat**

The T/M Clearseal Finish is applied in one (1) coat. Pour T/M Clearseal component H into component G and blend thoroughly. Apply the Finish coat liberally with a medium nap mohair roller to prevent puddling. This coat should be spread at the rate of approximately 300-350 sq. ft. per one gallon unit. Elastaflake is intended to have a slightly textured surface.

The Finish coat should be allowed to cure for at least twelve (12) hours at 65°F-75°F (18°C-24°C), before bearing light foot traffic. An additional twenty-four (24) hours is required before full service is restored.

**NOTE:** Additional T/M Clearseal Finish coats may be required or desired for special service conditions. Allow twelve (12) hours drying time between coats. Be sure additional T/M Clearseal materials are on hand before proceeding.

## **Cautions**

1. For proper workability it is important that the Dex-O-Tex materials be stored and mixed at a temperature of 65°F-80°F.



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- 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.
- 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.
- 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.
- 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.
- Good ventilation must be provided during application, particularly in confined spaces.
- 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.
- may cause skin sensitization or other allergic responses. Avoid all contact with eyes.
- In case of contact with skin, immediately remove the material with soap and water. Upon completion of work at lunchtime 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 deeper into skin. If redness or skin rash develop, consult a physician.
- In the event of eye contact, flush immediately with plenty of water for at least 15 minutes. Consult a physician immediately.
- 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.
- 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

- Read and observe precautionary statements on product labels.
- Keep containers tightly closed.
- Keep out of reach of children.
- For industrial use only. Do not allow application by untrained workers.
- Remove contaminated clothing and shoes. Wash clothing before re-use.
- 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.
- In general, prolonged contact of polymeric resins with skin may cause irritation. Contact with curing agents may cause skin burns. Products



**DOT MARINE PRODUCT LINE**  
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