

ASTM F 718

SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED: YES NO

Date: 5/17/2013 Rev. 002

I. GENERIC TYPE AND DESCRIPTION: **ELASTAFLAKE COLORCOAT**

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

II. MANUFACTURERS DATA:

(a) MANUFACTURER: **CROSSFIELD PRODUCTS CORP.
DEX-O-TEX MARINE PRODUCT LINE**

(b) PRODUCT DESIGNATION: **1640-Color
1641 (Hardener)**

(c) COLOR(S):

(d) USES: **Color Coat / Receiving Coat**

(e) TECHNICAL SERVICE REPRESENTATIVE
(Include Telephone Nos.): **STEVEN SCHROEDER 310-8886-9100**

(f) NOT RECOMMENDED FOR: **As Finish Coat for Polymeric Deck Coverings**

III. PROPERTIES:

(a) % VOLUME SOLIDS (ASTM D 2697): **N/A**

(b) % WEIGHT SOLIDS (ASTM D 1475): **N/A**

(c) FLASH POINT (ASTM TEST METHOD D 93 OR D 56 OR D 3278): **N/A**

(d) WEIGHT PER VOLUME: (FTMS 141a4184.1): **NA**

(e) % EDGE RETENTION (IF REQUIRED BY APPLICABLE SPECIFICATION): **N/A**

(f) SHELF LIFE: **One year minimum from date of manufacture.**

(g) VISCOSITY (STATE TEST METHOD TO BE USED): **N/A**

(h) PACKAGING: **1640-Color (Unit 1A) Do Not Split Unit
1641 (Unit 1B)**

(i) NUMBER OF COMPONENTS: **Two (2)**

(j) GLOSS (ASTM D 523): **N/A** (NOTE: This is to be a percentage, not "Gloss," "Semi-gloss," etc.) – **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): **5 g/L**

(m) WEIGHT OF DRY FILM (WEIGHT/FT² AT 1 MIL THICKNESS): **2.9 g**

(n) SPECIAL PROPERTIES (e.g., STAIN RESISTANCE, LOW SOLAR ABSORBANCE, MOISTURE TOLERANCE): **Moisture Absorption: 0.40%**

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

Surface profile is in accordance with SSPC-SP 1 & SSPC-SP 2.

(a) INITIAL - **Remove any trowel marks or other imperfections in the Elastaflake basecoat.**

(b) TOUCH-UP - **Lightly sand with 80-grit open coat sandpaper if necessary.**

(c) PROFILE (INCLUDE METHOD USED) – **N/A**

(d) SPECIAL INSTRUCTIONS - **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.**

(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:

**Use good ventilation. Avoid breathing vapors. A fan to circulate fresh air may be needed.
Always obtain, read and observe Manufacturer's Material Safety Data Sheets before handling polymeric materials.**

V. MIXING PROCEDURES:

(a) MIXING RATIOS BY WEIGHT - **4.5 : 1**
BY VOLUME - **4 : 1**

(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 - **Use Acetone, isopropanol, or xylene**

(d) THINNING REQUIREMENTS (RATIO) – NO THINNING ALLOWED – N/A

(e) POT LIFE - **25 – 30 min @ 70°F**

(f) SPECIAL INSTRUCTIONS – 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.

VI. APPLICATION:

(a) ENVIRONMENTAL LIMITATIONS -

SUBSTRATE TEMPERATURE: MIN. **65° 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. **45° F** MAX. **95° F**

(b) FILM THICKNESS (SSPC-PA 2): **Spread rate: 75 sq. ft per 1 mixed gallon**

TOTAL SYSTEM: DRY MIN. **8 mils** DRY MAX. **18 mils**

(c) DRY TIMES (ASTM D 1640) – **N/A**

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) – **Jiffy blade; High quality short nap roller**

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

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

(e) SPECIAL INSTRUCTIONS – **Allow to cure approximately 12-16 hours before proceeding.**

REPAIR PROCEDURES IF THE OVERCOAT WINDOW HAS BEEN EXCEEDED: **SSSP- SP 1, SSPC-SP 2 and SSPC-SP 3, Light Abrasion, Solvent-wipe and prime with TM Bondcoat.**

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Date Rev.

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