



# Application Specification

# COLORFLAKE M

## Purpose and Scope

To outline instructions for application of Dex-O-Tex Colorflake M, a terrazzo-like interior deck covering that does not require grinding. This product is manufactured to meet the requirements of MIL-PRF-24613(SH), Type I, Class 2 Deck Covering Materials, Interior, and Cosmetic Polymeric.

**Thickness** .....1/16” to 3/32”  
(1.59 mm to 2.39 mm)

## Approximate Quantity of Materials Required

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

Amount Required ..... THICKNESS  
1/16” (1.59mm)

VLW Type III Underlayment .....as required, see  
“Surface Preparation” below

Colorflake M Basecoat,  
(A & B Components) ..... 2.00 units

Colorflake M Chips  
(50-lb. bag).....0.16 bag

Colorflake “M” Sealer Resin  
(A & B Components) .....1.00 unit

## Required Equipment

- 1/4” or 3/8” Drill
- Jiffy Blade
- Masking Tape
- Foxtail Brush
- Industrial Vacuum
- 1/16” Notched Trowel
- Shoes with golf spikes
- Approved solvent for cleaning tools
- Protective gloves and hand cream
- Rubber-Edged Squeegees (White or Red)
- Dex-O-Tex Trowel 3” x 12” (8 cm x 30 cm)
- Medium/Heavy Nap Mohair Rollers, Sleeves and Handles
- Wallpaper smoothing brushes (natural bristle—not nylon)
- Sandpaper No. 80 or No. 100 grit

## Surface Preparation

Metal deck surfaces should be cleaned free of rust, loose scale, and dirt in accordance with SSPC SP-11/NACE No 6. Grease and oil should be removed with approved solvents and clean rags in accordance with SSPC SP-1. The resulting surface should be clean and bright and protected against corrosion before Dex-O-Tex materials are applied. Dex-O-Tex Colorflake M may be applied to a cured Navy Formula 150 Primer, MIL-DTL-24441, MIL-PRF-23636 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° to 85°F (18°C to 29°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) should be maintained for at least 24 hours for proper curing after installation.

### Packaging

- Colorflake M Basecoat  
(A & B Components packed in cartons)
- Colorflake Chips (packaged in 50-lb. bags)
- Colorflake M Sealer Resin, (A & B Components packed in cartons)

**NOTE:** Where Dex-O-Tex VLW Type III Underlayment or 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 Colorflake M 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 Colorflake M Basecoat.



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## **OPTION:**

It is permissible to apply a “first” or “primer” coat of Colorflake M Basecoat to the cured Terrazzo M Underlayment in lieu of the Terrazzo M coat.

## **APPLICATION PROCEDURE**

### **STEP ONE – Basecoat**

The Colorflake M Basecoat 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 Colorflake M Basecoat, Component B into the can containing Component A. Blend thoroughly with a Jiffy blade, paint mixer or other mechanical means for two (2) minutes. Colorflake M has a pot life of approximately 30 minutes at an 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 either poured out of the mixing pail 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.

Spread the blended Basecoat materials evenly over the surface using a 3” x 12” x 1/16” “V” notched trowel. This material will semi-self level in a couple of minutes. Allow to cure overnight or at least twelve (12) hours at 65°F-75°F (18°C-24°C) before starting Chipping Application.

A unit of Colorflake M Basecoat should cover approximately 50 sq. ft. (9.3 m<sup>2</sup>), on steel decking.

For vertical surfaces, apply a thin coat of Basecoat by brush, using masking tape to establish straight line at top of base.

### **STEP TWO – Colorflake M Chips**

After the Colorflake M Basecoat has cured for at least twelve (12) hours, mix and apply one (1) coat of Colorflake “M” Sealer (A & B Components) as follows;

Pour Colorflake “M” Sealer Component B into Component A 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 materials while blending). Pour blended Colorflake “M” Sealer into a large paint pan (to lengthen pot life and allow entrained air to escape). Spread the blended materials over the cured Colorflake “M” Basecoat using a medium nap Mohair roller, evenly spreading the coating.

As the Sealer coat levels, broadcast the Colorflake chips into the wet material. As an area is “chipped”, it should be “back-rolled” with Colorflake “M” Sealer to flatten and “encapsulate” the chips. One unit of Colorflake M Sealer should cover approximately 150-175 sq. ft.

For vertical surfaces chips are cast against the wet Colorflake “M” Sealer coat and immediately “back-rolled” to flatten and “encapsulate” chips.

Care must be taken to uniformly broadcast the Colorflake chips into the Sealer while it is still wet. Shoes with **golf spikes MUST** be used to walk on the Sealer during this operation. **DO NOT WALK ON AREAS** once they have been covered with Colorflake chips.

One bag (50 lbs.) of Colorflake chips will be sufficient to “chip” approximately 800 sq. ft. at 40%-60% coverage.

### **STEP THREE – Sealer Finish Coat**

The Sealer Finish is applied in one (1) coat. Pour Colorflake “M” Sealer Component B into Component A and blend thoroughly. Apply the Finish coat liberally with a medium nap mohair roller to prevent puddling. This coat should be spread at a rate of approximately 300-350 sq. ft. per one gallon unit. Colorflake M 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 to 75°F (18°C to 24°C) before bearing light foot traffic. An additional twenty-four (24) hours is required before full service is restored.



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## **NOTE:**

Additional Sealer coats may be required or desired for special service conditions. Allow twelve (12) hours drying time between coats. Be sure additional Sealer materials are on hand before proceeding.

## **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.
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.

## **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 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.
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.



## **DOT MARINE PRODUCT LINE Crossfield Products Corp.**

<b>West Coast Office</b>	<b>East Coast Office</b>
3000 E. Harcourt Street	140 Valley Road
Rancho Dominguez, CA	Roselle Park, NJ
90221	07204
310-886-9100	908-245-2800
310-886-9119 fax	908-245-0659 fax

[www.dexotexmarine.com](http://www.dexotexmarine.com)