



Application Specification

COLORFLAKE VP

Purpose and Scope

To outline instructions for application of Dex-O-Tex Colorflake VP, a seamless, cosmetic polymeric deck covering system with random decorative chips for interior deck covering. This material is manufactured to meet the requirements of IMO (International Maritime Organization) Materials, for Interior, Primary Deck Covering, and Floor Finish. (IMO Certifications on File).

NOTE: Always read and follow the complete application, safety instructions and MSDS for the materials before proceeding with the installation.

Thickness (dry film)..... nominal 1/8” (3.2mm) to 1/4” (6.4mm)

Colors Available

See Standard Dex-O-Tex Color Chart with Chips (Standard White)

Approximate Quantity of Materials Required

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

| | <u>Amount Required</u> | <u>Spread Rate Per mixed gal</u> |
|---|----------------------------|--------------------------------------|
| <u>TM Bondcoat Unit 1</u> | | |
| Comp. A ((1 gal. can)..... | 0.4 Units | 250 sq. ft |
| Comp. B (1/4 gal. can) | | |
| <u>Colorflake VP Unit 1</u> | | |
| Comp. A (1 qt. can)..... | 7.46 Units | 14.7 SF @ 1/8” |
| Comp. B (1 gal can) | | |
| OR | | |
| <u>Colorflake VP Unit 3</u> | | |
| Comp. A (1/2 gal. can)..... | 2.49 Units | 14.7 SF @ 1/8” |
| Comp. B (5 gal. pail) | | |
| <u>Terrazzo M Clearsealer Unit One</u> | | |
| Comp G (1 gal Can) | 0.38 units | 300 SF per coat |
| Comp H (1/2 Gal Can) | | |

NOTE: Actual coverage rates may vary depending on application methods and individual application techniques.

NOTE: Surface profile of Substrate can greatly affect coverage rates.

OPTION: To smooth the deck surface or create slope for drainage, install Dex-O-Tex Underlayment prior to application of Colorflake VP.

Equipment Required

- Clean mixing vessels
- 1/4” or 3/4” high-speed drill (minimum RPM = 275)
- “Jiffy blades”, small or large
- Mixing Buckets
- Notch Trowel or Squeegees
- Optional: Spray apparatus (Wagner Bulldog, Hopper sprayer, HVLP)
- Short-nap (3/8”) roller covers, handles and extension poles
- Short-nap (1/8”) Mohair roller covers
- Wet mil gauge
- Spike Rollers
- Tape and Masking Paper
- Rag
- Clean up Solvent

Job Site Survey

Determine substrate condition in accordance with ASTM D610 “Standard Test Method for evaluating Degree of Rusting on Painted Steel Surfaces” using SSPC VIS. If substrate evaluation is determined to be “Good or Fair” in accordance with this document, proceed with surface preparation. If substrate condition is determined to be “Poor or Bad” report findings to the engineer or surveyor to determine corrective action.

Residual Chloride: Perform conductive testing to determine that the substrate residual chloride level is below 3µg/cm².

Inspect substrate to verify preparation in accordance with this specification before applying any materials.



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Measure and record ambient temperature, humidity, surface temperature and the temperature of the materials being used. Do not proceed with the application, if the conditions are outside the recommended parameters. Inspect materials to be used. Verify material is the proper material and all components and sizes are correct. Inspect all containers and verify a proper factory seal with no sign of damage or leakage.

Environmental Conditions

All materials are mixed, applied and cured at the job site. Minimum environmental conditions are required to facilitate proper curing and Performance of the Products. Ensure conditions are in accordance with the following requirements.

| | | |
|-------------------|------------|------------|
| Ambient | <i>Min</i> | <i>Max</i> |
| Temperature | 40°F | 100°F |
| Relative Humidity | 20% rh | 85% rh |
| Wind | NA | 30 mph |
| Substrate | | |
| Temperature | 55°F | 90°F |
| Relative Humidity | NA | 90% |
| Moisture | 0% | 0% |
| Materials | | |
| Temperature | 63°F | 83°F |

Materials should be delivered in original packages and containers with seals unbroken and bearing manufacturer's labels containing brand name and directions for storage and mixing with other components. Check materials immediately upon receipt; verify all the correct materials in the correct packaging are accounted for in good condition. Sort the materials and store them in a tempered storage area.

Surface Preparation

Steel: Prepare Steel to SSPC (Society of Protective Coatings) SSPC SP 5 or SP 11 as appropriate. Inspect surface just prior to application to insure the surface is free from oil, grease, dirt, salts, moisture or any foreign contaminants. Solvent wipe the surface just prior to application.

Aluminum: Prepare aluminum substrates to SSPC (Society of Protective Coatings) SSPC SP 5. Inspect surface just prior to application to insure the surface is free from oil, grease, dirt, salts, moisture or any foreign contaminants. Solvent wipe the surface just prior to application. Proceed with application of Bondcoat immediately after preparation. Be cautious of flash rusting, additional grind may be necessary if prepared surface are left uncoated for extended periods. Never wait over 4 hours between begin preparation and coating the aluminum surface.

Other Surfaces:
Consult Crossfield products Corp.

foreign contaminants. Solvent wipe the surface just prior to application.

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Other Surfaces:
Consult Crossfield products Corp.

STEP ONE – TM Bondcoat

Mix Ratio: 2A:1B Pot Life: 35 min
Cure Time: 6 hrs Recoat Time: 6 – 24 hrs
Coverage: 225 - 320 s.f. DFT: 5 - 7 mils

A. Mix together the following materials:

- TM Bondcoat Comp A..... (2 Parts by Volume)
- TM Bondcoat Comp B.....(1 Part by Volume)

Measure out the required amount of Component A and Component B and pour into a clean mixing container, scraping the sides and bottom of cans to insure all materials are used. Mix with a low speed electrical mixer for approximately three minutes to a homogenous blend. 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 the larger open container.

B. Apply a thin coat of TM Bondcoat using a trowel, squeegee, or roller over the area to be coated. Do not allow primer to puddle or be applied too thick. A one and a half gallon (1 gal A: ½ gal B) mixture should cover approximately



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340 - 480 square feet (225 – 320 sq. ft. / mixed gallon) depending on the surface being coated. Smooth metal surface will yield more coverage; Underlayments with rough or porous surfaces will absorb more material and yield less coverage. If surface is very porous, two coats may be required. Allow to cure as described below before proceeding with the application

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

1. Apply as above to a large area and subsequently install Colorflake VP Basecoat mix over tacky TM Bondcoat with mechanics working on kneeboards. Be careful not to bring the TM Bondcoat up into the Colorflake VP Basecoat
2. Apply to the entire area and allow to cure. Apply Colorflake VP the next day.

STEP TWO – Colorflake VP

Mix Ratio: *1A:6B (Vol) Pot Life: 35 min
Cure Time: 18 hrs Recoat Time: 18 – 48 hrs
Coverage: 14 s.f. DFT: 125 mils

*** Material is prepackaged and weighted to exact proportions. Do Not Split Units**

After the TM Bondcoat, has cured, but within 24 hours of application, mix and apply Colorflake VP material.

- A. Mix together the following materials by unit:

Colorflake VP Comp A - Complete Factory Unit
Colorflake VP Comp B - Complete Factory Unit

Before mixing separate component together, open the B component and drain off all the liquid into a separate container, this will leave a semi-solid layer of pigments and fillers in the original container. Premix this semi-solid material into a smooth creamy texture, then slowly add back the previously drain off liquid back in, take care to

scrap all the liquid from the sides of the container and mix into homogenous blend.

Pour the contents of the can containing Colorflake VP component A into the can containing component B and mix using a Jiffy blade powered by a low R.P.M. drill. Be certain that all materials on the sides and bottom are blended into the resins. Thorough blending may take 2 to 3 minutes. The pot life of Colorflake VP is thirty-five (35) minutes @ 73°F. This mix will cover approximately 14 sq. ft. (1.28 m²) @ nominal 1/8” (3.2 mm).

Note: It is very important that surfaces to be covered with Colorflake VP be completely clean and free of dirt or other foreign matter, this will prevent small foreign particles being picked up and mixed into the base coat, causing contamination and creating protrusions and other surface irregularities. Use only a” Jiffy blade” type mixing blade to ensure good ingredient dispersion and prevent scraping plastic particles off the interior of buckets.

- B. Spread the Colorflake VP with a 1/8” gauge rake or notch trowel, distribute the material over the area as evenly as possible keeping the rake perpendicular to the substrate to ensure good flow and material distribution, a “Unit Three” mix will cover about 45 sq. ft. (3.72 m²) @ nominal 1/8” (3.2mm). Frequently check material spread rate, confirm regularly to determine the coverage achieved is as specified. Backroll with a spike or loop roller and allow to flow out to an even finish.
- C. Immediately after application of the Colorflake VP basecoat has flowed out, while the basecoat is still wet, broadcast Color Chips into the wet basecoat. Broadcast chips to approximately 20% density of the surface area. Disperse the chips by lofting onto the surface in an upward open tossing motion; do not throw chips hard and horizontal to the surface. Take care to provide an even dispersion of chips.



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Once the Colorflake VP is installed and broadcast with the decorative chips, allow the surface to cure a minimum of 18 hours at room temperature (i.e. 70-75°F) before proceeding with application of the sealer. A longer cure time will be necessary at colder temperatures but material can be successfully applied down to 40°F. Remove any unbounded chips, detail the application, lightly hand sand the surface to remove any protruding chips or irregularities. Remove all debris created by detailing and preparation. Solvent wipe if in accordance with SSPC SP 1 if necessary.

STEP THREE – TM Clearsealer Coat

Mix Ratio: 1.6A:1B Pot Life: 35 min
Cure Time: 8 hrs Recoat Time: 8 – 48 hrs
Coverage: 320 s.f. DFT: 5 mils

A. Mix together the following materials:

TM Clearsealer Comp G (1.6 Parts by Volume)
TM Clearsealer Comp H (1 Part by Volume)

Pour the H Component of the Dex-O-Tex 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. Take care not to entrap air into the sealer during the mixing process.

B. Pour some of the well blend TM Clearsealer onto the surface of the Dex-O-Tex Colorflake VP Basecoat. Using a squeegee as an applicator spread out the material to a minimum thickness of approximately 5 mils WFT. Care should be taken not to leave puddles. Lightly back-roll the wet material with a high quality 1/8” (3.18 mm) nap mohair roller is recommended to even out ridges in the sealer coat and provide a smooth even finish.

C. Allow to cure overnight. One unit will cover approximately 300 sq. ft. Working time in the container is approximately 35 minutes.

NOTE: If additional Terrazzo M Clear sealer coats are desired or required, lightly sand and detail the previous application. Solvent wipe in accordance with SSPC SP 1 and apply in accordance with STEP THREE (above). Coverage per unit will be approximately 300 sq. ft. per unit

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 affect 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 System

1. Read and observe precautionary statements on product labels.
2. Keep containers tightly closed.



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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.



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