



Application Specification

TERRAZZO M (FINE)

Purpose and Scope

To outline instructions for application of Terrazzo M (Fine), a terrazzo-like interior deck covering that does not require grinding. Terrazzo M (Fine) is manufactured to meet the requirements of MIL-PRF-24613(SH), Type I, Class 1, Deck Covering Material, Interior, Cosmetic Polymeric.

Thickness.....Terrazzo M (Fine) Topping
1/16" – 3/32" (1.59mm – 2.39 mm)

Colors..... Consult Selection Series

Approximate Quantity of Materials Required

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

TERRAZZO "M" UNDERLAYMENT (as required)
See Surface Preparation.

TERRAZZO "M" (FINE) BASECOAT TOPPING
Thickness
1/16 inch (1.59 mm)

Terrazzo M Bondcoat
(A & B Components)..... .33 unit
Terrazzo M (Fine) Basecoat
(C & D Components)..... 1.00 unit
Terrazzo M (Fine) Aggregate
(50-lb. bag)2.00 bag
TM Clearsealer
(G & H Components) (Sealer) 1.33 unit

NOTE: Terrazzo M Fine is also available in ½ size kits. A kit of Terrazzo M Fine consist of ½ gallon Terrazzo M Fine Basecoat resin and 50 lbs. blended colored quartz aggregate. One Kit will cover 25 sq ft.

Equipment Required

Dex-O-Tex Drill Mixing Blade mounted in slow speed (275 RPM), ¾" (19 mm) drill
Jiffy Blade (small size)
Wooden Mixing Paddle

Rubber-Tipped Pastry Spatula
Rubber-Edged Plasterer's Squeegees; one 12" (30 cm) & one 6" (15 cm)
Short Nap Rollers
Wallpaper Smoothing Brush
Industrial Vacuum
Disc and/or Spinner Sander with clean, worn #1-1/2 closed-coat sanding discs
Good lighting, preferably floor level
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 (Fine) 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 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) must be attained for proper curing during application and for at least 24 hours after installation.

Application Procedure

Separate materials so that they will not be intermixed:

Terrazzo M Bondcoat (A & B Components)
Terrazzo M (Fine) Basecoat (C & D Components)
Terrazzo M Aggregate (packed in 50 lb. bags)
TM Clearsealer (G & H Componentets)



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STEP ONE – Terrazzo M Bondcoat

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

- A. Combine A & B Components into a clean can and stir until thoroughly blended. Working time of this mixture is approximately 45 minutes (at 70°F - 21°C). In cold conditions, allow blended Bondcoat to stand five to ten minutes before using.
- B. Terrazzo M Bondcoat is to be applied in a thin coat by brush or squeegee onto the surface that is to be covered with Terrazzo M (Fine) Basecoat mix. The unit of Bondcoat should cover approximately 300 sq. ft. (27.87m²) on steel decking when applied with squeegee.
- C. Apply the Terrazzo M Bondcoat as described to a prepared steel surface or to the Terrazzo M Underlayment if it is part of the surface preparation. The roughness of the surface of the underlayment may reduce the spread rate of the Bondcoat required. Immediately after the Terrazzo M Bondcoat flows out, lightly sprinkle some Terrazzo M (Fine) Aggregate into the Bondcoat. Allow the Terrazzo Bondcoat to cure overnight.

STEP TWO – Applying Terrazzo M (Fine)

- A. If coved base is to be applied, this is usually best accomplished by making a “stiff” mix consisting of the ½ unit of Basecoat (Components C & D) into which approximately 25 lbs. (11.32 kg) of Terrazzo M (Fine) Aggregate is blended. The cove base is applied by trowel. It is NOT necessary to “wet” the Bondcoated base with Basecoat before troweling the cove base mix into place.
- B. Installation of Terrazzo M (Fine) sanitary cove base should be made to a piece of heavy cloth (duct) tape, placed approximately 1 ½” (3.8 cm) out on the floor, to create a straight edge to finish

the toe of the base. Remove the tape shortly after the cove base and toe have been formed and before the cove base materials cure.

STEP THREE – Terrazzo M (Fine) Basecoat

- A. After an overnight drying period the Terrazzo M Bondcoat may, due to the atmospheric conditions, still be slightly tacky. This tacky condition does not prohibit the application of the Terrazzo M (Fine) Basecoat. Pour the contents of Basecoat Can “D” into Can “C”. Blend thoroughly with a Jiffy Blade until the mix is homogeneous. Terrazzo M (Fine) Basecoat has a pot life of approximately 25 minutes.
- B. Spread the blended Terrazzo M (Fine) Basecoat materials evenly and fairly liberally over the entire surface using a short nap roller. This material will flow out in approximately 5 to 7 minutes, filling any minor voids or depressions. The Basecoat surface must be uniform, wet and free of ridges.
- C. A unit of Basecoat will cover approximately 50 sq. ft. (4.66m²).
- D. Where work is to be stopped for the day, apply a strip of heavy cloth (duct) tape to surface prior to spreading Basecoat. This will create a straight edge stop. Apply Basecoat up to and slightly over edge of tape. Remove tape shortly after broadcasting Terrazzo M (Fine) Aggregate.

STEP FOUR – Terrazzo M (Fine) Aggregate

- A. Immediately after the Basecoat material flows out, the pre-blended Terrazzo M (Fine) Aggregates are heavily broadcast into the Basecoat. Broadcasting the Terrazzo M (Fine) Aggregate may be accomplished by means of mechanical “Blower Assembly” (consult Crossfield Products Corp.) or manually.

CAUTION: When Broadcasting Terrazzo M (Fine) Aggregates, make every effort not to throw them horizontally. Aggregates should be “lofted” into the air and allowed to drop down



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upon wet basecoat; otherwise, a “spray” pattern may form.

- B. Leave a 6”-8” (15cm-20 cm) border of wet Basecoat at edge of continuing work into which aggregate is not broadcast. Apply succeeding application of Basecoat up to this wet edge and while it is still wet, continue to broadcast.
- C. Care must be taken to thoroughly cover the Basecoat while it is still wet. Make sure all “wet” spots receive additional Terrazzo M (Fine) Aggregate.
- D. If it becomes necessary to walk on the Basecoat while broadcasting the Aggregate, golf spikes or crampons should be used.

CAUTION: Do not walk on any of the area where the Terrazzo M (Fine) Aggregate has already been broadcast and is still wet as such activity will create minor voids which will result in serious imperfections in the finished surface.

- E. One bag of Terrazzo M (Fine) blended aggregates will be required to adequately cover approximately 50 sq. ft. (4.65m²). (Approximately $\frac{3}{4}$ of the blended aggregate may be retrieved for later use.)

CAUTION: In the case of a small installation which is all to be done at one time, or in only two or three “pours” of Basecoat, considerable additional quantities of Terrazzo M (Fine) Aggregate (approximately four times that shown on page 1 of this specification) must be on hand as sufficient aggregate cannot be recovered for re-use.

STEP FIVE – Removal and Recovery of Excess Aggregate

- A. After at least a twelve hour drying period at approximately 70°F (21°C), the excess or unadhered Terrazzo M (Fine) Aggregates are swept up. The surface is then thoroughly vacuumed to remove all loose particles. The swept-up aggregates will be re-used.

- B. After excess aggregate has been removed, very rapidly sand the floor using clean, worn sandpaper. The purpose of this is to remove any particularly high protrusions of the aggregate. This sanding is only a fast single “pass” over the floor. Vacuum floor after sanding.
- C. Insure that the surface of the aggregate is kept clean prior to Basecoat (Sealer) application since dust or stains not removed could be sealed into the surface. Pay particular attention to cleanliness of footwear and kneepads when sealing.

STEP SIX –Sealer

- A. Blend together the contents of the TM Clearsealer can “H” into can “G”. Using the Jiffy Mixer Blade, mix until homogeneous. Spread the blended Clearsealer evenly and quite liberally, using a clean, squeegee or natural bristle, wallpaper smoothing brush. Allow the Basecoat to flow slightly, then remove the excess using a rubber squeegee. A wet edged “bead” of Basecoat should be left where the next pour of Basecoat is to be made to avoid excessive “overlap” (which can result in an uneven appearing finish). A unit of TM Clearsealer will cover approximately 75 sq. ft. (6.97 m²).
- B. TM Clearsealer should be applied to verticals and cove base by paint brush in multiple thin coats. Avoid puddling and flow of excess material off the vertical surface collecting at the bottom of the cove base.

Cautions

1. For proper workability it is important that 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.



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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.

West Coast Office
3000 E. Harcourt Street
Rancho Dominguez, CA
90221
310-886-9100
310-886-9119 fax

East Coast Office
140 Valley Road
Roselle Park, NJ
07204
908-245-2800
908-245-0659 fax

www.dexotexmarine.com