



## SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED:  YES  NO

Date: 14 May 2015

## IV. SURFACE PREPARATION MINIMUM REQUIREMENTS:

- (a) INITIAL: Remove grease, oil and dirt (SSPC-SP1) or other approved method.

MIN: SSPC SP-10/NACE 2 / MAX: SSPC SP-5/NACE 1

UHP Water Jetting – SSPC-SP WJ-2/NACE WJ-2

- (b) TOUCH-UP: N/A

- (c) PROFILE (INCLUDE METHOD USED): MIN. N/A MAX. N/A

- (d) SPECIAL INSTRUCTIONS:

- (e) PRIMER REQUIREMENTS: AST MS-7CZ should be applied minimum 2 mils, DFT.

- (f) MAXIMUM ALLOWABLE CONDUCTIVITY (BRESTLE PATCH METHOD): N/A

- (g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWED: N/A

## SPECIAL SAFETY PRECAUTIONS:

CAUTIONS TO BE TAKEN IN HANDLING AND STORING: WARNING! IRRITANT, **Read MSDS before use.** Do not get in eyes, avoid contact with skin and clothing, and avoid inhalation vapor or mist. Use with adequate ventilation, wash thoroughly after handling and before eating, drinking or smoking. Remove contaminated clothing and wash before use. OTHER PRECAUTIONS: Avoid extreme heat – **keep away from flame or other ignition source.**

## V. MIXING PROCEDURES: Improperly mixed material will not cure properly

- (a) MIXING RATIOS BY WEIGHT: 13.3:1 (Base to Hardener)
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- BY VOLUME: 5.4:1 (Base to Hardener)

- (b) INDUCTION TIME: N/A

- (c) RECOMMENDED SOLVENT – CLEAN UP: S-31 Solvent, S-426 Solvent, Isopropyl Alcohol, Aromatic Naphtha, MAK

- (d) POT LIFE:

1 Hr(s) @	90°F (32°C)
2 Hr(s) @	70°F (21°C)
3 Hr(s) @	50°F (10°C)

- (e) SPECIAL INSTRUCTIONS:
- Improperly mixed material will not cure properly.**
- A Compound or Double Box Vortex Mixing blade may be used to perform both the base (Part A) pre-mix and combined components (Part A and B) with the same paddle. Perform a pre-mix of the base material for at least 1 minute. Following pre-mix of base material (Part A) add hardener (Part B) to the base material (Part A). Once the hardener is introduced, continue mixing the combined contents of the kit for an additional 2-5 minutes or until a homogenous blend of both components is achieved and mixture presents a uniform color and appearance.

If a single mixing blade is used for mixing, perform a pre-mix of the base material for no less than 3 minutes; add hardener and continue mixing the kit for 3-5 additional minutes. Ensure a homogenous blend of both components is achieved and the mixture presents a uniform color appearance. Additional mixing time may be required to obtain a homogenous blend and a uniform color appearance.

## VI. APPLICATION:

- (a) ENVIRONMENTAL LIMITATIONS:

SUBSTRATE SURFACE TEMPERATURE:	MIN. 50°F	MAX. 110°F
AMBIENT TEMPERATURE:	MIN. 55°F	MAX. 100°F
MINIMUM SUBSTRATE TEMPERATURE DIFFERENCE ABOVE THE DEW POINT:	5°F	
MAXIMUM PERCENT RELATIVE HUMIDITY:	85%	

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(b) FILM THICKNESS (SSPC PA2-73T) -		PER COAT:		
		WET MIN. N/A	WET MAX. N/A	
		DRY MIN. N/A	DRY MAX. N/A	
		SPREAD RATE: <u>20 – 30 ft<sup>2</sup> / gal.</u>		
(c) DRY TIMES (ASTM D 1640):				
Surface Temperature	50°F	70°F (21.1°C)	90°F (32.2°C)	110°F (43.3°C)
Dry to Touch	20-24 Hrs	10-12 Hrs	5-6 Hrs	3-4 Hrs
Dry to Handle*	72 Hrs	24-30 Hrs	12-15 Hrs	6-8 Hrs
Overcoat – Min**	N/A	N/A	N/A	N/A
Overcoat - Max**	N/A	N/A	N/A	N/A
Cure to Full Service	14 Days	7 Days	5 Days	3 Days
Color Topping - Max***	30 Days	30 Days	30 Days	30 Days
<p>* Minimum dry time before color top coat application of visual landing aid markings.                  ** Except for seam overlap – over coating nonskid with nonskid for shipboard application is not authorized.                  *** Applying color topping (Visual Landing Aid markings) prior to placing newly applied nonskid into service. Color topping may be used to overcoat itself or non-skid in excess of the 30 day window provided the surface is thoroughly cleaned to remove all containments, salts, petroleum products of lubricants to assure proper adhesion.</p> <p><u>Temperatures below 50°F should not be considered in the cure time calculations for MS-400G. Note:</u> Changes in environmental conditions (post application) are affected by day/night cure temperatures and exposure to sun light. Recorded temperature data will assist in determining an approximate creditable cure time within a 24 hour period. If the applied nonskid system is subjected to relative humidity 85% and greater during initial curing period (within 72 hours) at 50°F or below, this may cause whitening / amine blush that does not affect the integrity or performance of the coating and is limited entirely on the surface of coating.</p>				
(d) EQUIPMENT REQUIREMENTS: Phenolic hard core roller with extended handle; ¾HP, 450 RPM power mixer capable of mixing heavy mastic materials.				
(e) SPECIAL INSTRUCTIONS:				
REPAIR PROCEDURES: IF THE OVERCOAT WINDOW AS BEEN EXCEEDED FOR CRITICAL APPLICATIONS: Please refer to NAVSEA Standard Item 009-32 and NSTM Chapter 634 Guidelines for secondary surface preparation after 36 hours.  REPAIR PROCEDURES IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR NON-CRITICAL APPLICATIONS: If less than 7 days has elapsed since the application of the primer, a proprietary nonskid or color topping may be applied after visual inspection to confirm the absence of grease, dirt, salts, or other surface contaminants. If surface contamination is suspected as a result of visual inspection or for other reasons, the entire surface shall be cleaned in accordance with SSPC-SP 1. Apply the proprietary nonskid or color topping after surfaces have completely dried and or solvent has completely evaporated.				
ADDITIONAL DATA/INSTRUCTIONS:				
II. MANUFACTURERS DATA:				
III. PROPERTIES:				
IV. SURFACE PREPARATION MINIMUM REQUIREMENTS:				
V. MIXING PROCEDURES:				

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## VI. APPLICATION REQUIREMENTS:

ADD ADDITIONAL COMMENTS FROM PART VI HERE:

Temperatures below 50°F should not be considered in the cure time calculations for MS-400G. **Note:** Changes in environmental conditions (post application) are affected by day/night cure temperatures and exposure to sun light. Recorded temperature data will assist in determining an approximate creditable cure time within a 24 hour period. If the applied nonskid system is subjected to relative humidity 85% and greater during initial curing period (within 72 hours) at 50°F or below, this may cause whitening / amine blush that does not affect the integrity or performance of the coating and is limited entirely on the surface of coating.

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