MARINEGRIP
(32M Series – Bulk)

User Guide

FIRMFOOT®



FORREST
Technical Coatings

FIRMfoot® 32M Series (MarineGrip) is a **single-component modified acrylic alkyd, heavy-duty non-skid coating** designed for maximum traction and durability in demanding environments.

This product is specifically formulated for:

- **Marine environments (docks, boats, decks)**
- **Industrial applications requiring aggressive slip resistance**

It provides a **heavy grit, textured finish** with excellent resistance to:

- Salt water
- Abrasion
- Extreme temperatures
- Corrosion
- Impact

Suitable for properly prepared surfaces including steel, aluminum, wood, fiberglass, and masonry.

3 Basic Steps for Best Results

1 **Prepare the Surface**

2 **Mix & Apply the Coating**

3 **Allow Proper Dry & Cure Time**

Each step is critical to achieving maximum traction and long-term durability. Following the process in sequence will help prevent common failures and ensure consistent performance in demanding environments.

1 Surface Preparation (CRITICAL STEP)

Surface preparation is essential for adhesion and long-term performance.



General Requirements

- Surface must be clean, dry, and free of contaminants
- Remove all:
  - » Oil, grease, dirt
  - » Mill scale, rust, or failing coatings

Recommended Prep Methods

Depending on the condition of the surface, use one or more of the following preparation methods.

- Hand or power tool cleaning
- Power washing
- Abrasive blasting (SSPC-SP-6 recommended) to **1.5–2.5 mil anchor profile**

Additional preparation requirements may apply depending on the substrate

- **Wood:**
  - » Prime with exterior oil-based primer
  - » Seal edges and backside for durability
- **Steel / Ferrous Metals:**
  - » Clean thoroughly; blast or mechanically prepare
- • **Aluminum / Non-Ferrous Metals:**
  - » Clean with detergent
  - » Use adhesion primer
- **Fiberglass:**
  - » Light sanding or acetone wipe
- **Concrete / Masonry:**
  - » Cure minimum 28 days
  - » Acid etch or mechanically profile surface
  - » Remove sealers before coating

If prep is done incorrectly:

- Coating may peel, blister, or fail prematurely

2 Mixing & Thinning

Once the surface has been properly prepared, the next step is to ensure the coating is thoroughly mixed. Due to the heavy grit formulation, proper mixing is essential for consistent traction and performance.

Mixing (CRITICAL FOR HEAVY GRIT)

- Stir thoroughly before use
- Continue mixing frequently during application

Important:

- Heavy grit will settle quickly
- Poor mixing = inconsistent traction and finish

After thoroughly mixing the product, determine if thinning is necessary based on your application method and conditions.



Thinning (If Needed)

- Product is **ready-to-use**
- May be thinned up to **10% maximum with Xylene**

CAUTION: Do NOT over-thin

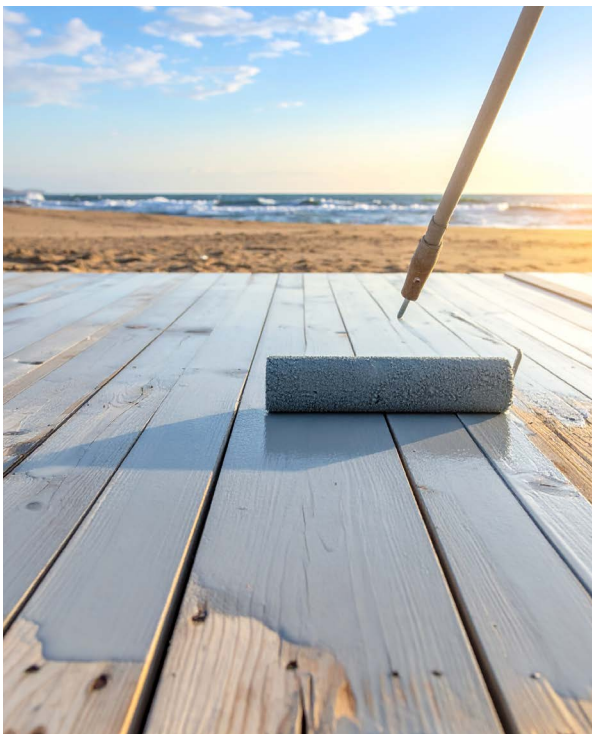
- Reduces traction performance
- Affects film build and durability

Once the coating is properly mixed (and adjusted if needed), proceed with application.

3 Application Instructions

Application Methods

- Stubble brush
- Carpet roller
- 1/32” notched trowel



Environmental Conditions

Before beginning application, confirm that environmental conditions are within the recommended range.

- Temperature: 50°F – 80°F
- Humidity: < 70%
- Surface temperature must be ≥5°F above dew point

How to Apply

After selecting your application method and confirming conditions, apply the coating as follows.

- Apply in 2 coats for best performance
  - » First coat: base/tack coat
  - » Second coat: full coverage coat with texture build

Film Thickness Targets

- Dry Film Thickness: 2–3 mils

4 Dry & Cure Time

After application is complete, allow sufficient time for the coating to dry and fully cure before placing into service.

- Dry to handle:
  - ~30 minutes (black)
  - ~45 minutes (white)
- Full cure: **~5 days**



Use the following information for planning, cleanup, and proper storage

Coverage

- Approx. **610 – 866 sq ft per gallon @ 1 mil** depending on formulation

Clean-Up

- Clean tools and equipment with **Xylene**

Storage

- Store in a cool, dry, well-ventilated area
- Keep containers tightly sealed
- Shelf life: ~12 months (unopened)

Safety Information

Always follow appropriate safety precautions when handling and applying this product.

- Flammable product—keep away from heat, sparks, and flame
- Use in well-ventilated areas
- Wear appropriate PPE
- Review SDS before use

Troubleshooting

If performance issues occur, use the guide below to identify common causes and corrective actions.

Uneven or Inconsistent Texture

- Cause: Poor or inconsistent mixing
- Fix: Maintain agitation throughout application

Low Traction

- Cause: Over-thinning or insufficient film build
- Fix: Apply proper thickness and avoid over-thinning

Peeling / Adhesion Failure

- Cause: Improper surface preparation
- Fix: Re-prep surface and reapply

Premature Wear

- Cause: Inadequate cure time or improper prep
- Fix: Allow full cure and ensure correct prep methods

Pro Tips

For best results in demanding environments, keep these application insights in mind.

- This is our maximum traction system—designed for the toughest environments
- Ideal for:
  - » Marine decks
  - » Docks and ramps
  - » Heavy industrial walkways
- Mixing is critical—heavy grit products demand attention during application
- Apply evenly to avoid high/low texture areas





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