



TECHNICAL DATA SHEET #14

PDC® F-611 Conductive

**Synthetic Rubber Coating
FOR INDUSTRIAL USE ONLY**

DESCRIPTION:

F-611 is a conductive synthetic rubber coating that exhibits durability, flexibility and strength. F-611 can be applied to polyethylene, X-Link PE and EVA foams as well as to many plastics such as ABS. Typical applications are foam packaging, case inserts and specialty products where ESD safe surfaces are needed.

OTHER FEATURES INCLUDE:

Excellent flexibility.

May cause artifacts in imaging applications

SPECIFICATIONS:

Solids: (wt.) 24%

Temperature use range: -30°F to 200°F Conductivity: 10/ 4th

Block Resistance: 4hr @ 140F

Shelf life: 1+ years at 77°F unopened container

Elongation: (ASTM D-638) 500%

Coverage: 30 sq.ft. per gal at 15 mil

Tensile: (ASTM D-638) 2,500psi

Finish: satin

Chemical resistance: In House Test Results [ASTM D-1308]
acids, alkalines, moisture: excellent
petroleums: limited

ALTERNATIVE PRODUCTS:

For non conductive coating used on EVA, Polyethylene and X-Link PE see, F-717/ F-719 , F-694, F-830 or F-888 technical data sheets.

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SURFACE PREPARATION:**MIX WELL BEFORE USE.**

All surfaces to be coated must be free of any oils, dust or loose foam particles.

USE ADEQUATE VENTILATION.

SPRAYING: Pressure pot/conventional sprayers may be used. Dilute with recommended thinners 20-50% as needed. Gently mix before spraying. Apply wet, overlapping coats holding gun 6"-12" from surface using a 4"-6" pattern. Allow 10-20 minutes dry time before applying additional coats to desired thickness.

RECOMMENDED EQUIPMENT AND SETTINGS:

Binks® model 2100 gun

Nozzle: 66SS

Cap: 66SD (20-30% dilution) for heavier build up

Needle: 565

Material: 20-25psi

Atomization: 15-25psi

Dilution: as needed

Clean up: Toluene, Naphtha or Xylene

Industrial/commercial airless equipment may be used. Use as described above.

Tip size: .011-.019

Pressure: as needed

Dilution: 20-30%

DIPPING: Dilute with recommended thinners up to 30% as needed. Gently mix before each use. Do not introduce air bubbles. Insert item 1" every 5 seconds. Remove at same rate. Allow 30-40 minutes (dry to the touch) before applying additional coats to desired thickness.

BRUSHING: Dilute with recommended thinners up to 30% as needed. Gently mix before each use. Apply wet, overlapping coats using a soft natural bristle brush. Allow 10-20 minutes (dry to the touch) dry time before applying additional coats to desired thickness.

HINTS:

Recommended thinners: Toluene, Naphtha or Xylene. A dry film thickness of 12-15 mils is recommended for best results. Approximate dry film thickness per coat: dipping 6-8 mils; brushing, 4-5 mils; spraying, 2-5 mils. Allow overnight drying whenever possible. When using a dip tank, allow 6" minimum from fluid surface to tank top to avoid "skinning over". Avoid excessive air movement, heat or humidity. Always use proper ventilation and protection.