

PDC® F-974 MURACULON/ABSORBER COAT

VINYL BASED FOAM COATING
FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-974 Muraculon Absorber Coat is a NON- halogenated vinyl based coating used to seal polyurethane foam used for pyramidal absorbers used in anechoic chambers.

F-974 Muraculon Absorber Coat will provide a flexible protective coating on polyurethane foam to create a barrier to moisture, dirt, UV, abrasion, impact, puncture and chemicals. This tough yet flexible coating adds durability and color to absorber foam and doesn't crack when flexed.

OTHER FEATURES INCLUDE:

Remains flexible	NON-Halogenated FR system
Wide selection of colors.	Super fast dry/ processing
Single component - no catalystr.	FR: Passes NRL requirements
	Meets or exceeds UL94 HBF

SPECIFICATIONS:

Solids: (wt) 35+ %	Tensile: [ASTM D-412] N/A
Temperature use range: -0°F to 200°F	Elongation: [ASTM D-412] N/A
Block resistant: 4hr @ 140°F	Shelf life: 1+ year @77 f unopened container
Coverage: 150 sq. ft. per gallon at 5 mils	Finish: matte

CHEMICAL RESISTANCE: In House Test Results (ASTM D1308)

Mineral oil: very good
Machine Oil: very good
Saline: very good
Blood: very good
Urea (6% in H2O): very good
All-purpose cleaner: very good
Betadiene (Iodine): *good
Acid (10% sulfuric in H2O): very good
Gasoline: good
Alcohol: very good
*stained after 5 minutes.

ALTERNATIVE PRODUCTS: contact technical service

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SURFACE PREPARATIONS:

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

USE ADEQUATE VENTILATION.

MIXING INSTRUCTIONS:

Like most liquid vinyl coatings, F-974 will coagulate [thicken] during storage, requiring thorough remixing before use each day. For best results, a * high speed air/explosion proof electric hand or drum mixer along with a Cowles® or dispersion blade gives the maximum combination of high shear, excellent flow and circulation. Dispersion blade diameters of 3" minimum for mixing five gallon containers and 7" minimum for mixing 50 gallon drums are required. Note: It has been found that the dispersion blades are highly effective, fast and produce more shearing action than can be obtained from a standard mixing blade or paddle blade. *It is very important that you check liquid temperature of the F-974 and ensure it is at a minimum of 68 F.*

After the F-974 has been properly sheer mixed each day before starting production it is only necessary to provide constant low speed agitation throughout the day to minimize any soft settling which may occur.

Avoid making solvent additions before proper sheer mixing is completed. Check viscosity. Some adjustments may be necessary for your particular use. Contact technical service for specific applications.

SPRAYING.

Set pot pressure at 20-25psi and atomizing at 40-80psi, open pattern adjustment for 4"- 6" pattern at 8"-12" from surface. Aim spray gun at foam and fully trigger spray gun. Adjust material until a uniform pattern appears on the foam.

Each spray pass should be applied "damp" and typically 3-4 spray passes will sufficiently coat/ seal and color the foam if applied properly. This process can be done as individual spray passes and allowed to dry between coats or can be applied consecutively to suit your production needs.

Applying F-974 **too heavy or wet** will result in excessive absorption into the foam and prevent the foam from sealing easily.

Applying F-974 **too lightly or dry** will result in lack of adhesion and proper film build for durability.

NOTE: To accelerate final drying, place coated object in ventilated oven at 100°F-140°F for 5 minutes. Make sure heat source is safe for this use and that you ventilate properly. To increase coating speed, you may increase atomizing pressure; open material adjustment and pattern adjustment to your comfort level.

RECOMMENDED EQUIPMENT AND SETTINGS:

Binks® model 2100 gun

Nozzle: 66SS

Cap: 66SD

Needle: 565

Material: 25psi

Atomization: 30-50psi

Dilution: none required

Clean up: Acetone and Methyl Ethyl Ketone

HINTS: Always mix before **spraying**. Avoid excessive air movement, heat or humidity. Always use proper ventilation and protection.