Performix BRAND

TECHNICAL DATA SHEET #98

PDC® F-977 LCC MURACULON

VINYL SOLVENT BASE
FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-977 Muraculon is a durable yet soft, flexible coating that produces a very unique finish for ultra contemporary furniture manufacturing where molded and fabricated polyurethane foams are used.

F-977 Muraculon provides the end user with a reasonable level of comfort, proper pressure relief and stability unlike other "truck bed liner" coatings being used in the market today.

Plasti Dip International has been the primary coating supplier to the largest and most innovative foam wheel chair seating systems and foam patient positioning products manufacturers in the world for over 30 years. We've utilized this knowledge to create a finish that not only meets high expectations for design and appearance, but also function, comfort and durability.

F-977 Muraculon is an easy to apply spray coating used to protect molded and fabricated polyurethane foam providing an excellent liquid barrier as well as puncture, chemical, UV, abrasion, cut and impact resistance.

F-977 Muraculon is the ultimate replacement for "sewn" fabric, vinyl or leather upholstery without the seams, pinholes, high minimum custom color requirements or limitation on shape or size. The ultimate coating is available for you to test your imagination....call us for assistance.

OTHER FEATURES INCLUDE:

Wide selection of colors. Low minimum order quantity.
Single component - no catalyst. Simple air dry system, low start up costs.
Passes methenamine pill burn test
Fast dry time.

SPECIFICATIONS:

Solids: (wt) 30%
Temperature use range: -0°F to 200°F
Block resistant: 4hr @ 140°F
Shelf life: 1+ years @ 77 f unopened container
Coverage: 50 sq. ft.per gallon at 10 mils
15 sq. ft per gallon at 30 mils

Tensile: [ASTM D-412] 1420 psi
Elongation: [ASTM D-412] 298%
Tear Strength: [ASTM D-1004] .18
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):	*very good	Acid (10% sulfuric in H2O):	very good
Gasoline:	good	Alcohol:	very good

*stained after 5 minutes.

We cannot anticipate all conditions under which this information and our products, or the products of other manufacturers in combination with our products, may be used. We accept no responsibility for results obtained by the applications of this information or the safety and suitability of our products, either alone or in combination with other product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and buyers and users assume all responsibility and liability for loss or damage arising from the handling and use of our products whether used alone or in combination with other products. Ever changing V.O.C. regulations in your area may require you to contact local authorities for proper use and/or disposal of this product. Should you need further assistance, please contact PLAST DIP INTERNATIONAL technical service.

PDC is a registered trademark of PLASTI DIP INTERNATIONAL
Performix and logo are trademarks of PLASTI DIP INTERNATIONAL
Hypalon is a registered trademark of DuPont, Wilmington, DE
Cowles is a registered trademark of Morehouse-COWLES, Inc.
BINKS is a registered trademark of BINKS MFG. CO., Franklin Park, IL

SURFACE PREPARATIONS:

Although adhesion characteristics of F-977 Muraculon are aggressive all surfaces to be coated must be free of any oils, dust or loose foam particles.

USE ADEQUATE VENTILATION.

MIXING INSTRUCTIONS:

QUALITY CONTROL RECOMMENDATIONS FOR SPRAY AND DIP APPLICATIONS.

Like most liquid vinyls, F-977 Muraculon may coagulate during storage, requiring thorough remixing agitation before use each day. For best results, a *high speed air/explosion proof electric drum mixer along with a Cowles® or other dispersion blade gives the maximum combination of high shear, excellent flow and circulation. Diameters of 3" for mixing five gallon containers and 7" for mixing 50 gallon drums. 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.

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

Prime coat: Set pot pressure at 20-25psi and atomizing at 30-50psi, open pattern adjustment for a 2"- 4" pattern at 6"-10" from surface. Aim spray gun at foam and fully trigger spray gun. Open material adjustment until a uniform, wet splatter appears on the foam. The wet splatter should melt or flow into the surface of the foam. Coat all sides (except bottom) with an overlapping motion. Make sure all corners and edges are thoroughly primed. The prime coat should be wet to the touch but should not completely color or cover the foam. Its purpose is to wet or prime the surface for the sealing coat, a necessity for proper adhesion.

Seal coat: After the prime coat has been applied, immediately begin sealing the foam by only partially pulling the trigger back from its previous setting until a dry, web coating appears. This seal coat should appear lighter in color than the prime coat. Hold gun approximately 6"-10" from surface and use an overlapping motion, being sure to **completely** seal the surface. If seal coat is applied too dry, poor adhesion will result. If applied too wet, sealing surface may become difficult. Again, seal all sides (except bottom), being sure to **check entire surface for complete seal.**

Finish coat: After seal coat has been applied, immediately begin applying the finish coat by fully triggering spray gun as in prime coat. Holding the gun 6"-10" from surface, apply a uniform splatter coat using an overlapping motion. Apply the finish coat as desired in thickness and texture. The finish coat is necessary to increase seal coat strength and durability. Allow the finished coated part to dry to the touch (see caution), minimum 5 minutes, then return to prime coat, seal coat, and finish coat bottom of part. Follow instructions and be sure to pay close attention to corners and edges on all steps.

F-977 Muraculon can be used as a base coat for F-970 Softouch top coat.

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 2001/ 95 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.