Performix Coatings
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PDC® F-874 Muraculon Vinyl Based Foam Coatings

F-874 Muraculon is a unique vinyl based coating that when spray applied provides a durable, flexible protective coating on polyurethane foams. F-874 can also be used on molded polyurethane and closed cell foam containing vinyl.

F-874 Muraculon will produce a skin/membrane on unskinned polyurethane foam to create a barrier to moisture and chemicals. This skin has excellent resistance to fluids and petroleums. F-874 is a tough coating that adds durability to foam and imparts abrasion as well as

+ more

Technical Specs | Other Features Include | Surface Preparations | Mixing Instructions | Recommended Equipment And Settings | Hints | Note

– Technical Specs

Brands	Performix®
Solids Weight	24 %
Temperature Use Range	-0 to 200 °F
Block Resistance at 140 Degree Fahrenheit (°F) Temperature	4 h
Shelf Life	1+ years at 77 °F unopened container
Finish	Satin
Tensile	1,200+ psi
Tensile Test Method	American Society for Testing and Materials (ASTM D-412)
Elongation	251 %
Elongation Test Method	American Society for Testing and Materials (ASTM D-412)
Tear Resistance	0.125
Tear Resistance Test Method	American Society for Testing and Materials (ASTM D-1004)
Coverage	80 ft^2/gal at 5 mils

Chemical Resistance	Mineral Oil: Very Good Saline: Very Good Urea (6% In H_2O): Very Good Betadine (Iodine): Very Good (Stained After 5 Minutes.) Gasoline: Good Machine Oil: Very Good Blood: Very Good All Purpose Cleaner: Very Good Acid (10% Sulfuric In H_2O): Very Good Alcohol: Very Good In House Test Results (ASTM D1308)
Alternative Products	F-830

– Other Features Include

Wide selection of colors
Single component - no catalyst
Fast dry time.
Passes UL94 HBF
Does not cause artifacts in most imaging applications

– Surface Preparations

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 vinyl, F-874 may coagulate [thicken] during storage, requiring thorough remixing agitation 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. 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.
After the F-874 has been agitated thoroughly, it should last 8 to 10 hours depending on spray equipment and temperature. **Avoid making solvent additions before 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

– Recommended Equipment and Settings

Binks® model 2100 gun
Nozzle: 66SS
Cap: 66SD
Needle: 565
Material: 25 psi
Atomization: 30-50 psi
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.

– Note

To accelerate final drying, place coated object in ventilated oven at 100ºF-140ºF 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.

For Industrial Use Only.

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