



Performix Coatings

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PDC® F-977 Muraculon Vinyl Based Foam Coatings

F-977 Muraculon is a unique vinyl based coating that when spray applied provides a durable, flexible protective coating on polyurethane foams used in manufacturing ultra contemporary furniture.

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

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- Technical Specs

Brands	Performix®	
Solids Weight	30 %	
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	
Coverage	15 ft ² /gal at 30 mils	50 ft ² /gal at 10 mils
Tensile	1,420 psi	
Tensile Test Method	American Society for Testing and Materials (ASTM D-412)	
Elongation	298 %	
Elongation Test Method	American Society for Testing and Materials (ASTM D-412)	
Tear Strength	0.18	
Tear Strength Test Method	American Society for Testing and Materials (ASTM D-1004)	

Finish	Matte
Chemical Resistance	<p>Mineral Oil: Very Good Saline: Very Good Urea (6% in H₂O): Very Good Betadine (Iodine): (Stained after 5 minutes.) Very Good Gasoline: Good Machine Oil: Very Good Blood: Very Good All Purpose Cleaner: Very Good Acid (10% Sulfuric in H₂O): Very Good Good Alcohol: Very Good</p> <p>In House Test Results (ASTM D1308)</p>
Alternative Products	F-830, F-874, PDC® 3119

– 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.

– Other Features Include

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

– Mixing Instructions

QUALITY CONTROL RECOMMENDATIONS FOR SPRAY AND DIP APPLICATIONS.

Like most liquid vinyl, F-977 Muraculon may coagulate during storage, requiring thorough remixing agitation before use each day. For best results, a *(F-977 Muraculon can be used as a base coat for F-970 Softouch top coat.)* 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.

– 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.

– Note

For Industrial Use Only.

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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.