



TECHNICAL DATA SHEET #15

PDC[®] SYNTHETIC RUBBER COATING

(F-717 / F-719)

FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-717 and F-719 are synthetic rubber coatings that exhibit the ultimate in durability and strength in the foam coatings industry. Their unbeatable flexibility and elongation range from -30°F to 200+°F. These coatings can be applied to polyethylene, EVA, as well as to many plastics such as ABS. These coatings, previously referred to as PDC-11 coatings, have been in use in the medical industry for over a decade and exhibit excellent abrasion, puncture, moisture and urine resistance. Typical applications are foam positioning devices, buoys, sporting goods and padding, packaging, seat cushions, boat and dock bumpers.

OTHER FEATURES INCLUDE:

Wide variety of colors available including fluorescents.

Clear formula. (F-719)

Excellent flexibility.

F-694 is the FR version which meets requirements for UL94 HBF

F-810 is the UV enhanced version.

Does not cause artifacts in imaging applications

SPECIFICATIONS:

Solids: (wt.) 24%

Temperature use range: -30°F to 200°F

Block Resistance: 4hr @ 140F

Elongation: (ASTM D-638) 500%

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

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Weatherability: (ASTM G-53): 3-5 years: F-717/F-719

7-10 years: F-810

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

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

Finish: satin

Chemical resistance: In House Test Results [ASTM D-1308]

acids, alkalines, moisture, urine: excellent

petroleums: limited

ALTERNATIVE PRODUCTS:

For urethane foams, see F-830 Muraculon technical data sheet #26. For PVC foams, see F-818 technical data sheet #4.

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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 2001/95 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: PLASTI DIP® THINNER, 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.