



PDC® F-939 LCC MURACULON

VINYL SOLVENT BASE
FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-939 Muraculon is the ultimate PVC spray coating used to protect polyurethane foam and molded polyurethane foam products.

F-939 Muraculon provides a super tough yet flexible/ elastic coating on polyurethane foam to create a moisture barrier to most fluids as well as provide excellent puncture and abrasion resistance.

F-939 has also been formulated for greater adhesion to all polyurethane foam especially molded PU foams where mold release residue often causes adhesion issues.

The unique properties of F-939 Muraculon find particular use in the medical industry, where cushioning and positioning devices are fabricated and used in sterile environments, as well as therapeutic practices, military applications and institutional uses such as day care and other furniture applications. F-939 the ultimate replacement for “sewn” vinyl covers, without the seams and pinhole or limitation of 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.

Single component - no catalyst.

Passes UL94 HBF

Fast dry time.

Does not cause artifacts when used in imaging applications

SPECIFICATIONS:

Solids: (wt) 26%

Tensile: [ASTM D-412] **2360 psi**

Temperature use range: -0°F to 200°F

Elongation: [ASTM D-412] **490%**

Block resistant: 4hr @ 140°F

Tear Strength: [ASTM D-1004] **.25**

Shelf life: 1+ years @ 77 f unopened container Finish: semi gloss

Coverage: 90 sq. ft. per gallon at 5 mils

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.

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SURFACE PREPARATIONS:

Although adhesion characteristics of F-939 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-939 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.

After the F-939 has been agitated thoroughly, it should last 8 to 10 hours depending on your 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.

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.