

VFI®-2622 68 D POLYURETHANE SPRAY COATING

VFI-2622 68 D Polyurethane Spray Coating is a fast setting, 100% solids, spray-applied urethane coating. It is typically used for interior applications over plywood and other substrates that need a structural hard coat. It also has good rigidity for increased protection from abrasion and impact. VFI-2622's quick set time and low viscosity make for easy application and attractive textures.

- Cures to touch in 4 minutes and can be placed into service in 4 hours
- Lays flat with a slight, fine texture from increased speed
- Excellent adhesion to plywood and metal
- Encapsulates the surface and protects from the elements
- 100% solids and contains no VOCs
- A tough, shell-like film allows the substrate to withstand impact

PHYSICAL PROPERTIES	TEST METHOD	TEST RESULTS
Hardness Shore D	ASTM D 2240	68
Tensile Strength	ASTM D 412	3,000 psi
Elongation	ASTM D 412	25%
Flexural Strength	ASTM D 790	>40,000 psi
LIQUID PROPERTIES	TEST METHOD	TEST RESULTS
Solids by Volume	ASTM D 2697	100%
Liquid Density A Side	ASTM D 2939	9.85
Liquid Density B Side	ASTM D 2939	9.60
Mixed Liquid Density	ASTM D 2939	9.73
Ratio by Volume (A:B)	N/A	1A:1B
Viscosity A Side	ASTM D 2196	1000 cps
Viscosity B Side	ASTM D 2196	2500 cps
Mixed Viscosity	N/A	1750 cps
Gel Time	N/A	15 sec
Cure to Touch	N/A	4 min
Place into Service	N/A	4 hours
Flash Point	ASTM D 56	>200 °F
VOC	N/A	0 g/L

MANUFACTURER OF HIGH PERFORMANCE POLYMERS

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THICKNESS REQUIREMENTS

Coverage will vary depending on the substrate, but VFI recommends applying the coating at a minimum of 30 mils to develop a uniform film that protects the piece. Some applications may even require 80-120 mils for increased durability.

EQUIPMENT

VFI's recommended specifications for a high-pressure, plural component spray rig is to run it at 150°F-155°F and 2,500 psi of constant pressure with high-pressure heated hoses and 10 ft whip hoses. Gun tips will vary by the project and will need to be adjusted on site. The following machines are capable of meeting these specifications:

- Graco A-XP1 air sprayer provides up to 3,500 psi of constant pressure and 170°F with a 1.5 gal/min output and 210 ft hoses. Use with any Probler P2 or Fusion gun.
- Graco Reactor 2 E-XP2 electric sprayer provides up to 3,500 psi of constant pressure and 190°F with a 2 gal/min output and 310 ft hoses. Use with any Probler P2 or Fusion gun.
- Graco Reactor 2 H-XP2/XP3 hydraulic sprayers provide up to 3,500 psi of constant pressure and 190°F with 1.5 or 2.8 gal/min outputs and 310 or 410 ft hoses. Use with any Probler P2 or Fusion gun.
- PMC PHX-2 or 25 hydraulic sprayers, ideal for small or medium-scale applications, provide up to 3,000 psi of constant pressure and 190°F with outputs just under 2 gal/min and 210-410 ft hoses. Use with the AP-2 Air Purge, PX-7 Mechanical Purge, or Xtreme Spray Gun.

SURFACE PREPARATION

For the best adhesion results, the surface should be clean, dry, and free of oils, dirt, films, etc. Depending on the substrate, sanding or priming may be required

- Wood - The wood should be dry and contain less than 11% moisture; otherwise, it should be primed or mist-coated (a light dusting of the coating followed by the main application of the coating).
- Metal - The surface must be cleaned by roughly sanding or sandblasting to SP6 to remove rust, mill scale, dirt, and other contaminants.

MIXING

Before use, bring the material to a minimum temperature of 65°F and premix the B side (Poly) components until uniform. The time it takes to mix will depend on volume and mixing method. The A side (Iso) does not need to be mixed.

POST CURE

The material will need at least 4 hours to cure before placing it into service. Once cured, it can be sanded and/or painted to get the desired finish needed for aesthetic purposes. When spraying in thinner passes less than 40 mils, it may require a longer post-cure time.

CLEANUP

To clean spray equipment, VFI recommends using xylene or MEK. When cleaning and flushing out spray lines, we recommend using the VFI-8005 pump flush.

STORAGE/SHELF LIFE

The material shelf life is 12 months from the date of manufacture. Store in a dry, temperature-controlled space in sealed and unopened containers between 60°F - 90°F. Once open, use it immediately. Opened containers can be resealed with a nitrogen purge, but the material shelf life will ultimately shorten. Moisture contamination can occur in both sides if you don't nitrogen purge the material. Moisture may create a hardened film over and in the A side (Iso). If there is moisture contamination within the B side (Poly), it will cause pinholes and foaming once mixed and sprayed. VFI-8403 Dryer can be used to reduce undesired effects in the B side.

PRECAUTIONS

VFI-2622 is not UV color stable and has no long-term UV testing. This product contains isocyanate, which may cause skin irritation and can be toxic if inhaled. During use, the temperature must stay between 40°F - 100°F. Avoid prolonged breathing of vapors and repeated skin contact. When spraying, use a supplied air respirator or a respirator with forced air ventilation in a chemically approved spray booth. Do not thin or add foreign material to the product. See the Safety Data Sheet for all safety information.

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