

SPRAYABLE OR CASTABLE QWIK-SPRAY SOFT ELASTOMER

■ **Description**

VFI-2717 is a two component, 100% solids, one part iso to one part poly by volume, moderately fast cure aromatic polyurethane elastomer.

■ **Usage**

VFI-2717 is a plural component spray applied coating that has been found to have the following applications:

- General purpose soft castings.

- Single shot material for open molding castings.
- Elastomeric skin for soft foams both in-mold & post-finish applications.
- Automotive dash-boards & paneling in conjunction with an aliphatic in-mold coating or post-finish

■ **Color**

Neutral is typical. Many other colors may be available upon request. Contact Volatile Free, Inc. for details.

Physical Properties

■ **Weatherability**

QUV results indicate that yellowing may be visibly discerned in neutral or off-white in 2 – 3 months continuous exposure. Dark colors such as black may persist for almost a year before oxidative damage may manifest itself as chalking. Under high continuous heat or UV exposure the material may over time, unless protected by an aliphatic topcoat, harden up to 2 hardness points within three years. If outdoor installation is expected it is highly recommended that the product be protected by a topcoat as indicated above.

■ **Fire Resistance**

Mild, but unrated. Contact Volatile Free, Inc. for details.

■ **Chemical Resistance**

Not recommended for constant immersion service. Will resist damage from daily contact with mild detergents or cleaning agents.

■ **Tensile Properties**

ASTM D-412	
Tensile Strength:	745 psi
Elongation:	130 %
Yield Strength:	81 psi
Elastic Modulus:	1122 psi

■ **Tear Resistance**

ASTM D-624:	77 lb/in
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■ **Hardness**

ASTM D-2240	
Shore A:	66
Shore D:	17

Liquid Component Properties

■ **Solids**

% Nonvolatile (wt):	100%
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■ **Viscosity**

Poly Component:	860 cps @ 77°F
Iso Component:	1700 cps @ 77°F

■ **Density**

Poly Component:	8.6 lbs./gal.
Iso Component:	9.5 lbs./gal.

■ **Flash Point**

ASTM D-56 (TCC)
 Greater than 200°F.

■ **Toxicity**

Iso component contains polymeric isocyanate requiring fresh air supply respirator, gloves, and protective clothing during application.

Application

■ Material Preparation

Thoroughly power mix ISO and POLY components separately before beginning to apply. Usually this takes a minimum of 15 minutes per drum with proper mixing equipment. For specific mixers, blade and shaft length, contact Volatile Free, Inc. A hand mixer is not adequate.

■ Equipment

Plural component hydraulic caulk tube (140 psi min) equipment that may accommodate either 300 ml or 750 ml cylinders, fitted with an atomizer tip if spraying is being performed or alternately with a static mix tube if castings are desired. Contact VFI for more information and recommendations on application equipment.

■ Reactivity

Gel time: 14 – 18 sec @ 75 F
Sandable: 16 – 20 minutes
Cure Time: 20 – 30 minutes

■ Cure Time

Applied coating will set in 5.5 to 6 minutes at 75 F, depending on film thickness, liquid material temperature and the substrate temperature. Product can be placed into service after twenty four hours of cure time at 70 F minimum. It is encouraged to begin priming or painting the elastomer at the first sign of cure (from 6 minutes to 2 hours) to maximize adhesion.

Procedure for Priming / Painting:

1. Sand / finish all surfaces to be coated.
2. Blow off surface with dry air.
3. Wipe the surface with MEK or another approved active solvent.
4. Allow part to dry.
5. Prime surface.
6. ***Note: You should always test untested paint or primer on the recommended primer or the elastomer; respectively, before coating your projects.

■ Mixing

Volume 1 unit ISO: 1 unit POLY by volume.
Weight 1 unit ISO: 0.913 units POLY by weight.

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