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TECHNICAL BULLETIN

SPRAY APPLICATION OF PR-1005-L

Most synthetic rubber coatings are applied by brush, dip, or fill and drain methods since they tend to "cob-web" during spraying and produce rough, stringy films unless diluted to 5 to 10% solids content. Films sprayed at this low solids content by ordinary spraying methods are only about $\frac{1}{2}$ mil (0.0005") thick. By use of the spraying method described herein, smooth films of 1 to 2 mils (0.001" to 0.002") thick per spray coat can be obtained.

A catalyst-type spray gun, such as a DeVilbiss Model JGC-501 spray gun with a #2E nozzle (0.086" orifice) should be used in conjunction with two pressure pots. One pressure pot contains the synthetic rubber coating at its standard solids content and the other contains a suitable solvent. When the coating material and solvent are fed to the spray gun, the atomized material becomes heavily laden with solvent vapor and does not show the undesirable tendency to "cob-web".

To adjust the spray, apply pressure to the coating material pot until the material starts to flow from the nozzle of the gun. Then turn on the air pressure to the spray gun and adjust spray pattern. Apply pressure to the solvent pot until "cob-webbing" disappears. Some further adjustment of the atomizing air pressure may be necessary to keep the desired spray pattern.

The following pressures and results were obtained for spraying PR-1005-L:

Solvent	Methyl isobutyl ketone
Atomizing pressure	50 psig
Material pot pressure	5 psig
Solvent pot pressure	100 psig
Dry film thickness per spray coat	1 mil

These pressures may be used as a guide, but they should be adjusted to obtain the desired spray coat.

It should be noted that other PRC solvent dispersed synthetic rubber materials can be sprayed by use of the above method. Pressure and solvents will vary as well as the coating thickness obtained, depending on the particular material sprayed.

SUPERSEDES

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