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TECHNICAL DATA

FUTURA 5321

Fast cure aromatic urethane

DESCRIPTION

Futura 5321 is rapid curing, solventless, aromatic urethane coatings. It is “hardcoats” designed to provide high impact damage resistance for Expanded Polystyrene (EPS), and PUF. The coating is sprayable and features a one-to-one mix-ratio. It zero Styrofoam volatile organic content (V.O.C) meets all emission level requirements.

RECOMMENDED USES

- High impact damage protection for Expanded Polystyrenes (EPS) and Styrofoam.
- Protection and enhanced aesthetic appeal for urethane foam and phenolic foam boardstock.
- Protection and enhanced aesthetic appeal for wood surfaces.

FEATURES

- Fast cure/fast cycle times for increased production rates
- High gloss visual appeal for product enhancement
- Durability extends substrate life
- Impact Resistant protection
- Protection against chemical attacks (gasoline, oil, solvents, etc.)
- Excellent waterproofing characteristics
- Resistant to freeze/thaw expansion contractions and thermal shock cycles.

TECHNICAL SPECIFICATIONS

Theoretical Coverage: 1604 mil sq. ft/gallon

Recommended Thickness: 30 – 100 mils

Number of Coats: one or more (30 mils/coat)

Colors: Neutral or special order colors.

Compatibility: If desired, may be topcoated with Styrotex 1400 for an acrylic EIFS finish coat, or ULTRACHROME 650, 652, 654 for improved gloss and color stability in weathering exposures.

ORDERING INFORMATION

Availability: 10 gal kit 110 gal kit 550 gal kit

Approx. Shipping Weight **5321**

5 gal pail (A)	54 lb
5 gal pail (B)	49 lb
55 gal drum (A)	577 lb
55 gal drum (B)	534 lb
275 gal tote (A)	2895 lb



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Table 1: Typical Properties (WET)

TEST	METHOD	RESULTS
Solids (mixed): by Weight by Volume	ASTM D 1353	100%
	Calculated	100%
Mixing Ratio	A:B by Volume	1:01
Shelf Life:		
Component A	65 - 80 °F	12 months
Component B	65 - 80 °F	12 months
Flash Point:	Penksy-Martens	
Component A	Closed Cup	>300°F/(149°C)
Component B		>300°F/(149°C)
VOC	Calculated	0 lbs/ (0 gm/L)

For weight and Viscosity see Table 2.

Table 2: Typical Physical Properties of Cured Material

Physical Properties	Test Method	Results
Tensile Strength	ASTM D 412 PSI-(Npa)	2450 - 2950
Elongation	ASTM D412, %	25 - 35
Hardness	ASTM D 2240 Shore A/D	69 - 73
Flexural Modulus	ASTM D 790	60000 ± 5000
Water Absorption 3 days at 75°F, %	ASTM D 471	1.1
Weight (#/gal)	ASTM D 1475	
Component A		9.8
Component B		8.7
Viscosity (cps)		
Component A	Brookfield	900
Component B	LV4/60RPM	700
Density	Pounds/cubic feet	60 - 70

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APPLICATION INSTRUCTION

GENERAL EQUIPMENT INFORMATION

Method: use only 1:1 mix ratio, heated plural component spray equipment capable of a material temperature change of 60 – 80 °C at a delivery rate of 1.25 gal/minute and operating fluid spray pressure of 2600 – 3000 psi.

Transfer pumps: Two 2:11 ratioed high volume fluid transfer pumps equipped with 3.4' discharge lines.

Air Requirements: 30 – 35 CFM (0.8 – 1 cubic meter/min) at 100 PSI (7 kg/cm²) for combination of all of the above.

Electrical Requirement: 1 of 3 phase 220V 60 – 80 AMP service depending on electric motor purchased with pump.

APPLICATION PARAMETERS

Application Temperatures: Ambient 40-120°F (5-49°C)

Material Temperature: Both A & B components should be maintained at 75 – 85 °F prior to application.

Preheater Temperature: Both A & B component preheater temperatures should be set at 140°F.

Hose Heat: The hose heat should be set to maintain the 140°F to gun. At 140°F the material viscosities are close to equal so as to effect a better flow and mixing capability at the gun.

Pressure Settings: The proportioning should be set as to effect equal fluid pressures a minimum of 1800 PSI while spraying. The transfer pumps should be supplied with 90 – 100 PSI at 10 CFM.

Thinning: Do not add thinner.

Pot Life: 10 – 15 seconds – do not batch mix

Mixing: After preconditioning to 75 – 90 °F (24 – 32 °C), agitate Components A & B separately with clean impeller-type powered mixers – mix thoroughly for 15 – 20 minutes.

Clean Up: See Futura Bulletin EQ 120 for information on cleaning spray equipment.

Approx Time To:	50 - 60°F (10 - 15°C)	70 - 80°F (21 - 27°C)	90 - 100°F (32 - 40°C)
Dry Surface	1 - 3 min	40 - 45 sec	20 - 30 sec
Hard Film	20 - 30 min	10 - 20 min	5 - 10 min
Recoat, Min	5 min	5 min	5 min
Recoat, Max	36 hrs	24 hrs	12 hrs
Full Cure	7 - 10 days	5 - 7 days	3 - 5 days

Warning: See Training Manual for important adhesion window and recoat information.

SAFETY INFORMATION

Read the Material Safety Data Sheet and container labels for detailed health, hygiene and safety information.

Do not apply without adequate air exchange and ventilation in enclosed areas. Wear protective clothing and proper breathing apparatus supplied with a remote source of fresh air when spraying the coating. Breathing fumes or contact with skin may cause severe allergic reactions.

These product are intended for professional use only by properly trained applicators.



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