

Forsch Polymer URS 2787

Foam Kote F - 201 Instructions

Solvented Base Coat

1) Clear area to be repaired:

- a) Wipe surrounding area with cotton rags & xylene solvent.
- b) Remove Foam that is soiled or torn loose from inside the repair.
- c) Make sure the foam is dry, and protected to keep dry.

2) Sand Down The Edge Of A Repair:

- a) The urethane color top coat should be removed by sanded down to the original URS 2787 gray undercoat, approximately 1 inch wide all the way around the repair. The colored topcoat paint should have another 1/2 inch layer of shine removed all the way around the repair as well.
- b) 80 Grit sandpaper discs on a air sander work best for the task of preparation.
- c) Use the sander at low speed applied using only gentle hand pressure will prevent the material from becoming overheated.

3) If needed new foam maybe added to damaged areas:

- a) The use of a heat gun can be used to bond two layers of foam together. Foam starts to melt at 156°F., by directing hot air from a heat gun between the layers of foam and applying pressure the foam can be heat bonded. You will be able to apply pressure to the top foam by hand using flat tools. As the top foam attaches to the bottom foam keep the gun moving and continue to work your way up the foam surface heat sealing it as you go. Avoid leaving any unbonded areas between the two layers of foam, as air bubbles will form if the two foams are not completely bonded. Air bubbles typically occur well after repair has been finished, usually in hotter weather when air which was trapped expands.
- b) Do not proceed any further until you complete heat bonding of foam.

4) Primer requirements:

Apply Forsch Polymer PRI 1050

- a) This is a single component urethane primer that is clear in color.
- b) A slight dye maybe added to PRI 1050 to help identify foam area that's been primed.
- c) This primer needs to be applied as thin as possible using a clean, lint free white cotton rag. Then let primer dry to touch.
- d) Typically the primer needs 2 to 4 hours to dry at 73 degrees F. Drying time will vary with temperature and humidity conditions.
- e) Do not apply PRI 1050 to wet or damp surfaces, avoid times with dew.
- f) The maximum elapsed time is 8 hours after the primer dries. As soon as it is dry to the touch and ideally in the first two hours the best bonding strength for this ISO rich moisture curing primer occurs.

5) **Mixing of the URS 2787 Foam Kote:**

- a) Component "A" is mixed with a clean Helix power mixer for about 3 minutes before Component "B" is added.
- b) Continue to mix the Component "A" with the Helix mixer, slowly pouring in component "B" a little at a time while continuing to mix for at least 10 minutes.
- c) Prevent air entrapment during the mixing process and always use a proper Helix mixer. Proper complete mixing is critical.
- d) **Caution! Start to** mix 25 minutes prior to the material being needed, but try to let stand for 15 minutes after mixing.
- e) Skinning of mixed Foam Kote left standing in a container can be slowed down by the placing of a wetted solvent rag over the opening. Skim off any skin that forms before attempting use.

6) **Application of the Foam Kote:**

- a) Foam Kote can be brushed, rolled, or sprayed.
- b) Cure times are determined by temperature and humidity, Foam Kote is a moisture curing material. Times will vary 30 to 90 minutes.
- c) Apply thin coats of Foam Kote to the tack free primer surface following primer guidelines. The Foam Kote will be applied typically in 3 to 5 layers with 30 minutes to 90 minutes dry time between each coating later. Between each separate layer let the foam Kote was applied allow it to dry lightly to the touch,. each subsequent layer can be applied a little thicker, but the final thickness of the 3 to 5 layers is going to be 60 to 80 mils dry film thickness. (About the thickness of at least an American dime) **Note:** 1 mil = 1/1000 inch.
- d) If Foam Kote is applied too quickly in thicker layers the finished coating will crack or excessive shrinkage will occur from solvent entrapment. go slowly to let solvent evaporate between layers.
- e) Keep the brush in the Foam Kote between coats when applying Foam Kote by brush or it will dry out. Keep the container top covered, and the typical pot life of Foam Kote is about 8 hours at 30% Relative Humidity at 73 degrees F.
- f) Wear rubber gloves, use a respirator, and use a drop cloth. Part "B" Component will turn your skin black, and you should avoid all skin contact. Do not smoke when handling chemicals.
- g) The time period between passes is affected by humidity, and temperature. It can vary between 30 minutes & 90 minutes.
- h) The pot life of the material is about 2 hours for spraying, longer for rolling or brushing. The thicker it is the easier it is to brush. Remove skin that forms before use, but when product starts to become chunky and or inconsistent, discontinue further use.
- i) After the Foam Kote is applied it will require at least 12 hours drying time before being painted with URS 7600.

Foam Kote Preparation:

- 7) Preparation to allow same day painting over Foam Kote is very difficult, it can be done if the repair was small however. However, if it is possible, it is desirable to wait for a 12 hours cure time before starting to paint.
 - a) Before top coated or painted the Foam Kote base surface will need some preparation, usually by sanding the shine off the surface.

- b) Small shallow pockets or voids, and areas that are not smooth enough can be repaired by sanding. These shallow divots or voids that remain can then be repaired using Forsch Polymers repair putty. The putty comes in a one LB. kit and is applied to adjust and smooth uneven or damaged Foam Kote surfaces.
- c) When the Foam Kote has cured enough that the surface no longer feels cakey, (typically 12hrs. or overnight) it will need a surface sanding to prep, followed again by PRI 1050 priming.
- d) Let the primer dry to touch, typically 1 to 3 hours. The URS 7600 topcoat must be applied ideally within 2 hours and within 6 hours of the primer having dried. (Prime again if you exceed 8 hours after primer dries)

Note:

The use of either Forsch urethane putty should if possible be avoided by starting with a smooth foam surface and applying enough Foam Kote during application for sanding the surface smooth. Foam Kote will not however hide defects always reflects what the surface condition was when Foam Kote was applied. A bump will still be a bump & a hole remains a hole, or a dimple.

- 8) Mix the two component top coat at one to one and apply by brush, roller or for best result by spray application method.
 - a) If painted or top coated within an 18 hour window of application the Foam Kote need only have a light sanding & PRI 1050 priming is not needed. The top coat paint and Foam Kote will form a molecular bond by cross linking together in the still uncured system to form a cross linked solid adhesion between the two layers.
 - b) Apply at least 2 layers of coating of at least 10 mils wet for each URS 7600 application so a 14 to 16 DMT (dry mil thickness) layer forms.
 - c) Wait until the first application to skin over, or is just dry to the touch before applying the second layer of URS 7600 paint.
 - d) **Allow 3 days URS 7600 cure time** or a minimum of 12 hours before putting system into service. Choosing to provide reduced cure time will normally result in having to redo affected repairs, or paint systems. In operating season may repairs suffer from reduced cure times in order to get the ride operating quickly. Often shortened cure times allow a ride to be safely repaired & returned to operation, only to need another repair being made in the off season when time permits.

Description of Foam Kote:

Foam Kote is a solvented elastomeric, two component moisture curing polyurethane coating. ASTM type IV. Cured films of this coating are tough, flexible, erosion resistant and display excellent tensile strength.

Foam Kote is used as a base coat over closed cell polyethylene foam. It is either applied by multiple layers to produce a smooth finish or applied in a few thicker coats to allow it to be granulated with EPDM granules to produce a non-slip coating.

It is recommended that all Foam Kote be Top Coated with Forschs URS 7600 a two part paint to provide needed UV & Chemical protection.

Foam Kote URS 2787 Base Coat:

Typical Properties:	Part "A"	Part "B"	"A/B"
Color:	gray	amber-brown	
% Solids weight:	71%	9%	
% Solids by volume:	66%	7.5%	52%
% Solids by weight:			56%
Weight Lbs./Gallon:	8.5 Lbs/Gal	7.0 Lbs/Gal	3.5 Lbs/Gal 420g/liter

Flashpoint:	81°F	102°F
Shelf Life: @ 73°F & dry conditions	1 year	1 year

(Unopened in sealed metal containers.)

Mix Ratio by volume: 3 "A" to 1 "B"

Pot Life: 3 hours @ 77°F & 50% R.H. (Relevant Humidity)

Tack Free Time: 30 to 90 minutes

Build: Apply in 30 mil to 40 mil WFT (Wet Film Thickness) coats. Let dry to tack free. Apply in up to five individual coats to achieve a final 60 mil to 70 mil DFT (Dry Film Thickness) coating.

(1 mil = 1/1000 inch)

Spray Equipment: Any standard airless sprayer with a titan adjusta tip

Coverage: 7.2 gallons covers - 100 sq ft. @ 60 mils THICK

or

27 liters covers - 9 sq m @1.50mm THICK