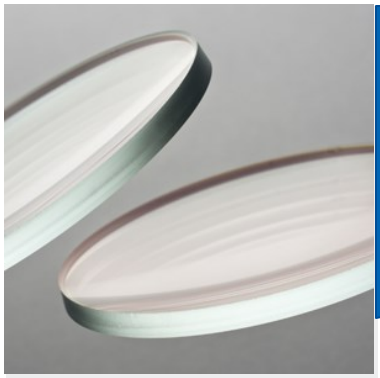

Technical Data Sheet

CrystalCoat™ PF-2810

Abrasion Resistant Coating, Primer-Free on Polycarbonate and Tritan™

DESCRIPTION

CrystalCoat™ PF-2810 is a polysiloxane based thermal cure coating with primer-free adhesion to polycarbonate and Tritan™ substrates.

FEATURES

- Abrasion Resistance
- Chemical Resistance
- Optical Clarity
- Fast tack-free dry time
- Primer-free Adhesion to Polycarbonate and Tritan substrates.
- Compatible with Anti-reflective and metalizing treatments

STORAGE AND USE

The recommended storage temperature for PF-2810 is 4°C (40°F). When stored at this temperature in the original closed container, it is recommended to start use of PF-2810 within 3 months of the date received.
For extended periods of storage (3 - 6 months), PF-2810 should be stored in a freezer at -18°C (0°F).

SOLUTION PROPERTIES

PROPERTY	TYPICAL VALUES
Solids	22 - 25 %
Viscosity @ 25°C	≤ 11.0 cP
Density @ 25°C	0.90 - 1.00 g/ml
Solvents: Water, Methanol, Ethanol, EB Glycol Ether, PM Glycol Ether, Diacetone Alcohol	

CURED COATING PROPERTIES

PROPERTY	TYPICAL VALUES
Coating Thickness	3.0 - 5.0 µm
Refractive Index	1.49
Bayer Ratio	3.0 - 4.0
Adhesion	100 %

RECOMMENDED OPERATING GUIDELINES

PROPERTY	TYPICAL VALUES
Environmental Conditions	20 - 25 °C, 30 - 55 % RH
Air Flow	Filtered, Laminar
Coating Temperature	16 - 18 °C
Coating Filtration	5 - 10 µm absolute
Extraction Speed	4.0 mm/s
Dry Time/Temperature	5 mins IR heater
Cure Conditions	Polycarbonate—3hrs @ 129 °C Tritan—5hrs @ 90°C

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CrystalCoat™ PF-2810

Abrasion Resistant Coating, Primer-Free on Polycarbonate

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CrystalCoat™ is a trademark of SDC Technologies.

Teflon® is a registered trademark of E. I. due Pont de Nemours & Co.

Tritan™ is a trademark of Eastman Chemical Company

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EQUIPMENT PREPARATION

Equipment Cleaning: Coating equipment should be cleaned prior to use of PF-2810 in order to avoid any possible contamination problems. Coating contamination can result in adhesion problems or general appearance problems. The cleaning process should include multiple solvent rinses (utilizing a solvent compatible with the material in prior use with the equipment) followed by a thorough PM Glycol Ether rinse. PM Glycol Ether should also be used for cleaning equipment after the use of PF-2810.

Equipment Materials: All equipment surfaces that are exposed to PF-2810 should be constructed of stainless steel, polyethylene, polypropylene or Teflon®. Other materials should be tested for compatibility with PF-2810 prior to use. Materials made with polyvinyl chloride (PVC) should not be used under any circumstances with PF-2810 or other primers or coatings that contain glycol ethers.

PRETREATMENT AND CLEANING OF SUBSTRATE

Prior to coating with PF-2810 , parts should be clean and free of any surface residues. Parts to be coated with PF-2810 should be clean and free of any possible surface residues. Injection molded parts should be cleaned with a neutral or slightly alkaline pH detergent solution to remove any residues left on the parts from the molding process, and then rinsed thoroughly with de-ionized water.

SOLUTION MANAGEMENT

For optimum performance, PF-2810 should be maintained in a % solids range of 22 - 25%. Higher or lower solids can cause appearance problems or lead to a coating deposition that is either too thick or too thin, respectively. The % solids should be measured on a regular basis and adjusted as needed by the addition of SM-835 a 90/10 mixture of denatured ethanol and PM glycol ether. Denatured ethanol formulations that contain methanol, isopropanol and <1% water can be used.

HEALTH AND SAFETY INFORMATION

Before using this product, read and understand the Safety Data Sheet, SDS, which provides information on health, physical, and environmental hazards, handling precautions and first aid recommendations. For a copy of an SDS, contact a sales or customer service representative.

WARRANTY AND LIABILITY LIMITATIONS

Information contained herein is accurate to the best of our knowledge. The coating solution properties and cured coating properties listed herein represent typical values for PF-2810 and are not meant as specifications. SDC Technologies, Inc. insists that users conduct their own tests for applicability and fitness for any purpose. Statements concerning use of products or formulations described herein shall not be construed as a warranty or license to infringe any patent or trademark, and no liability for infringement arising out of such use is assumed. Please refer to SDC Technologies' Standard Terms and Conditions or to your Purchase Agreement with SDC for the warranty coverage of SDC's product.

PRODUCT SHIPPING AND AVAILABILITY

Typical lead-time for shipment of PF-2810 is four (4) weeks from confirmation of a purchase order. SDC provides several shipping options. Please contact an SDC representative to determine which option best fits your needs. All orders are shipped F.O.B. Additional shipment charges including customs clearance and fees (if applicable) are the responsibility of the customer.

Mitsui Chemicals Group