

MARSHALL DEVELOPMENT LABORATORY STANDARD FORMULATING PRACTICE FP-893-A

Date of Issue: 9/30/65

Supersedes: New

I. Description of Line:

(a) General Description:

The 893-A line is an alternate for the 867-line High Gloss Thermo-Flow "Lucite*" Acrylic Lacquer metallics designed for automotive use. The 893-A line is an Industrial Sales code for use mainly in the sale of casket finishes.

(b) References:

Correspondence with the National Casket Co., Lancaster, Kentucky during 1964 and 1965.

II. Application and Testing:

Refer to the 867-line formulating practice for physical constants data.

The application procedure used in finishing caskets is a bake-sand-bake system which is, as follows:

1. Hand spray 0.3 mil DFT 881-2038 Primer, reduced by volume 1-1/2 parts 37767 thinner to one part 881-2038. Flash 1-2 minutes.
2. Immediately spray one heavy coat, then a mist coat to DFT of 1.0 mil of 893-line lacquer, reduced equal parts with 37767 thinner.
3. Flash 10 to 15 minutes.
4. Spray 2.0 mils DFT of 4550 clear, reduced 1.25 parts 37767 thinner to one part of 4550.
5. Flash 10 to 15 minutes, then bake 15 min. at 180°F.
6. Cool and wet sand with 500 or 600 W/D sandpaper and odorless mineral spirits.
7. Clean-Up.
8. Reflow bake at one of the following schedules:

30' x 250°F
15' x 270°F
10' x 300°F

*-Registered Du Pont Trademark

III. Formulation:

(a) Pigmentation:

All 893 line colors should meet the 867 line pigmentation practice but exterior durability is not required. Any unusual problems or deviation from this practice should be referred to the Marshall Development Laboratory for approval or alternate recommendations.

(b) Vehicle:

Same as 867 line.

(c) Modifying Agents:

Same as 867 line.

(d) Thinners:

All regular "Lucite" thinners can be used but 37767 is preferred.

IV. Formulating Tables:

None

V. Manufacturing Problems:

Refer to 867 line formulating practice.

VI. Reason for Revision:

New

MARSHALL DEVELOPMENT LABORATORY

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