

MARSHALL DEVELOPMENT LABORATORY
STANDARD FORMULATING PRACTICE FP-890-A

DATE OF ISSUE - 9/30/65

SUPERSEDES: NEW

I. DESCRIPTION OF LINE:

(a) General Description:

The 890-A line is an alternate line for the 868-line automotive quality "Lucite*" non-metallic acrylic lacquer. This line is supplied to Industrial Sales for use mainly as casket finishes.

(b) References:

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

II. APPLICATION AND TESTING

Refer to the 868-line formulating practice for physical constants data.

The application procedure for casket finishes comprises a bake-sand-bake system which is, as follows:

1. Spray 0.3 mil DFT 881-2038 Primer, reduced 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 a DFT of 1.0 mil of 890-line lacquer, reduced equal parts with 37767 thinner.
3. Flash 10 to 15 minutes.
4. Spray one heavy coat to a DFT of 2.0 mils of 4550 clear, reduced 1.25 to 1 with 37767.
5. Flash 10 to 15 minutes, then prebake 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 890-A line colors should meet the 868 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 868-line.

(c) Modifying Agent

Same as 868-line.

(d) Thinners

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

IV. FORMULATING TABLES

None

V. MANUFACTURING PROBLEMS:

Refer to 868-line

VI. REASON FOR REVISION

New

MARSHALL DEVELOPMENT LABORATORY

A. F. Krause

A. F. KRAUSE

AFK:ms
10/6/65

ANG