



TECHNICAL DATA SHEET #65

## PDC® F-897 IMC

ALIPHATIC POLYURETHANE BASED-IN MOLD FOAM COATING  
FOR INDUSTRIAL USE ONLY

### DESCRIPTION:

**F-897 is a unique high performance aliphatic polyurethane IMC [in mold coating] that is spray applied into the mold tool to provide a durable, flexible, chemical and UV resistant coating on flexible urethane molded products.**

F-897 acts as the finish coat or can be used as an in mold barrier coat and post coated after trimming. F-897 offers excellent durability, flexibility, abrasion, UV and chemical resistance. The demand for a high performance IMC [in mold coatings] makes this innovative product the new alternative for your specialty foam products applications in the medical, sporting goods, pool and spa, leisure, automotive and industrial markets.

### OTHER FEATURES INCLUDE:

Intended for use in molds with starting temps 70-90° F

Super fast dry time

Custom color matching

Very good chlorine, bromine and other harsh chemical resistance.

### SPECIFICATIONS:

Solids: (wt.) F-897 10%

Shelf life: 1+ years at 77°F unopened container

Finish: semi gloss

Coverage: 225 sq ft/ gal @ 1 mil

Shore A Hardness 40

**ALTERNATIVE PRODUCTS:** F-899, F-953, F-959

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**SURFACE PREPARATIONS:**

All surfaces to be coated must be free of any oils, dust or loose foam particles. Allow solvent to flash before applying F-897 to mold.

**USE ADEQUATE VENTILATION.****SPRAYING: GENTLY MIX BEFORE SPRAYING.**

Siphon Gun/ Pressure pot sprayers may be used.

F-897 as **IMC** [in mold coating]. Apply wet, overlapping coats to mold holding gun 6"-12" from surface, using 4"-6" pattern. Be sure to coat entire surface evenly. Allow to dry to the touch before adding polyurethane chemicals. Allow adequate "bake" time for the foam before removing finished product. If a seam is present after removal of any flashing, either touch up with paint brush or proceed to finish coat step.

F-897 finish coat. Apply wet, overlapping coats, holding gun 6"-12" from surface, using 4"-6" pattern. Allow to dry to the touch before applying additional coats or turning part over. Its recommended that 2-3 coats be applied for best results. Allow coated part to dry 4 to 6 hours minimum [depending on mil thickness applied] before handling and 24 hours minimum before packaging or shipping.

**RECOMMENDED EQUIPMENT AND SETTINGS:**

Binks® model 2100 gun	Material: 20psi
Nozzle: 63B	Atomization: 10-25psi
Cap: 63PB	Dilution: up to 10% toluene
Needle: 363A	Clean up: toluene

**HINTS:**

Always use proper ventilation and protection. Allow overnight drying whenever possible. Avoid excessive air movement, heat or humidity. To accelerate drying of coated parts: air dry coated part 10-15 minutes then force dry 30-60 minutes at 90-120° F being careful not to distort or damage foam substrate. Contact foam manufacturer for guidelines.

**Caution:**

Flexible molded polyurethane foam may have a tendency to out gass which can cause delamination or blistering of the coating or distorsion of the part. Use caution when speed drying or shipping coated parts by air freight or into hot conditions too soon after completing part.