



TECHNICAL DATA SHEET #64

PDC® F-899 IMC

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

DESCRIPTION:

F-899 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-899 acts as the finish coat or can be used as an in mold barrier coat and post coated after trimming. F-899 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 70-100° F
Super fast dry time
Custom color matching
Very good chlorine, bromine and other harsh chemical resistance.

SPECIFICATIONS:

Solids: (wt.) F-899 14%	Shelf life: 1+ years at 77°F unopened container
Temperature use range: 0°F to 200°F	Coverage: 225 sq ft/ gal @ 1 mil
Block resistance: 4hr @ 140°F	Finish: gloss
Shore A Hardness 40	

CHEMICAL RESISTANCE: In House Test Results: Further testing being done.

Good- Excellent common household chemicals.

ALTERNATIVE PRODUCTS: F-897, F-953, F-959

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SURFACE PREPARATIONS:**MIX WELL BEFORE USE.**

All surfaces to be coated must be free of any oils, dust or loose foam particles. It is recommended that the entire foam surface be wiped clean using a lint free cloth with either NMP [n-methyl-pyrrolidone] or MEK [methyl ethyl ketone] solvent. Allow solvent to flash before coating.

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

Pressure pot/conventional sprayers may be used.

F-899- Apply wet, overlapping coats, holding gun 6"-12" from surface, using 4"-6" pattern. Allow 30 minutes minimum dry time before applying additional coats or turning part over. It's recommended that 2-3 coats be applied for best results. Allow coated finished 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: not recommended
Needle: 363A	Clean up: Glycol Ether EB or quality lacquer thinner.

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:

EVA foam has a tendency to out gass which can cause delamination or blistering of the coating. Use caution when shipping coated parts by air freight or into hot conditions too soon after completing part.