



TECHNICAL DATA SHEET #45

PDC® F-786's' eccs®

IMC Acrylic Urethane Spray Coating FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-786's' is a water base in mold barrier coating is specifically developed to use as an in mold coating for flexible polyurethane foams. F-786's' has a "built in" mold release and is recommended as an **IMC** [in mold coating] only and is a very economical, efficient, non-flammable coating. F-786's' is used in manufacturing of patient positioning products such as wheelchair cushions, positioning aids as well as other industrial applications.

SPECIFICATIONS:

Solids: (wt.) 36%
Shelf life: 1+ years at 77°F unopened container
Coverage: 250 sq ft/ gallon @ 2 mils.
Finish: matte

SURFACE PREPARATIONS:

MIX WELL BEFORE USE.

All surfaces to be coated must be free of any oils, dust, release agent build up or loose foam particles. .
Allow any solvent to flash before applying F-786's'.

USE ADEQUATE VENTILATION.

SPRAYING: GENTLY MIX BEFORE SPRAYING.

Pressure pot sprayers are recommended. Bring mold to temp to 125-135 degrees f.
Apply light [damp] overlapping coat of F-786's' to mold, holding gun 6"-12" from surface, using 4"-6" pattern. Be sure to coat the entire surface. Allow F-786's' to become "tacky" before adding polyurethane chemicals. Allow adequate "bake" time for the foam before removing finished product.
Contact OEM Technical Support for more details regarding your specific application and process and top coat recommendations.

RECOMMENDED EQUIPMENT AND SETTINGS:

| | |
|--------------------------|----------------------------------|
| Binks® model 2001/95 gun | Material: 20psi |
| Nozzle: 63C | Atomization: 10-30psi |
| Cap: 63PB or 66SD | Dilution: not recommended |
| Needle: 363A | Clean up: water, MEK once dried. |

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