



# PDC® F-818 Vinyl Dip

## FOR INDUSTRIAL USE ONLY

### DESCRIPTION:

F-818 is a vinyl based coating designed to coat vinyl based foams. F-818 has excellent chemical, petroleum, abrasion, moisture and UV resistance. F-818 can be used on items such as key fobs, can coolers, medical cushioning, pool floats, sporting goods, padding, wrestling mats, etc. For our highest gloss finish, top coat with F-760.

### OTHER FEATURES INCLUDE:

- Fast dry times.
- Excellent flexibility.
- Wide selection of colors.
- Passes requirements for UL94 HBF
- Does not cause artifacts in imaging applications**

### SPECIFICATIONS:

Solids: (wt.) 15%	Elongation: (ASTM D-412) 421%
Temperature use range: -30°F to 200°F	Tensile: (ASTM D-412) 1958psi
Block resistance: 4hr @ 140°F	Shelf life: 1+ years at 77°F unopened container
Weather ability: (ASTM G-53) excellent 7-10 yrs	Coverage: 60 sq. ft. per gal at 5 mils
	Finish: Gloss

### Chemical resistance: In House Test Results [ASTM D-1308]

Mineral oil:	very good	Machine Oil:	very good
Saline:	very good	Blood:	very good
Urea (6% in H2O):	very good	All purpose cleaner:	very good
Betadiene (Iodine):	*very good	Acid (10% sulfuric in H2O):	very good
Gasoline:	good	Alcohol:	very good

\*stained after 5 minutes.

### ALTERNATIVE PRODUCTS:

For bonding vinyl based foams, see Vyna Bond F-632 technical data sheet #2. For high gloss clear coat, see F-760 technical data sheet #17.

We cannot anticipate all conditions under which this information and our products, or the products of other manufacturers in combination with our products, may be used. We accept no responsibility for results obtained by the applications of this information or the safety and suitability of our products, either alone or in combination with other product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and buyers and users assume all responsibility and liability for loss or damage arising from the handling and use of our products whether used alone or in combination with other products. Ever changing V.O.C. regulations in your area may require you to contact local authorities for proper use and/or disposal of this product. Should you need further assistance, please contact PLASTI DIP INTERNATIONAL technical service.

## **SURFACE PREPARATION:**

All surfaces to be coated must be free of any oils, dust or loose foam particles.

## **USE ADEQUATE VENTILATION.**

## **MIXING INSTRUCTIONS:**

### **QUALITY CONTROL RECOMMENDATIONS FOR SPRAY AND DIP APPLICATIONS.**

Like most liquid vinyls, F-818 may coagulate during storage, requiring thorough remixing agitation before use each day. For best results, a Cowles® or dispersion blade gives the maximum combination of high shear, excellent flow and circulation. Diameters of 3" for mixing five gallon containers and 7" for mixing 50 gallon drums. Note: It has been found that the dispersion blades are highly effective, fast and produce more shearing action than can be obtained from a standard mixing blade or paddle.

**Avoid making solvent additions before mixing. Check viscosity.** Some adjustments may be necessary for your particular use. F-818 is normally used in a 15 – 20 second range using a Zahn #3. If coating mixture exceeds 20 seconds, or is not flowing off part properly, dilute coating mixture with a 1 to 1 ratio of M.E.K. and Toluene until a satisfactory range is accomplished. Contact technical service for specific applications.

**SPRAYING: Industrial/commercial airless sprayers** may be used. Contact technical service for specific applications.

**DIPPING:** Hang part securely with a thin wire hook. Submerge part completely using a clean paint stick (or other blunt object) making sure entire part has been "wetted" out or covered. Remove quickly and allow to run off. Air dry to the touch and repeat 3-5 coats. If faster drying is preferred, allow to air dry 30-60 seconds, then place in mild heat (95°F-120°F) with mild air flow. Make sure the heat source is safe for this use and that you ventilate properly. Drying will typically take 10-15 minutes (air dry 30-45 minutes). Apply 3-5 coats to your desired thickness.

## **HINTS:**

When using a dip tank, always leave at least 6" from fluid surface to tank top to minimize "skinning over". For surface defects (fish eyes or pin holes) add a defoamer, such as BYK066 from BYK ChemieCorp or contact technical service for assistance. Always use proper ventilation and protection. If dip coating more than 2 coats, reverse hanging part 180° after second coat has dried and apply final coats. This will better distribute the coating milage more evenly across the entire part being coated.