



## **PDC® F-851's' eccs®**

**IMC Acrylic Spray Coating  
FOR INDUSTRIAL USE ONLY**

### **DESCRIPTION:**

F-851's' is a water base in mold barrier coating is specifically developed to use as an IMC [in mold coating] for flexible polyurethane foams. F-851's' is very economical, efficient, non-flammable and also reduces the risk of coating adhesion issues with top coats. F-851'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-851'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-851's' to mold, holding gun 6"-12" from surface, using 4"-6" pattern. Be sure to coat the entire surface. Allow F-851'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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