



TECHNICAL DATA SHEET #65

PDC® F-897

IMC Aliphatic Urethane Spray Coating FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-897 is a unique high performance aliphatic urethane **IMC** [in mold coating]. This high performance coating is an air dry, spray applied coating used in mold for *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:

Super fast dry time
Custom color matching
Unbeatable chlorine, bromine and other harsh chemical resistance.

SPECIFICATIONS:

Solids: (wt.) F-897 10%
Finish: semi gloss

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

ALTERNATIVE PRODUCTS:

Contact Technical Support

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.

PDC is a registered trademark of PLASTI DIP INTERNATIONAL
Performix and logo are trademarks of PLASTI DIP INTERNATIONAL
BINKS is a registered trademark of BINKS MFG. CO., Franklin Park, IL

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

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 mils thickness applied] before handling and 24 hours minimum before packaging or shipping. Contact OEM Technical Support for assistance regarding your specific application and process.

RECOMMENDED EQUIPMENT AND SETTINGS:

Binks® model 2001/95 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 manufacture 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.