



TECHNICAL DATA SHEET #4

PDC® F-851's' IMC eccs®

WATER BASED ACRYLIC In Mold 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.

OTHER FEATURES INCLUDE:

Intended for use in molds with starting temps 80-110 °F.

Water base clean up.

One component-no catalyst

Custom color matching

SPECIFICATIONS:

Solids: (wt.) 36%

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

Coverage: 250 sq ft/ gallon @ 2 mils.

Finish: matte

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**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 2100 gun

Material: 20psi

Nozzle: 63C

Atomization: 10-30psi

Cap: 63PB or 66SD

Dilution: not recommended

Needle: 363A

Clean up: water, MEK once dried.