

PDC® F-1059 IMC

DMF FREE

TPU POLYURETHANE BASED- IN MOLD FOAM COATING
FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-1059 is a unique, high performance thermoplastic polyurethane IMC [in mold coating] that is spray applied into the mold tool to provide a durable, flexible, chemical and UV resistant coating on flexible urethane molded products. F1059 is also DMF FREE.

F-1059 IMC is a thermoplastic polyurethane coating typically spray applied as an in-mold coating [IMC] for molded flexible and rigid polyurethane foams.

F-1059 IMC is specifically designed for use in aluminum molds where high temperature applications are needed, 115-145°F.

F-1059 IMC provides a .5-1.5 mil coating that acts as a barrier and protects molded foams from UV, moisture, impact, puncture, abrasion, and chemicals while providing a durable flexible finish.

OTHER FEATURES INCLUDE:

Intended for use in molds with starting temps 115-145° F

Wide selection of colors.

Single component - no catalyst.

Fast dry time.

DMF free

SPECIFICATIONS:

Solids: (wt.) 11%

Temperature use range: -0°F to 250°F

Block resistant: 4hr @ 200°F

Shelf life: 1+ years @ 77 f unopened container

Coverage: 180 sq. ft. per gallon at 1 mil

Tensile: [ASTM D-412] 4500 psi

Elongation: [ASTM D-412] 630%

Tear Strength: [ASTM D-1004] N/A

Finish: semi-gloss

ALTERNATIVE PRODUCTS: F-897, F-899, F-1053

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SURFACE PREPARATIONS:

For best results avoid using silicone lubricants or excessive amounts of wax on mold surfaces. Always ensure the mold release being used is “paint compatible” or “paintable” to minimize adhesion issues.

USE ADEQUATE VENTILATION.**MIXING INSTRUCTIONS:****QUALITY CONTROL RECOMMENDATIONS FOR SPRAY APPLICATION.**

F-1059 IMC will thicken/settle during storage, requiring thorough remixing before use each day. Use a high speed sheer blade for best results. You can find this equipment at www.indco.com or for 5 gallon pails use a high rpm 3/8” air drill, threaded shaft with 4” circular saw blade and double nut with washers. Mix the pail for 2-3 minutes each day before use or every 4 hours during use for best results.

Avoid making solvent additions before mixing. Check viscosity. Some adjustments may be necessary for your particular use. Contact technical service for specific applications.

Spraying in mold: Hold spray gun 6"-10" from the mold surface, apply F-1059 IMC in a uniform wet coat using an overlapping motion. Be sure to cover the entire mold surface evenly to avoid finish variations. Check dry coating thickness periodically to ensure a minimum thickness of .5-1.5 mils are achieved for best results.

NOTE: To accelerate cycle times preheat the mold between 115-145° F.

RECOMMENDED EQUIPMENT AND SETTINGS:

Binks® model 2100 gun

Nozzle: 66SS

Cap: 66SD

Needle: 565

Material: 10-12 psi

Atomization: 40-60 psi depending on spray pattern and distance from mold applied

Dilution: none required

Clean up: Acetone or MEK

HINTS: Always mix before spraying. Always use proper ventilation and protection.