



Technical data sheet #114

PLASTI DIP® F-866

SYNTHETIC RUBBER BASED COATING
FOR INDUSTRIAL USE ONLY

DESCRIPTION:

PLASTI DIP® F-866 is high build air dry, synthetic rubber coating that can be easily applied by spraying, brushing or dipping. PLASTI DIP® F-866 resists moisture, acids, abrasion, weathering, electrical shock, skidding/slipping, corrosion; coats and gives a comfortable, controlled, color coded grip to all types of tools; lawn and garden, mechanical, electrical, woodworking and masonry.

PLASTI DIP® F-866 can also be applied to:

Wood: seals and protects from weathering and prevents splinters.

Metal: reduces vibration, deadens sound, prevents corrosion, insulates electrically and from extreme temperatures.

Glass: shatterproofs glass objects (available in clear).

Rope/Fabrics: weatherproofs, prevents rotting and fraying.

Plastics: protects delicate surfaces from scratches.

Rubber: weatherproofs, wear resistant.

SPECIFICATIONS:

Solids: (wt.) 28%

Tensile: (ASTM D-638) 3,740psi

Elongation: (ASTM D-638) 430%

Cut resistance: (ASTM D-1044) very good

Coverage: 40 sq.ft. per gallon at 10 mils

Stone abrasion: (ASTM D-3170) excellent

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

Viscosity range: 80 – 100 K.U. @ 77°F (+/- 2°F)

Durometer: shore A (ASTM D-2240) 70

Salt spray: (ASTM B-117) passed 1,000 hours

Temperature use range: -30°F to 200°F.

Permeability: (ASTM E-96) .03 grains/sq. ft./hr.

Dielectric: (ASTM D-149) 1,400 v/mil

Chemical resistance:

acids, alkalines, pollutants: excellent

petroleums: limited

ALTERNATIVE PRODUCTS:

HCFeccs® F-688/ F-688's', PLASTI DIP® F-829, F-819, F-698

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SURFACE PREPARATION

MIX WELL BEFORE USE.

All surfaces to be coated must be free of all oils, grease, dirt, wax and loose rust. A sandblasted or rough surface improves adhesion. Use PLASTI DIP® PRIMER F-716 or H.P. PRIMER F-938 on all metals for best results.

SPRAYING: Pressure pot may be used (siphon cup not recommended). Dilute with recommended thinners up to 50% as needed. Gently mix before spraying. Apply wet overlapping coats, holding gun 6"-12" from surface, using a 4"-6" pattern. Allow 10-20 minutes dry time before applying additional coats to desired thickness.

RECOMMENDED EQUIPMENT AND SETTINGS:

Binks® model 2100 gun

Nozzle: 63B

Needle: 663A

Material: 20-25psi

Atomization: 15-25psi

Dilution: as needed

Cap: 63PB (up to 50% dilution) or 66SD (up to 50% dilution) for heavier build up.

Clean up: See recommended thinners.

SPRAYING: Airless equipment may be used. Use as described above.

Tip size: .011 - .019

Pressure: as needed

Dilution: up to 50%

DIPPING: Dilute with recommended thinners up to 25% as needed. Gently mix before each use. Do not introduce air bubbles. Insert item 1" every 5 seconds. Remove at same rate. Allow 30-40 minutes (dry to the touch) dry time before applying additional coats to desired thickness.

BRUSHING: Dilute with recommended thinners up to 25% as needed. Gently mix before each use. Apply wet overlapping coats using a soft natural bristle brush. Allow 10-20 minutes (dry to the touch) dry time before applying additional coats to desired thickness.

HINTS:

Recommended thinners: Toluene or VM&P Naphtha. A dry film thickness of 12-15 mils is recommended for best results. Approximate dry mil thickness per coat, dipping 6-8 mils; brushing 4-5 mils; spraying 2-5 mils. **Allow 4 hours dry time per coat before use.** Allow overnight drying whenever possible. When using a dip tank, allow 6" minimum from fluid surface to tank top to avoid "skinning over". Avoid excessive air movement, heat or humidity. Always use proper ventilation and protection.