IN-MOLD COATING

POLANE® GLAS CLAD®

E67BC1905—BLACK CONDUCTIVE IMC

THE REFLECTION OF A WINNER

PRODUCT DESCRIPTION

E67BC1905 is a conductive in-mold coating designed to be injected onto SMC, Preform or BMC while still in mold, allowing for the easy removal of parts from the tools. It is also designed to exhibit greater hot hardness as well as greater hardness overall when compared to other products. In addition, it exhibits improved water spot resistance over other products. A long workable pot life permits the use of one component injection equipment. This technology leaves a conductive surface allowing electrostatic application of subsequent coatings while filling mold imperfections and surface porosity.

TECHNICAL DATA

Mixing Ratio: 60 to 1 with TBPB

Color: Black

Viscosity: 18,000–26,000 cps

VOC: Zero

Theoretical Coverage: 1,600 sq. ft./gal. @ 1.0 mil.

Dry Film Thickness: 3.0–5.0 mils.

% Volume Solids: 100%

Weight per Gallon: 11.9 ±0.5 lbs./gal.

% Weight Solids: 100%

Conductivity: 140 min. (RA236)

SPI Gel Test: Time from 150°F to peak temperature 99–172 sec., peak temperature 335°–400°F

Grind: 4 hegman–grind, 2 hegman–clean

Pot Life: 12 days at 80°F

SPECIFICATIONS

Ford: ESBM2P124-A1, ESBM2P7-B2 and ESBM99J331-A

Freightliner: 49-00087 (Rel: PA2024-61)

GM: 998-4365M

Kenworth: R026-198-108 and R026-198-116

Mack: 014GS16017, 617GS133 and 617GS12

APPLICATION

SMC compression molding press and mold, P-20 chromed steel or equivalent. One component coating injection equipment for automated system.

Catalyst 100% t-butyl perbenzoate. Carefully read and follow the cautionary information on the TBPB container.

60 parts by weight GLAS CLAD® to 1 part TBPB.

Dry film thickness is dependant on part geometry and process controls. Film thickness for specific parts should be evaluated for each case.

*Note: Mix thoroughly (minimum 8 minutes at 1500 rpm with paddle style blade).

Other TBPB levels may be used with manufacturer's approval.

CURE SCHEDULE

30 seconds at 300°F.

Part configuration, TBPB levels and mold temperature will affect cure rate.

STORAGE

Store material indoors away from heat and sunlight. Do not store over 90°F. Lower storage temperature (50°–60°F) will lengthen shelf life.

Use within 6 months of date of manufacture.

SHERWIN-WILLIAMS AUTOMOTIVE FINISHES

OEM OPERATIONS

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