

# IN-MOLD COATING

POLANE® GLAS CLAD®

E67BR1906—BLACK CONDUCTIVE IMC

THE REFLECTION OF A WINNER

## PRODUCT DESCRIPTION

E67BR1906 is a low viscosity conductive in-mold coating designed to offer better coverage for molders when injecting onto SMC, Preform or BMC while still in the mold. It maintains the greater hot hardness and overall hardness that E67BC1905 contains, as well as the water spot resistance. A long workable pot life permits the use of one component injection equipment. This technology leaves a conductive surface allowing electrostatic application of subsequent coating while filling mold imperfections and surface porosity.

## TECHNICAL DATA

Mixing Ratio: 60 to 1 with TBPB  
Color: Black  
Viscosity: 4,500–9,000 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: 10.8 ±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

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.