

IN-MOLD COATING

POLANE® GLAS CLAD®

E67AR1908—GRAY CONDUCTIVE IMC

THE REFLECTION OF A WINNER

PRODUCT DESCRIPTION

E67AR1908 is a gray conductive in-mold coating designed to be injected onto SMC, Preform or BMC while still in the mold, allowing for the easy removal of parts. A long workable pot life permits the use of one component injection equipment. This technology leaves a gray 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: Gray
Viscosity: 15,000–26,000 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: 10.7 ±0.5 lbs./gal.
% Weight Solids: 100%
Conductivity: 160 min. (RA236)
SPI Gel Test: Time from 150°F to peak temperature 99–175 sec., peak temperature 335°–400°F
Grind: 4 hegman–grind, 2 hegman–clean
Pot Life: 5 days at 80°F

SPECIFICATIONS

Mack: 014GS16017, 617GS133 and 617GS12
Volvo: 5751Y550

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

40 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.