

**In-Mould Coating**  
 - Protective Coating, Spar Varnish -

HP-IMC is a two component polyurethane in-mould coating with long time adhesion to following epoxy layers.

**Applications:**

- long time adhesion to suitable epoxy resins
- high quality coatings for In-Mould coating (first layer in female moulds)
- long time causes to user friendly processing
- available in different colours (RAL colour chart)
- good uv-stability
- for spraying, manual application with a paint-brush is also possible
- wax free

Generates chemical compounds with all epoxy-resins (laminating, covering and infusion) from HP-Textiles.

**Processing data:**

Colouring	Available almost in all RAL colours, and also in transparent.		
Mixing ratios	100 parts resin / 50parts hardener	(by weight)	
Working Time (pot life)	30 min	(at 20°C)	
Working Temperature OPTIMUM	18 - 25	°C	
Working Temperature MINIMUM	15	°C	(air)
	18	°C	(mixture)
Waiting time before laminating	approx. 24	h	(at 20°C)
	approx. 6	h	(at 40°C)
Consumption per layer	70-80	g/m <sup>2</sup>	(wet)
	<i>results to approx.</i> 40-50	g/m <sup>2</sup>	(dry)
Recommended number of coats / layers	2 - 3	(depends on the covering of the colour)	
1 liter mixture is enough for 4-5m <sup>2</sup> surface in 3 layers with each 75g/m <sup>2</sup> (wet).			
Mixed viscosity	15 – 16	s	4mm nozzle (resin)
Density	1	g/cm <sup>3</sup>	(approx)
Temperature stability			
Decrease of surface hardness from	approx. 100	°C	

**Further datas:**

V.O.C. sprayable product	480 - 500*	g/L	
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\* depends on the colour

*Information presented herein has been compiled from sources considered to be dependable and is accurate and reliable to the best of our knowledge and belief but is not guaranteed to be so.  
 It is the user's responsibility to determine for himself the suitability of any material for a specific purpose and to adopt such safety precautions as may be necessary. We make no warranty as to the results to be obtained in using any material and, since conditions of use are not under our control, we must necessarily disclaim all liability with respect to the use of any material supplied by us.  
 We recommend tests be performed for trials and suitability for the particular type of application.  
 With the newest printing of this data sheet the previous version loose validity!*

### Safety instructions:

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The safety instructions are to be taken as being of greatest importance.  
Do not allow children to handle. Prevent inhalation of the fumes and contact with the bare skin.  
Wear approved protective gloves and goggles. If ingested do not eat, drink or smoke.  
Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapours and paint mist by wearing an air mask.  
Only mix the components in the recommended proportions in accordance with the instructions.

### Surface preparation:

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Avoid direct sunlight while coating!

#### In-Mould coating:

- Apply suitable release agent.
- A combination of priming wax (HP-G) and a film release agent (HP-PVA) is possible.
- You can also use HP-CX7 (carnauba-wax) or the water based, high-gloss release agent HP-HGR5.
- Weigh out resin and hardener (100:50) and mix it. Avoid bubbles formation during the stirring period.
- We recommend 2-3 layers of In-Mould
- It is not necessary to grind before the 2<sup>nd</sup> layer, when apply within 24h.
- Minimum waiting time required before start laminating with epoxy resin: 24h at 20°C

### Application:

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Spray coating: Nozzle 1.2 - 1.4mm / air pressure 4 bar / 2-3 layers

Roller coating: Use rolls with very fine upper face finish.  
Apply constant in several directions and avoid bubbles formation.

### Cleaning work tools:

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Unhardened product remains can be removed from tools by means of acetone or Thinner XB. Tools should be given a good airing after being cleaned with these solvents, in order to prevent the solvent from being retained until the tool is used again in a process.

Hardened remains can only be removed by mechanical means such as grinding tools.

### Storage:

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Threaded container tops should be kept free of material remains. Do not exchange tops/lids.  
With optimal storage conditions, shelf-life should be beyond 12 months.

### Disposal:

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Do not dispose of through the sewerage system, on areas of open water, or in the soil.  
The hardened product waste should be treated as building rubbish or household rubbish.

### Further Information:

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Further application information can be obtained from our Internet site, by selecting Product Info on the homepage. Please do not hesitate to contact us by telephone if you have further queries.