



## 2K-IN-MOULD-COAT 6991

**Base** : Polyurethane resins, anorganic and organic pigments, dissolved in organic solvents.

**Application** : For colouring of workpieces in the mould. The workpieces are made of Polyurethane which is Polyester – and Polyether based.

**Processing** : Before processing the colour has to be stirred very well. Also during processing the colour should be stirred in order to avoid separation.

**2K-In-Mould-Coat** has to be mixed with hardener D 330 in the following mixing ratio:

- 100 g 2K-In-Mould-Coat 6991
- 12 g Hardener D 330
- Pot-Life approximately 2 hours

While processing **2K-In-Mould-Coat 6991**, the moulds that are considered for the material have to be sprayed evenly with Release Agent. The recommended mould-temperature is at 55 – 65°C. After an air-drying-time of 15 – 20 seconds, the moulds are sprayed evenly with **2K-In-Mould-Coat 6991**, already mixed with the corresponding hardener, by means of a spraying-gun; ( not too wet and not too dry ), nozzle size should be 1,0 mm, pressure should be 2 – 3 bar.

After a short air-drying-time the Polyurethane foam can be poured into the moulds as usual.

The manufactured Polyurethane workpieces can be demoulded within the normal circle time and are subsequently coloured with adhesive strength. Moreover this In-Mould-Coat can be adjusted in the requested colour tones.

**Technical Data** : - Base : Polyurethane resins, anorganic and organic pigments, dissolved in organic solvents.

- Density : Approximately 0,860 – 0,940 g/cm<sup>3</sup>
- Hazardous Classification : 3
- Flashpoint : -17° C
- Storage : Cool and dry, not below 5°C.

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*The information contained herein is based on our technical knowledge and experience. Since it is the user's responsibility to determine the suitability of the product for his own use, he should thoroughly test any application.*



**Technical Data Sheet**

KECK-CHIMIE S.A.  
67340 Ingwiller / France  
Tel. : +33 / 3 88 89 57 33  
Fax : +33 / 3 88 89 51 30  
mail : [info@keck-chimie.com](mailto:info@keck-chimie.com)

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