ROTATIONAL MOULDING · SOLVENT-BASED INK

Rotomold Ink SB

Solvent-based in-mould spray ink for rotational moulding

APPEARANCE
Black paste
in-mould ink

1.35–1.45 g/cm³	approx. 75–80 %	20–23 s	1–3 min	25–50 g/m²
Density (20 °C)	Solids	Spray viscosity (FC 4)	Flash-off	Theoretical consumption

Product description

UNICA ROTOMOLD INK SB is a solvent-based in-mould spray ink applied to the mould surface in rotational moulding. During the rotomoulding process it transfers into the polymer melt and creates a homogeneous, permanent colour on the plastic part surface.

Typical uses

- Rotomoulded plastic tanks
- Polyethylene containers and drums
- Toys and decorative plastic parts
- Industrial rotomoulded products

Advantages

- High transfer performance
- Even spreading in spray application
- Thermal stability for rotomoulding
- Homogeneous colour formation
- Good film formation on the mould
- Smooth, homogeneous appearance

Position in the system

Polymer part
PE melt – rotational moulding

In-mould ink film — THIS PRODUCT
ROTOMOLD INK SB · thin, even film

Mould surface
Clean metal mould

In-mould decoration

Ink transfers from mould to part during moulding

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Technical data (at +20 °C)

Appearance	**Black paste**	Spray viscosity (Ford cup 4, 20 °C)	**20–23 s**
Density (20 °C)	**1.35–1.45 g/cm³**	Flash-off	**1–3 min**
Solids	**approx. 75–80 %**	Solvent removal	**3–5 min**
Viscosity	**Paste**	Theoretical consumption	**25–50 g/m²**
VOC	**approx. 180 mg/g**	Storage temperature	**+15 °C to +30 °C**
Thinning (ink : UNIPU-006)	**40 : 60**	Shelf life	**12 months**

Application procedure

01

Thinning

Thin with the special solvent UNIPU-006 (40 parts ink : 60 parts solvent) and mix until homogeneous – spray viscosity 20–23 s FC 4.

02

Application

Apply a thin, even film on the mould by air spray, airless or automatic in-mould spray systems.

03

Flash-off

Allow 1–3 min flash-off and 3–5 min for solvent removal.

04

Moulding

Load the polymer into the mould and start rotational moulding – the ink film transfers to the part surface.

Thinning ratio

40 parts | **60 parts**

- **40 parts** — ROTOMOLD INK SB
- **60 parts** — UNIPU-006 solvent

Mix until homogeneous before application.

Spray viscosity
20–23 s
Ford cup 4 at 20 °C after thinning.

Flash-off
1–3 min
Solvent removal 3–5 min.

Consumption
25–50 g/m²
Theoretical – depends on film thickness and surface conditions.

Important: ensure adequate ventilation during application – the product contains solvents.

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Packaging

- 20 kg metal containers
- 200 kg drums

Storage

- Store closed in dry areas at +15…+30 °C.
- Protect from direct sunlight.
- Shelf life: 12 months.

Safety

- Provide adequate ventilation during application.
- See the Safety Data Sheet (SDS).

LEGAL NOTE

The explanations provided in this technical data sheet are based on test evaluations and results conducted according to relevant standards and are intended to guide applicators. As workmanship, weather conditions, construction, equipment used and other variables that may affect results are entirely beyond our control, UNICA does not provide any explicit or implicit warranty regarding this material. UNICA only guarantees that the material conforms to its product specifications, and its sole responsibility towards the buyer or user of this product is limited to the replacement value of the product in case of manufacturing defects. Under no circumstances shall UNICA be liable for any direct or incidental, special or consequential injury, loss or damage arising from the material or its application. UNICA shall not be held responsible in any way for any defects, alterations or changes in conditions in the substrate where its products are applied.

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