

Basis	Lightweight backfilling system
Resin	HFG
Hardener	PUR 11 Comp. B
Colour	grey

Applications

- Backfillings for core boxes
- Backfillings for negataves

Properties

- very thick castable
- fast curing
- impact resistant
- dimensionally accurate
- for large volume back fillings

Processing data

Product		Mixture HFG / PUR 11	Resin HFG	Hardener PUR 11 Comp. B
Colour		grey	grey	yellow
Mixing ratio	p. b. w.		100	33
Viscosity at 25°C	mPas	20000 ± 5000	pastös	25 ± 10
Density at 20°C	g / cm ³	0,97 ± 0,02	0,90 ± 0,02	1,10 ± 0,02
Pot life 200 g / 20°C	min.	7 - 9	-	-
Curing time at RT	hrs.	4 - 5	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	22 ± 2
Flexural modulus	EN ISO 178	MPa	2200 ± 250
Flexural strength at breakage	EN ISO 178	%	1,00 ± 0,02
Tensile strength	EN ISO 527	MPa	-
Elongation	EN ISO 527	%	-
Compressive strength	EN ISO 604	MPa	29 ± 3
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	2 ± 0,2
Heat resistance (Martens)	DIN 53458	°C	65 ± 2
TG in TMA T _G	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore D	74 ± 2
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	-

Sales units (packages)

Units	Comp. A	HFG	7,500 kg / 15,000 kg / 20,000 kg
	Hardener	PUR 11 Comp. B	1,000 kg / 5,000 kg / 50,000 kg

Processing instructions

Material- and working- temperature: between 18 - 25 °C.

Close containers after use.

Seal porous mould surfaces first (**ebalta** mould sealer).

For optimum mould releasing we recommend a special release agent (like T1-1), which can be applied easily with a brush or be sprayed. Releasing of the mould 2-3 times, evaporate for about 20 min. after each releasing.

Mixing ratio resin/hardener according to instructions.

Stirring rods etc. with residual resin can be easily cleaned with **ebalta** cleaning agent.

1. brush gel coat, e.g. OH 11
2. Gelling of surface
3. Brush gel coat together with chopped glass strand
4. Cast comp. B into comp. A
5. Stir with spiralmixer
6. Cast immediately

In General

ebalta HFG is a light filled 2-components-polyurethane casting compound, which cures fast at room temperature. After curing this material is dimensional accurate light weight but anyway resistant, which is especially suitable for big volume backfilling of coreboxes and negative moulds.

Storing

At appropriate storage (18 - 25 °C) in closed original container 6 months.

Already opened containers should be closed immediately after use and be protected against moisture. This material should be used up as soon as possible.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste.

Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.

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