

Basis	<b>polyurethane blockmaterial</b>
Colour	beige
Further colours	yellow

### Applications

- Moulding tools
- jig
- Mould constructions
- Foundry pattern

### Properties

- low thermal expansion
- high heat resistance
- big volume blocks available
- well workable

### Processing data

<b>Product</b>	<b>ebablock® 1820</b>	
Colour	beige	
Density at 20°C	g / cm <sup>3</sup>	1,60 ± 0,03

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	72 ± 5
Flexural strength at breakage	EN ISO 178	%	0,76 ± 0,02
Flexural modulus	EN ISO 178	MPa	11000 ± 400
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	4 ± 0,5
Compressive strength	EN ISO 604	MPa	106 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	90 ± 5
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion 20 - 50 °C	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	ca. 53
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	ca. 208

### Sales units (packages)

**ebablock® 1820**

block material, dimensions variable

## Processing instructions

Advices for machining of block material

- Making even of milling support
- Roughing of geometry
- Removing of clamps, if possible over night
- Clamping
- Finishing

Milling parameters available.

## In General

**ebablock®** material is available as rough boards and blocks:

Advantages:

- Dense structure
- Jointless
- Low-stress
- Close to contour and variable measurements

Please take dimensional allowances into consideration regarding sizes of rough blocks and boards. We recommend an addition of 10 mm per dimension.

Dimensional tolerance of 1 % possible.

During casting of a block/blank voids or colour shades may occur. Therefore we can not give any guarantee, that the block/blank is completely free from bubbles. In case of a casting thickness over 250 mm or complex contours we reserve the right to cast in parts. Colour shades, bubbles and parting lines are not considered as inferior quality.

"VP"-products are experimental products.  
Slight changes regarding technical data are still possible.

## Safety measure

**ebablock®** material is a cured filled polyaddition product, no hazardous dusts when grinding. Anyway the quantity of dusts coming from mechanical treatment of wood and metal 6 mg/m<sup>3</sup> (MAC-value)- must not be exceeded.

According to regulations for hazardous products all **ebablock®** products are not to be marked for transport and storage. Please follow safety advices !

## Waste Disposal

Small quantities can be disposed as domestic waste. For big quantities please contact your local authorities. In case of further questions please do not hesitate to contact our department for product safety.