

Basis	<b>ebablock® M 04</b>
Colour	yellow

Applications	Properties
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| <ul style="list-style-type: none"> <li>• Core boxes</li> <li>• Foundry patterns</li> <li>• Pattern plates</li> </ul> | <ul style="list-style-type: none"> <li>• high abrasion resistance</li> <li>• very good edge strength</li> <li>• very shock resistant</li> <li>• dense surface</li> <li>• well workable</li> </ul> |
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Processing data
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<b>Product</b>	<b>ebablock® M 04</b>		
Colour	yellow		
Density at 20°C	g / cm <sup>3</sup>	1,20 ± 0,02	

Physical data
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Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	120 ± 5
Flexural modulus	EN ISO 178	MPa	2950 ± 300
Flexural strength at breakage	EN ISO 178	%	6,9 ± 0,5
Tensile strength	EN ISO 527	MPa	-
Elongation	EN ISO 527	%	-
Compressive strength	EN ISO 604	MPa	90 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	66 ± 9
Heat resistance (HDT)	DIN EN ISO 75 B	°C	87 ± 3
Shore hardness	DIN 53505	Shore D	84 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	ca. 77
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 105

Sales units (packages)
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<p><b>ebablock® M 04</b></p>	<p>Block material, dimensions variable</p> <p>board material, ebaboard M 04</p> <p>1000 x 500 x 50 mm</p> <p>1000 x 500 x 75 mm</p> <p>1000 x 500 x 100 mm</p> <p>1500 x 400 x 50 mm</p> <p>1500 x 400 x 100 mm</p>
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## Processing instructions

**ebablock® M 04** is a wear resistant, synthetic material on polyurethane base. The material contains no halogen, softener and solvents.

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 are available.

The gluing of **ebablock® M 04** is made with our "adhesive for modelboards".

## In General

Products with VP in the name are experimental products.  
Small changes regarding technical data are still possible.

**ebablock®** material is available in unworked boards and rough blocks:

Advantages:

- Dense structure
- Jointless
- Low-stress
- Close to contour and variable delivery sizes

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 1-2% is 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 **ebaboard** 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, contact your local authorities, please.

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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