

Basis	Wear resistant PU-gelcoat
Resin	OH 11 Comp. A
Hardener	PUR 3 Comp. B
Colour	oxyde red

Applications

- Foundry patterns
- Core boxes

Properties

- abrasion resistant
- impact resistant
- excellent demoulding from mould and core sand properties
- polyurethane-based

Processing data

Product		Mixture OH 11 / PUR 3	Resin OH 11 Comp. A	Hardener PUR 3 Comp. B
Colour		oxyde red	oxyde red	brown
Mixing ratio	p. b. w.		100	40
Viscosity at 25°C	mPas	thixotrope	thixotrope	thixotrope
Density at 20°C	g / cm ³	1,27 ± 0,02	1,30 ± 0,02	1,24 ± 0,02
Pot life 200 g / 20°C	min.	20 - 25	-	-
Curing time at RT	hrs.	3 - 5	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	65 ± 5
Flexural strength at breakage	EN ISO 178	%	3,5 ± 0,3
Flexural modulus	EN ISO 178	MPa	3568 ± 250
Tensile strength	EN ISO 527	MPa	-
Tensile strength / test piece type 2	ISO 37	MPa	-
Elongation at break	ISO 37	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	8,6 ± 1
Compressive strength	EN ISO 604	MPa	75 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	70 ± 2
Glass transition temperature TG	methode DSC	°C	-
Shore hardness	DIN 53505	Shore D	86 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 233
Abrasion Taber Abraser H 18 Application weight 500g / 250 Rotations	internal	mg	ca. 135

Sales units (packages)

Packing size A-Pack OH 11 / PUR 3 resin 12 x 0,250 kg / hardener 12 x 0,100 kg = 4,200 kg

Processing instructions

The temperature of material and processing should be between 18 and 25° C.

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before (**ebalta** sealant).

For an optimum mould release we recommend a suitable release agent (e.g. T 1-1) which can be easily applied with a brush.

The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

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

In General

OH 11 is available in 3 different variances:

ebalta OH 11 is abrasion- and impact- resistant.

ebalta OH 11-hard is even more wear resistant and harder

ebalta OH 11-steel has a good surface slip and together with GM 708 and steel granules it is used for production of metal sheet shaping moulds.

Due to its thixotropic consistency the resin/hardener mixture can be easily applied without any bubbles with a short-haired brush in a layer of 1-3 mm. No sagging at edges, corners and vertical surfaces.

For backfilling of OH 11 the thick castable polyurethane cast resin GM 725-7 is most suitable. If requested plastic granules can be added to GM 725-7.

A coupling paste is not necessary.

Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Shelf life is indicated on the labels.

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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