

Basis	thin liquid, universal gelcoat
Resin	OH 25
Hardener	SR
Colour	green

## Applications

- Negatives
- Foundry patterns
- Boards
- Pattern plates
- Core boxes
- Jigs
- Bedding-down models
- Coping models
- Master models

## Properties

- very good spreadable
- impact resistant surface
- easy to grind

## Processing data

Product		Mixture OH 25 / SR	Resin OH 25	Hardener SR
Colour		green	green	amber
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>12,5</b>
Viscosity at 25°C	mPas	thixotrop	pastös	1650 ± 50
Density at 20°C	g / cm <sup>3</sup>	1,65 ± 0,05	1,72 ± 0,05	1,07 ± 0,02
Pot life 200 g / 20°C	min.	10 - 15	-	-
Curing time at RT	hrs.	3 - 5	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	90 ± 9
Flexural modulus	EN ISO 178	MPa	5250 ± 400
Flexural strength at breakage	EN ISO 178	%	1,9 ± 0,25
Tensile strength	EN ISO 527	MPa	-
Elongation at break	ISO 37	%	-
Compressive strength	EN ISO 604	MPa	108 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	8,5 ± 2
Heat resistance (Martens)	DIN 53458	°C	75 ± 3
Shore hardness	DIN 53505	Shore D	90 ± 2
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-

## Sales units (packages)

Packing size      A-Pack      OH 25 / SR      12 x 0,325 kg resin / 12 x 0,040 kg hardener = 4,380 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.

## Storing

Storage at room temperature 18-25 °C.

Already opened containers should be closed immediately after use and should be used as soon as possible.

Information about the expiration date you find on the sales packages.

## 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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