

Basis	Heat resistant gelcoat
Resin	OH 3-1
Hardener	CH-1
Colour	yellow
Further hardeners	PO / CH-2

### Applications

- Polyester tools
- PU-foaming tools
- RIM

### Properties

- heat resistant
- chemical resistant
- resistant against solvent
- good grinding
- polishable

### Processing data

Product		Mixture OH 3-1 / CH-1	Resin OH 3-1	Hardener CH-1
Colour		yellow	yellow	yellow transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>18</b>
Viscosity at 25°C	mPas	thixotrop	thixotrop	3500 ± 500
Density at 20°C	g / cm <sup>3</sup>	1,44 ± 0,05	1,50 ± 0,05	1,08 ± 0,02
Pot life 200 g / 20°C	min.	15 - 20	-	-
Curing time at RT	hrs.	20 - 22	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	120 ± 10
Flexural modulus	EN ISO 178	MPa	6500 ± 500
Flexural strength at breakage	EN ISO 178	%	2,20 ± 0,15
Tensile strength	EN ISO 527	MPa	-
Compressive strength	EN ISO 604	MPa	135 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	11 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	104 ± 3
Shore hardness	DIN 53505	Shore D	92 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-

### Sales units (packages)

Packing size      A-pack      OH 3-1 / CH-1      resin 12 x 0,400 kg / hardener 12 x 0,072 kg = 5,664 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

Optimum chemical resistance, e.g. compared to styrol is reached after 12 hrs. postcuring at 60 °C. Apply with a short haired brush or spatula.

In case of applying more layers, don't exceed maximum waiting time of 60 min.

## Storing

Storage at room temperature (18-25 °C) in closed original container 6 months.

Already opened containers should be closed immediately after use and should be used 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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