

Basis	polishable gelcoat
Resin	OH 35
Hardener	HM
Colour	black

Applications

- PU-foaming tools
- RIM foam tools
- Polyester press moulds
- Prepreg tools
- Adhesive probes
- Vacuum forming tools

Properties

- chemical resistant
- dense surface
- polishable
- grinding possible
- heat resistant

Processing data

Product		Mixture OH 35 / HM	Resin OH 35	Hardener HM
Colour		black	black	amber
Mixing ratio	p. b. w.		100	14
Viscosity at 25°C	mPas	thixotrop	thixotrop	2000 ± 500
Density at 20°C	g / cm ³	1,60 ± 0,05	1,70 ± 0,05	1,03 ± 0,02
Pot life 200 g / 20°C	min.	20 - 30	-	-
Curing time at RT	hrs.	16 - 24	-	-
Post curing	Time in h/ Temperature in °C	6 / 60 4 / 80 4 / 120	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	80 ± 5
Flexural strength at breakage	EN ISO 178	%	2,7 ± 0,3
Flexural modulus	EN ISO 178	MPa	4500 ± 500
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	12 ± 2
Compressive strength	EN ISO 604	MPa	125 ± 10
Heat resistance (HDT)	DIN EN ISO 75 B	°C	143 ± 5
Glass transition temperature TG	methode DSC	°C	122
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Packing size	A-Pack	OH 35 / HM	resin 12 x 0,400 kg / hardener 12 x 0,056 kg = 5,472 kg
Units	resin	OH 35	6,000 kg / 20,000 kg
	hardener	HM	1 kg / 5 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.

When you apply the second layer of gelcoat or the reinforcement the gelcoat has to be still tacky.

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.

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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