

Basis **Abrasion resistant gelcoat**
 Resin **OH 48 Comp. A (Amin)**
 Hardener **OH 48 Comp. B (Iso)**

Colour green
 Further colours beige

Applications

- Core boxes
- Foundry patterns
- Pattern plates
- fixtures
- Hammer form tools

Properties

- non-toxic according to regulations for hazardous material
- very abrasion resistant
- hard elastomeric
- Shore D hardness approx. 65
- no brittleness phase

Processing data

Product		Mixture OH 48 / Comp. A+B	Resin OH 48 Comp. A (Amin)	Hardener OH 48 Comp. B (Iso)
Colour		green	green	milky filmy
Mixing ratio	p. b. w.		100	75
Viscosity at 25°C	mPas	thixotrop	pastös	pastös
Density at 20°C	g / cm ³	1,12 ± 0,02	1,12 ± 0,02	1,12 ± 0,02
Pot life 100 g / 20°C	min.	25 - 30	-	-
Curing time at RT	hrs.	20 - 24	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	25 ± 2
Flexural enlongation at flexural strength	EN ISO 178	%	7,2 ± 0,3
Flexural modulus	EN ISO 178	MPa	730 ± 50
Tensile strength / test piece type 2	ISO 37	MPa	26 ± 2
Elongation at break / test piece type 2	ISO 37	%	200 ± 30
Shore hardness	DIN 53505	Shore D	65 ± 3
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 35
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 35

Sales units (packages)

Packing size	A-Pack	OH 48 / Comp. A+B	Resin 6 x 0,200 kg / Hardener 6 x 0,150 kg = 2,100 kg
Units	Comp. A	OH 48 Comp. A (Amin)	5,000 kg
	Comp. B	OH 48 Comp. B (Iso)	3,750 kg

Processing instructions

Material- and processing temperature between 18 and 25° C.

Close containers after use.

Seal porous mould surfaces first (**ebalta** mould sealer).

For optimum mould releasing we recommend a special release agent (like T1-1), which can be applied easily with a brush or be sprayed. Releasing of the mould 2-3 times, evaporate for about 20 min. after each releasing.

Mixing ratio resin/hardener according to instructions!

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

At room temperature workable after about 1,5 hours.

In General

ebalta OH 48 is a very hard elastic polyurethane gelcoat, curing at room temperature. The hard- elastic consistency leads to an extremely good abrasion- and impact -resistance as well as to good dissolving power of mould- and coresand.

For backfilling of OH 48 the slowly curing polyurethane material GM 725-7/PUR 4 is most suitable.

An optimal adhesion on PU-resins can be achieved by laying up the coupling paste KP 8.

For optimum bonding of the epoxy resin or of laminating paste, apply coupling paste KP 6/BR wet-in-wet or within 30 min.

This product is not colour stable, possibly yellowing. This doesn't have any influence on properties.

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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