

Basis	Seamless modelling paste
Resin	P 27 resin
Hardener	P 27 hardener
Colour	grey

Applications

- Moulds for low temperature prepregs
- Vacuum infusion tools
- Vacuum thermoforming tools

Properties

- jointless surface
- high heat resistance
- 15 - 30 mm layer possible in one step
- dense surface
- fine structure
- very well workable
- dimensionally stable
- no sagging at vertical surfaces

Processing data

Product		Mixture P 27 /resin+hardener	Resin P 27 resin	Hardener P 27 hardener
Colour		grey	dark-grey	beige
Mixing ratio	p. b. w.		100	50
Viscosity at 25°C	mPas	thixotrope	thixotrope	thixotrope
Density at 20°C	g / cm ³	1,0 ± 0,03	1,0 ± 0,03	0,98 ± 0,03
Pot life 500 g / 20°C	min.	45 - 60	-	-
Post curing	Time in h/ Temperature in °C	4 / 60 16 / 80	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	35 ± 1,7
Flexural modulus	EN ISO 178	MPa	2308 ± 207
Flexural strength at breakage	EN ISO 178	%	2,3 ± 0,2
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	4 ± 0,3
Compressive strength	EN ISO 604	MPa	34 ± 0,5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	86 ± 3
TG in TMA T _g	Methode TMA	°C	90 ± 3
Shore hardness	DIN 53505	Shore D	70
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	50 - 52
Linear shrinkage	internal	%	approx. 0,26

Sales units (packages)

Units	resin	P 27 resin	40 kg
	hardener	P 27 hardener	40 kg

Processing instructions

Processing only by means of standard two-components machines for applying pastes.

Before processing make sure that the base construction is solid, stable and dustfree.

Material-, processing- and supporting frame-temperature between 19 - 24 °C.

Final properties are achieved after post curing. Post curing 24 hrs. after application of the paste for 24 hrs. at 60°C + for 16 hrs. at 80°C.

Machining of the surface after post curing.

As base construction we recommend our **ebazell 80**, **ebazell 260**, **ebaboard L** or **ebaboard 60** material. Furthermore pasting on aluminium/honeycomb panels possible.

The lines flow into each other, no sagging of the 15 - 30 mm layers at vertical surfaces. P 27 can be processed head first.

1) Output

Depending on the contour and surface the output is between 1.5 liters and 2.25 liters.

2) Spindle speed of mixer

Employment of a dynamic, static mixer, according to output volume the spindle speed is between 2900 speed/min and 3250 speed/min

3) Pre-pressure on follower plate

Pressure not more than 3.5 bar

4) Operating pressure

Pressure inside the pipes not more than 20 bar for 2.25 litres output. Otherwise unintentional cross-section reduction might arise

5) Temperature

The processing temperature for the paste is 19-24°C. Temperature at the end of the output tube must not exceed 27°C.

6) Layer Thickness

Material can be applied in a layer of 15 - 30 mm. All layers must be even, apply paste in corners radius-shaped.

Attention: material accumulations! Uneven layer thicknesses and material accumulations lead to cracks.

7) Evacuation in case of change of container

When using new material, take care that there are'nt any air entrapments between the container and the follower plate.

For this purpose we recommend to discharge 750 ml of the material directly at the follower plate as well as behind the pump in each case. Only when having uniform material flow you can continue application of the paste.

8) Mixing faults

Do not mix any material residues with the new material since this leads to uncontrolled air entrapments which cannot be removed by evacuation. Moreover this will cause faulty mixtures.

Avoid frequent switch on-switch off (start/stop) of the machine.

In General

Storing

At appropriate storage 18-25°C.

Occuring crystallization due to disadvantageous storage conditions can be made return by warming up the material at approx. 60° C.

Opened containers should be closed immediately after use and be protected against moisture. This material 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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