

Basis	low friction gel coat
Resin	OH 11 - Stahl new Comp. A
Hardener	PUR 3 Comp. B
Colour	oxyde red

### Applications

- Sheet metal forming
- Mould constructions
- Foundry patterns
- Core boxes
- Pattern plates

### Properties

- good surface slip
- wear resistant
- impact resistant
- excellent demoulding from mould and core sand properties
- polyurethane-based

### Processing data

Product		Mixture OH 11 - Steel new / PUR 3	Resin OH 11 - Stahl new Comp. A	Hardener PUR 3 Comp. B
Colour		oxyde red	oxyde red	brown
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>20</b>
Viscosity at 25°C	mPas	thixotrop	thixotrop	thixotrope
Density at 20°C	g / cm <sup>3</sup>	1,60 ± 0,05	1,70 ± 0,05	1,24 ± 0,02
Pot life 200 g / 20°C	min.	20 - 25	-	-
Curing time at RT	hrs.	3 - 5	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	60 ± 5
Flexural modulus	EN ISO 178	MPa	3750 ± 350
Flexural strength at breakage	EN ISO 178	%	3,0 ± 0,2
Tensile strength	EN ISO 527	MPa	-
Tensile strength / test piece type 2	ISO 37	MPa	-
Elongation at break	ISO 37	%	-
Compressive strength	EN ISO 604	MPa	55 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	8 ± 1
Heat resistance (HDT)	DIN EN ISO 75 B	°C	68 ± 2
Glass transition temperature TG	methode DSC	°C	-
Shore hardness	DIN 53505	Shore D	85 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-
Abrasion Taber Abraser H 18 Application weight 500g / 250 Rotations	internal	mg	ca. 120

### Sales units (packages)

Packing size      A-Pack      OH 11 - Steel new / PUR 3      resin 12 x 0,500 kg / hardener 12 x 0,100 kg = 7,200 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

OH 11 is available in 3 different variances:

**ebalta** OH 11 new is abrasion- and impact- resistant.

**ebalta** OH 11-hard new is even more wear resistant and harder

**ebalta** OH 11-steel new has a good surface slip and together with GM 708 and steel granules it is used for production of metal sheet shaping moulds.

Due to its thixotropic consistency the resin/hardener mixture can be easily applied without any bubbles with a short-haired brush in a layer of 1-3 mm. No sagging at edges, corners and vertical surfaces.

## 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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