

Basis	Gel coat with sliding ability
Resin	OH 12-G
Hardener	AG
Colour	beige

Applications

- Moulding tools for aluminium sheet forming
- Jigs

Properties

- good surface slip
- resistant
- abrasion resistant

Processing data

Product		Mixture OH 12-G / AG	Resin OH 12-G	Hardener AG
Colour		beige	white	yellow - brown
Mixing ratio	p. b. w.		100	15
Viscosity at 25°C	mPas	thixotrop	thixotrop	thixotrope
Density at 20°C	g / cm ³	1,25 ± 0,05	1,30 ± 0,05	1,08 ± 0,02
Pot life 200 g / 20°C	min.	20 - 25	-	-
Curing time at RT	hrs.	8 - 12	-	-
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	1700 ± 150
Flexural strength at breakage	EN ISO 178	%	8,5 ± 0,5
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	38 ± 3
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	31 ± 5
Heat resistance (Martens)	DIN 53458	°C	41 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	-
Shore hardness	DIN 53505	Shore D	77 ± 2
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Packing size	A-Pack	OH 12-G / AG	resin 12 x 0,290 kg / hardener 12 x 0,043 kg = 3,996 kg
Units	Resin	OH 12-G	5,000 kg
	Hardener	AG	0,900 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

ebalta OH 12-G/AG is a thixotropic epoxy gelcoat, curing at room temperature, the material is very impact resistant and durable.

Due to its thixotropic consistency the resin/hardener mixture can easily be applied without any bubbles with a short-haired brush in a layer of 1-2 mm, no sagging at corners, edges and vertical surfaces.

Due to its good surface slip, OH 12-G is especially used as gel coat for moulds to shape aluminium sheets.

Application of OH 12-G from temperatures between -25°C to +60°C.

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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