

Basis	Hard flexible, very abrasion resistant gelcoat
Resin	OH 16 Comp. A
Hardener	OH 16 Comp. B
Colour	light green

Applications

- Core boxes
- Hammer form tools
- Jigs

Properties

- very abrasion resistant
- hard flexible
- very shock resistant
- excellent demoulding from mould and core sand properties

Processing data

Product		Mixture OH 16 / Comp. A+B	Resin OH 16 Comp. A	Hardener OH 16 Comp. B
Colour		light green	whitish transparent	light green
Mixing ratio	p. b. w.		100	70
Viscosity at 25°C	mPas	thixotrope	pasty	pasty
Density at 20°C	g / cm ³	1,12 ± 0,02	1,10 ± 0,02	1,12 ± 0,02
Pot life 200 g / 20°C	min.	10 - 15	-	-
Curing time at RT	hrs.	6 - 8	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural modulus	EN ISO 178	MPa	-
Flexural strength at breakage	EN ISO 178	%	-
Tensile strength	EN ISO 527	MPa	23 ± 4
Tensile strength / test piece type 2	ISO 37	MPa	-
Elongation at break	ISO 37	%	170 ± 20
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	n. a.
Heat resistance (Martens)	DIN 53458	°C	n. a.
Heat resistance (HDT)	DIN EN ISO 75 B	°C	-
Glass transition temperature TG	methode DSC	°C	-
Shore hardness	DIN 53505	Shore D	58 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 19

Sales units (packages)

Packing size	A - Pack	OH 16 / Comp. A+B	Resin 8 x 0,200 kg / Hardener 8 x 0,140 kg = 2,720 kg
Units	Resin	OH 16 Comp. A	5,000 kg
	Hardener	OH 16 Comp. B	3,500 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.

The mixture is thixotropic which means no sagging at edges, corners and vertical surfaces, when applied with a short-haired brush in a layer not thicker than 1 mm.

A second layer can be applied after about 30 - 40 minutes.

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 16 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 16 the thick castable polyurethane cast resin GH 708 with filler F-B is most suitable. A coupling paste is not necessary. A good adhesion between the layers of OH 16 and GM 708 is reached if the resin is casted after about 1 hour.

The backfilling can nevertheless also be with epoxy resin systems and a coupling paste for example KP 6/TGL.

Depending on the cast thickness, demoulding can be made after 6-8 hrs. Before use of the moulds, the material should be cured some days at room temperature or postcured for 8 hrs. at 50-60°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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