

|          |  |
|----------|--|
| Basis    | Very hard-flexible, abrasion resistant gelcoat |
| Resin    | OH 17 Comp. A                                  |
| Hardener | OH 17 Comp. B                                  |
| Colour   | white  |

## Applications

- Pattern plates
- Foundry patterns
- Hammer form tools
- Jigs

## Properties

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

## Processing data

| Product               |                     | Mixture<br>OH 17 / Comp. A+B | Resin<br>OH 17 Comp. A | Hardener<br>OH 17 Comp. B |
|-----------------------|---------------------|------------------------------|------------------------|---------------------------|
| Colour                |                     | white                        | whitish transparent    | creme                     |
| <b>Mixing ratio</b>   | <b>p. b. w.</b>     |                              | <b>100</b>             | <b>45</b>                 |
| Viscosity at 25°C     | mPas                | thixotrope                   | pasty                  | pasty                     |
| Density at 20°C       | g / cm <sup>3</sup> | 1,18 ± 0,02                  | 1,10 ± 0,02            | 1,30 ± 0,02               |
| Pot life 200 g / 20°C | min.                | 10 - 15                      | -                      | -                         |
| Curing time at RT     | hrs.                | 8 - 10                       | -                      | -                         |

## 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                              | 34 ± 5   |
| Tensile strength / test piece type 2                                   | ISO 37             | MPa                              | -        |
| Elongation at break  | ISO 37             | %                                | 220 ± 20 |
| Compressive strength   | EN ISO 604         | MPa                              | -        |
| Impact resistance (Charpy)   | EN ISO 179         | kJ/m <sup>2</sup>                | -        |
| Heat resistance (Martens)  | DIN 53458          | °C                               | -        |
| Heat resistance (HDT)  | DIN EN ISO 75 B    | °C                               | -        |
| Glass transition temperature TG  | methode DSC        | °C                               | -        |
| Shore hardness   | DIN 53505          | Shore D                          | 64 ± 3   |
| Coefficient of linear expansion  | DIN 53752          | 10 <sup>-6</sup> K <sup>-1</sup> |          |
| Abrasion Taber Abraser H 18<br>Application weight 500g / 500 Rotations | internal           | mg                               | ca. 18   |

## Sales units (packages)

|              |          |                   |  |
|--------------|----------|-------------------|--|
| Packing size | A - Pack | OH 17 / Comp. A+B | Resin 12 x 0,200 kg /Hardener 12 x 0,090 kg = 3,480 kg |
| Units        | Resin    | OH 17 Comp. A     | 5,000 kg   |
|              | Hardener | OH 17 Comp. B     | 2,250 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 90 - 120 minutes.

Don't apply before since the first layer might be shifted.

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 17 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 17 the thick castable HFG and HFG plus as well as the slowly curing polyurethane material GM 725-7 are most suitable.

After applying the second layer the back filling should be casted wet-in wet. The backfilling can also be made with epoxy resins and a coupling layer.

Depending on the cast thickness, demoulding can be made after 8-10 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.