

Basis	Abrasion resistant gelcoat
Resin	OH 47 Comp. A
Hardener	OH 47 Comp. B
Colour	white

Applications

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

Properties

- very abrasion resistant
- hard elastomeric
- very shock resistant
- non-toxic according to regulations for hazardous material

Processing data

Product		Mixture OH 47 / Comp. A+B	Resin OH 47 Comp. A	Hardener OH 47 Comp. B
Colour		white	milky filmy	white
Mixing ratio	p. b. w.		100	41
Viscosity at 25°C	mPas	thixotrope	pasty	pasty
Density at 20°C	g / cm ³	1,10 ± 0,02	1,10 ± 0,02	1,12 ± 0,02
Pot life 200 g / 20°C	min.	14 - 20	-	-
Curing time at RT	hrs.	8 - 10	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

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	-
Tensile strength / test piece type 2	ISO 37	MPa	20 ± 2
Elongation at break	ISO 37	%	200 ± 30
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
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 ⁻⁶ K ⁻¹	-
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 22

Sales units (packages)

Packing size A-Pack OH 47 / Comp. A+B resin 12 x 0,200 kg / hardener 12 x 0,082 kg = 3,384 kg

Processing instructions

Material- and processing temperature between 18 and 25° C.

Close containers after use.

Seal porous mould surfaces first (**ebalta** mould sealer).

For optimum mould releasing we recommend a special release agent (like T1-1), which can be applied easily with a brush or be sprayed. Releasing of the mould 2-3 times, evaporate for about 20 min. after each releasing.

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 50 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 47 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 47 the slowly curing polyurethane material GM 725-7/PUR 4 are most suitable.

In order to get optimum bonding of the intermediate coating, after application of the second surface layer we recommend to cast the backfilling within 4 hrs.

In case of covered back casting we recommend to cast only after 3-4 hrs.

For optimum bonding of the epoxy resin or of laminating paste, apply coupling paste KP 6/TGL wet-in-wet or within 30 min.

This product is not colour stable, possibly yellowing. This doesn't have any influence on properties.

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.

ebalta Kunststoff GmbH . Erlbacher Straße 100 . 91541 Rothenburg ob der Tauber / Germany
Tel.: +49 9861 7007-0 . Fax: +49 9861 7007-77 . info@**ebalta**.de . www.**ebalta**.de