

Basis	<b>ebaboard PW 920</b>
Colour	green

### Application

- foundry pattern
- Core boxes
- Pattern plates
- Jigs
- bath models for galvanic tools
- Construction- and maintenance gauges

### Properties

- very well workable (contains no abrasive fillers)
- good edge strength
- high quality surface
- dense surface
- high impact strength
- no generation of dust during machining

### Working data

<b>Product</b>	<b>ebaboard PW 920</b>	
Colour	green	
Density at 20°C	g / cm <sup>3</sup>	1,21 ± 0,05

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	72 ± 5
Flexural modulus	EN ISO 178	MPa	1807 ± 150
Flexural strain at breakage	EN ISO 178	%	7,5 ± 0,5
Tensile strength	EN ISO 527	MPa	44 ± 5
Elongation at break	ISO 37	%	11 ± 3
Compressive strength	EN ISO 604	MPa	56 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	25 ± 3
Heat resistance (Martens)	DIN 53458	°C	62 ± 2
Heat resistance	-	°C	95 ± 5
Shore hardness	DIN 53505	Shore D	79 ± 2
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	ca. 109
Abrasion Taber Abraser CS 17 Application weight 500g / 1000 Rotations	internal	mg	ca. 26
Abrasion Taber Abraser H 18 Application weight 500g / 250 Rotations	internal	mg	ca. 101

### Sales units (packages)

<b>ebaboard PW 920</b>	1000 x 500 x 30 mm •
	1000 x 500 x 50 mm •
	1000 x 500 x 75 mm •
	1000 x 500 x 100 mm

## Processing instructions

Advices for machining of board material.

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- -Making even of milling support.
- -Roughing of geometry.
- -Removing of clamps, if possible over night.
- -Clamping.
- -Finishing.
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The gluing of the board material is made with our „adhesive for board material“.

The glued parts are easily fixed by clamps or by weight.

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- Milling parameter are available.

## In General

**ebaboard** material is available in specified sizes. The surface is machined on all sides. **ebaboard** is a synthetic, post-cured board material on polyurethane base. It has an even structure and plane parallel machined surfaces.

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Advantages:

- Dense structure.
- Good edge strength.
- Low tension.
- Good workability.
- Low dust development when milling.
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- Dimensional tolerance of 1-2 % is possible.
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• "VP"-products are experimental products.

• Regarding technical data slight modifications are possible.

## Safety measure

**ebaboard** material is a cured filled polyaddition product, no hazardous dusts when grinding.

• Anyway the quantity of dusts coming from mechanical treatment of wood and metal 6 mg/m<sup>3</sup> (MAC-value)- must not be exceeded.

• According to regulations for hazardous goods **ebaboard** products don't have to be marked during transport and storage.

• 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

Small quantities can be disposed as domestic waste. For big quantities, contact your local authorities, please.

• 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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