Technical Datasheet

OH 38 / SR

Basis	**polishable, heat resistant gelcoat**
Resin	**OH 38**
Hardener	**SR**
Colour	alu grey
Further hardeners	**CH-1**

Applications

- Vacuum forming tools
- PU-foaming tools
- Prepreg tool
- Adhesive probes

Properties

- easy to grind
- aluminium-like
- polishable
- dense surface
- good heat resistance

Processing data

Product		**Mixture OH 38 / SR**	**Resin OH 38**	**Hardener SR**
Colour		alu grey	alu grey	amber
Mixing ratio	**p. b. w.**		**100**	**12**
Viscosity at 25°C	mPas	thixotrop	thixotrope	1650 ± 50
Density at 20°C	g / cm^3	1,60 ± 0,05	1,65 ± 0,05	1,07 ± 0,02
Pot life 200 g / 20°C	min.	20 - 30	-	-
Curing time at RT	hrs.	16 - 24	-	-
Post curing	Time in h/ Temperature in °C	10 - 12 / 60 - 80	-	-

Physical data

Properties	**Inspect. requirem.**	**Unit**	**Value**
Flexural strength	EN ISO 178	MPa	95 ± 5
Flexural modulus	EN ISO 178	MPa	7000 ± 500
Flexural strength at breakage	EN ISO 178	%	2,0 ± 0,2
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	110 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m^2	14,5 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	99 ± 3
Glass transition temperature TG	methode DSC	°C	-
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	$10^{-6}K^{-1}$	ca. 50

Sales units (packages)

Packing size	A-Pack	OH 38 / SR	Resin 12 x 0,400 kg / Harder 12 x 0,048 kg = 5,376 kg
Units	resin	OH 38	6,000 kg / 20,000 kg
	Hardener	SR	1,000 kg / 5,000 kg / 50,000 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 38 is an epoxy gelcoat curing at room temperature with almost no shrinkage, yielding a polishable very dense surface with aluminium-like characteristics.

Due to its thixotropic consistency the resin/hardener mixture can be easily applied without any bubbles with a short-haired brush in a layer of 1 mm. No sagging at edges, corners and vertical surfaces.
Apply two layers, the second one about 60 min. after the first one.

We recommend postcuring for 10-12 hrs. at 60-80°C for long potlife and good heat resistance.

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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