

Basis	Universal gelcoat
Resin	OH 4
Hardener	SR
Colour	white
Further colours	blue
Further hardeners	SL

Applications

- Negatives
- Master models
- Jigs
- Foundry patterns

Properties

- versatile
- very good spreadable
- easy to grind
- impact resistant surface

Processing data

Product		Mixture OH 4 / SR	Resin OH 4	Hardener SR
Colour		white	white	amber
Mixing ratio	p. b. w.		100	12,5
Viscosity at 25°C	mPas	thixotrope	pasty	1650 ± 50
Density at 20°C	g / cm ³	1,4 ± 0,05	1,45 ± 0,02	1,07 ± 0,02
Pot life 200 g / 20°C	min.	15 - 20	-	-
Curing time at RT	hrs.	3 - 5	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	95 ± 5
Flexural modulus	EN ISO 178	MPa	4815 ± 300
Flexural strength at breakage	EN ISO 178	%	2,4 ± 0,3
Tensile strength	EN ISO 527	MPa	-
Compressive strength	EN ISO 604	MPa	100 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	10 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	82 ± 3
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Packing size A - Pack OH 4 / SR Resin 12 x 0,325 kg + Hardener 12 x 0,040 kg = 4,380 kg

Units Resin OH 4 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 4 is a very well spreadable epoxy gelcoat, curing at room temperature with almost no shrinkage.

Due to its thixotropic, but soft consistency, the resin/hardener mixture can be applied without any bubbles with a short-haired brush in a 1-3 mm layer. No sagging at edges, corners or at vertical surfaces. For this reason thicker layers can be applied which in general cannot easily be made in one step.

After curing the gelcoat is not brittle, the surface is well polishable.

With **ebalta** OH 4 /SR you get a hard surface. The short potlife leads to rapid gelling and further working on.

With **ebalta** OH 4/SL the surface shows more impact resistance with a longer potlife, which is especially suitable for big surfaces.

As coupling paste for the rear construction we recommend coupling paste KP 6/TGL.

Storing

Storage at room temperature (18-25 °C) in closed original container 12 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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