

Basis	ebablock® 1400
Colour	blue

Applications

- Foundry patterns
- Core boxes
- Pattern plates

Properties

- low coefficient of thermal expansion
- high abrasion resistance
- fine structure
- easy to work

Processing data

Product	ebablock® 1400		
Colour	blue		
Density at 20°C	g / cm ³	1,38 ± 0,03	

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	109 ± 5
Flexural elongation at break	EN ISO 178	%	3,8 ± 0,15
Flexural modulus	EN ISO 178	MPa	4175 ± 100
Tensile strength	EN ISO 527-1	MPa	-
Elongation	EN ISO 527-1	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	19,5 ± 2
Compressive strength	EN ISO 604	MPa	102 ± 5
Shore hardness	DIN ISO 7619-1	Shore D	85 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	87 ± 2
coefficient of linear expansion 20 - 50 °C	internatl test / Dilatometer	10 ⁻⁶ K ⁻¹	ca. 69
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 99
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 62

Sales units (packages)

ebablock® 1400

Block material, dimensions variable
board material, ebaboard 1400
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

Advice for machining of block material

- Making even of milling support
- Roughing of geometry
- Removing of clamps, if possible over night
- Clamping
- Finishing

For bonding and repairing we recommend our adhesive blue as well as our repair putty blue.

The repair putty can also be used as fast adhesive and can be mixed individually with the adhesive following the indications of a mixing table in order to set up the pot-life.

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

Milling parameter completed for download on our homepage.

In General

ebablock® material is available as rough boards and blocks:

Advantages:

- Dense structure
- Jointless
- Low-stress
- Close to contour and variable measurements

Please take dimensional allowances into consideration regarding sizes of rough blocks and boards. We recommend an addition of 15 mm per dimension.

Dimension tolerances of 3 mm in length and width and 0,5 mm in thickness are possible.

During casting of a block/blank voids or colour shades may occur. Therefore we can not give any guarantee, that the block/blank is completely free from bubbles. In case of a casting thickness over 250 mm or complex contours we reserve the right to cast in parts. Colour shades, bubbles and parting lines are not considered as inferior quality.

Safety measure

ebablock® material is a cured filled polyaddition product, no hazardous dusts when grinding.

According to regulations for hazardous products all **ebablock®** products are not to be marked for transport and storage. Please follow safety advices !

Waste Disposal

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