

|          |                         |
|----------|-------------------------|
| Basis    | wear resistant gel coat |
| Resin    | OH 11 hard Comp. A      |
| Hardener | PUR 1 Comp. B           |
| Colour   | oxyde red               |

### Applications

- Pattern plates
- Foundry patterns
- Core boxes

### Properties

- very abrasion resistant
- impact resistant
- excellent demoulding from mould and core sand properties
- polyurethane-based

### Processing data

| Product               |                                 | Mixture<br>OH 11 - hard / PUR 1 | Resin<br>OH 11 hard Comp. A | Hardener<br>PUR 1 Comp. B |
|-----------------------|---------------------------------|---------------------------------|-----------------------------|---------------------------|
| Colour                |                                 | oxyde red                       | oxyde red                   | brown                     |
| Mixing ratio          | p. b. w.                        |                                 | 100                         | 30                        |
|                       | volume                          |                                 | 100                         | 39                        |
| Viscosity at 25°C     | mPas                            | thixotrop                       | thixotrop                   | 100 ± 30                  |
| Density at 20°C       | g / cm <sup>3</sup>             | 1,50 ± 0,05                     | 1,60 ± 0,05                 | 1,24 ± 0,02               |
| Pot life 200 g / 20°C | min.                            | 20 - 25                         | -                           | -                         |
| Curing time at RT     | hrs.                            | 3 - 5                           | -                           | -                         |
| Post curing           | Time in h/<br>Temperature in °C | -                               | -                           | -                         |

### Physical data

| Properties   | Inspect. requirem.             | Unit                             | Value      |
|--|--------------------------------|----------------------------------|------------|
| Flexural strength  | EN ISO 178                     | MPa                              | 65 ± 5     |
| Flexural elongation at break   | EN ISO 178                     | %                                | 3,0 ± 0,15 |
| Flexural modulus   | EN ISO 178                     | MPa                              | 3200 ± 250 |
| Tensile strength   | EN ISO 527-1                   | MPa                              | -          |
| Tensile strength / test piece type 2                                   | ISO 37                         | MPa                              |            |
| Elongation at break  | ISO 37                         | %                                | -          |
| Impact resistance (Charpy)   | EN ISO 179                     | kJ/m <sup>2</sup>                | 9,5 ± 1,5  |
| Compressive strength   | EN ISO 604                     | MPa                              | 60 ± 5     |
| Shore hardness   | DIN ISO 7619-1                 | Shore D                          | 85± 3      |
| Heat resistance (HDT)  | DIN EN ISO 75 B                | °C                               | 70± 2      |
| Glass transition temperature T <sub>g</sub>                            | DSC                            | °C                               | -          |
| Coefficient of thermal expansion                                       | internal test /<br>Dilatometer | 10 <sup>-6</sup> K <sup>-1</sup> | -          |
| Abrasion Taber Abraser H 18<br>Application weight 500g / 250 Rotations | internal                       | mg                               | ca. 140    |

### Sales units (packages)

|              |        |                      |   |
|--------------|--------|----------------------|---|
| Packing size | A-Pack | OH 11 - hard / PUR 1 | resin 12 x 0,330 kg / hardener 12 x 0,100 kg = 5,160 kg |
| Units        |        | PUR 1 Comp. B        | 0,100 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** sealer).

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** ebaclean.

## In General

**ebalta** OH 11 is abrasion- and impact- resistant.

**ebalta** OH 11-hard is even more wear resistant and harder

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 1-3 mm. No sagging at edges, corners and vertical surfaces.

## Storing

Storage at room temperature 18-25 °C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Shelf life is indicated on the labels.

## 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.