

OH 49-1 Comp. A + B

Technical Datasheet



Polyurethane gel coat

Applications

foundry models
core boxes
form recordings
hammer tools

Properties

Shore D 66
hard elastic
highly abrasion resistant
impact resistant

Processing data

Product		Mixture	Resin	Hardener
		OH 49-1 Comp. A + B	OH 49-1 Comp. A (Iso)	OH 49-1 Comp. B (Amin)
Colour		green	transparent	green
Mixing ratio	p.b.w.		100	130
Viscosity at 25 °C	mPas	pasty	pasty	pasty
Density at 20 °C	g/cm ³	1,11 ± 0,02	1,12 ± 0,02	1,10 ± 0,02
Pot Life	minutes	20 - 25		
Demoulding time	hours	14 - 20		

Physical data

Properties	Inspect. Requirements	Unit	Value
Flexural strength	DIN EN ISO 178*	MPa	28 ± 2
Flexural elongation at break	DIN EN ISO 178*	%	7 ± 0,1
Flexural modulus	DIN EN ISO 178*	MPa	640 ± 20
Shore hardness	DIN ISO 48-4*	Shore D	66 ± 3
Abrieb Taber Abraser H 18 500g/500U	Internal audit	mg	~ 26
Wear jet test	Internal audit	mm ³ /min	~ 21

* based on

Sales units (packages)

OH 49-1 comp. A / VP OH 49-1 comp. B, green 1.840 kg A-Pack

additional products

Release agent T1-1 liquid whitish 1 ltr. bottle
Release agent T1-1 liquid whitish 5 ltr. can
colour paste blue 0,250 kg tin
colour paste red 0,250 kg tin
cleaning agent ebaclean, colourless 5 l can

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Processing instructions

Material- and processing temperature: between 18 - 25 °C.
Close containers after use.

Seal porous mould surfaces first

For optimal mould release, we recommend using a suitable release agent (e.g., T 1-1), which can be easily applied with a brush. The mold should be treated 2-3 times and aired for about 20 minutes after each application.

Component A may undergo phase separation depending on the storage duration, so it must be thoroughly stirred before use.

The mixing ratio of resin and hardener must be adhered to according to the specifications.

Residues of resin on stirring tools etc. can be easily cleaned using ebaclean.

Thanks to its thixotropic consistency, the resin/hardener mixture can be applied in a single layer with a short-bristle brush, bubble-free, without running off edges, corners or vertical surfaces.

It is recommended to apply the material in one direction to ensure a homogeneous and bubble-free surface.

To create contrast, a small amount of colour paste can be added to the second layer.

As soon as the surface resin gels (i.e. no longer forms threads when touched but is still slightly tacky), the next layer or build-up can be applied

General

OH 49 - 1 is a high abrasion-resistant, hard-elastic gelcoat based on polyurea.

Consumption is approximately 600 g/m² per 0.5 mm layer thickness.

For intermediate layer adhesion, we recommend the following product:

- PU resin-based backfill (e.g. GM 727): KP 8 Comp. A + B
- Epoxy resin-based backfill (e.g. PS 03 - 1): KP 6 /BR

All specified characteristic values were determined after thermal conditioning at 80 °C for 8 hours.

The pot life was determined in accordance with internal test procedures using a 200 g sample at room temperature (approx. 23 °C).

The demolding times refer to demolding at room temperature.

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.

Please refer to the product labels for the shelf life of the material.

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material.

Please refer to the respective safety data sheets

Waste Disposal

The cured materials can be disposed of as household or commercial waste in consultation with the respective competent authority.

Uncured products must be properly disposed of in consultation with the competent authority.

For further questions, our product safety department is at your disposal.

Compliance & Legal

The information and recommendations provided are based on careful evaluation and practical experience. They reflect the state of our knowledge at the time of provision. Updates may be made without notice.

The information is intended as general guidance and does not constitute a warranty of specific characteristics or properties of the product. Due to the wide range of potential applications and processing methods, not all individual use cases can be covered.

The product must be used in accordance with the applicable safety and usage instructions. No liability will be accepted for improper use or application outside the intended purpose.

Unless otherwise agreed, it is the responsibility of the user to independently assess the suitability of the product for the intended application and processing method.

The information provided does not release the user from the obligation to seek individual advice in cases of uncertainty regarding specific applications.

Statutory warranty rights remain unaffected.