

Basis	carbonfibre filled gel coat
Resin	OH 82
Hardener	TM
Colour	black

Applications

- Prepreg tools
- Vacuum forming tools
- High temperature press tools

Properties

- very low coefficient of linear expansion
- very high heat resistance
- dimensionally accurate

Processing data

Product		Mixture OH 82 / TM	Resin OH 82	Hardener TM
Colour		black	black	brown transparent
Mixing ratio	p. b. w.		100	31
Viscosity at 25°C	mPas	thixotrop	thixotrop	375 ± 75
Density at 20°C	g / cm ³	1,22 ± 0,02	1,35 ± 0,03	0,97 ± 0,02
Pot life 200 g / 20°C	min.	220 - 260	-	-
Curing time at RT	hrs.	24 - 48	-	-
Post curing	Time in h/ Temperature in °C	16 / 60 8 / 130 4 / 160	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	90 ± 4
Flexural modulus	EN ISO 178	MPa	4630 ± 300
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	7,3 ± 1,5
Compressive strength	EN ISO 604	MPa	105 ± 7
Shore hardness	DIN ISO 7619-1	Shore D	87 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	175 ± 5
Glass transition temperature T _g	TMA	°C	175
Coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	ca. 50

Sales units (packages)

Packing size A-Pack OH 82 / TM resin 12 x 0,285 kg / hardener 12 x 0,090 kg = 4,500 kg

Processing instructions

The material and processing temperature should be between 18 and 25 °C.

As soon as the surface resin has gelled but is still slightly tacky, you can proceed with your buildup.

We recommend our coupling paste KP 7/TM as a coupling layer for the subsequent backing.

After use, the containers should be resealed.

Porous mould surfaces should be sealed first (e.g. **ebalta** Pore Sealer or **ebalta** Sealer 02).

For optimal mould release, we recommend a suitable release agent (e.g. T 1-1), which can be applied very easily with a brush.

The mould should be coated 2-3 times and allowed to evaporate for approx. 20 min. after each application.

The mixing ratio of resin and hardener must be kept according to the instructions.

Resin residues on stirring rods etc. can easily be cleaned with **ebalta** ebaclean.

In General

ebalta OH 82 is a 2-component epoxy ge lcoat filled with micro carbon fibres.

After heat treatment it has a high temperature resistance and low thermal expansion. In combination with our LH 28-1/TM laminating resin system and carbon fibre fabrics, it is used to build very dimensionally accurate, heat-resistant prepreg tools.

The physical data are achieved according to the thermal treatment specified on the front side under "Processing data".

We recommend to heat up and cool down at a rate of approx. 10°C/h.

Depending on the geometry, different parameters may be operated.

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: see 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.