

Basis	ebablock® 1204
Colour	yellow
Further colours	black

Applications

- Core boxes
- Foundry patterns
- Pattern plates

Properties

- high abrasion resistance
- very good edge strength
- very impact resistant
- dense surface
- easy to work

Processing data

Product	ebablock® 1204		
Colour	yellow		
Density at 20°C	g / cm ³	1,20 ± 0,02	

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	120 ± 5
Flexural elongation at break	EN ISO 178	%	6,9 ± 0,5
Flexural modulus	EN ISO 178	MPa	2950 ± 300
Tensile strength	EN ISO 527-1	MPa	-
Elongation	EN ISO 527-1	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	66 ± 9
Compressive strength	EN ISO 604	MPa	90 ± 5
Shore hardness	DIN ISO 7619-1	Shore D	84 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	87 ± 3
Coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	ca. 77
Wear jet test	internal tests	W(V/t) [mm ³ /min]	approx. 82
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 44

Sales units (packages)

ebablock® 1204

Block material, dimensions variable

board material, ebaboard 1204

1000 x 500 x 50 mm

1000 x 500 x 75 mm

1000 x 500 x 100 mm

Processing instructions

ebablock® 1204 is a wear resistant, synthetic material on polyurethane base. The material contains no halogen, softener and solvents.

Advise for machining of block material

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

Milling parameters are available.

The gluing of **ebablock® M 1204** is made with our "adhesive yellow".

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.