

Basis **ebablock® 1220**

Colour orange

Applications

- Foundry patterns
- Pattern plates
- Core boxes

Properties

- high abrasion resistance
- dimensionally accurate
- easy to work
- high quality surface
- good edge stability

Processing data

Product	ebablock® 1220		
Colour	orange		
Density at 20°C	g / cm ³	1,21 ± 0,02	

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	120 ± 10
Flexural modulus	EN ISO 178	MPa	3000 ± 200
Elongation at max. flexural stress	EN ISO 178	%	6,5 ± 0,5
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	60 ± 10
compressive strength 0,75 % proof stress	EN ISO 604	MPa	92 ± 8
Shore hardness	DIN ISO 7619-1	Shore D	85 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	82 ± 4
coefficient of linear expansion 20 - 50 °C	internatl test / Dilatometer	10 ⁻⁶ K ⁻¹	approx. 73
Wear jet test	internal tests	W(V/t) [mm ³ /min]	approx. 47
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 25

Sales units (packages)

ebablock® 1220

Block material, dimensions variable

board material ebaboard 1220

1000 x 500 x 50 mm

1000 x 500 x 75 mm

1000 x 500 x 100 mm

Processing instructions

Advices for machining of board material

- Making even of milling support
- Roughing of geometry
- Remove clamps, if possible allow to relax over night
- Clamping
- Finishing

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

For changes we recommend the Casting resin orange

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.

Dimensional tolerance of 1 % 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 200 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.