

Basis **ebaboard 1220**

Colour orange

Applications

- Foundry patterns
- Core boxes
- Pattern plates

Properties

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

Processing data

Product	ebaboard 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	ca. 73
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 47
Abrasion Taber Abraser H Application weight 500g / 500 Rotations	internal	mm ³	ca. 25

Sales units (packages)

ebaboard 1220

1000 x 500 x 50 mm
1000 x 500 x 75 mm
1000 x 500 x 100 mm

blockmaterial, eblock 1220
dimensions variable

Processing instructions

Advice 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.

The repair putty can also be used as fast adhesive and can be mixed individually with the adhesive following the indications of a mixing table in order to set up the pot-life.

For changes we recommend the Casting resin orange
Milling parameters are available.

In General

ebaboard material is available in specified sizes. The surface is machined on all sides. **ebaboard** is a synthetic, post-cured board material on polyurethane base. It has an even structure and plane parallel machined surfaces.

Advantages:

- Dense structure
- Good edge strength
- Low tension
- Good workability
- Low dust development when milling

Dimension tolerances of 3 mm in length and width and 0,5 mm in thickness are possible.

Safety measure

ebaboard material is a cured filled polyaddition product, no hazardous dusts when grinding.
According to regulations for hazardous goods **ebaboard** products don't have to be marked during transport and storage.
Please follow safety advices !

Waste Disposal

Small quantities can be disposed as domestic waste. For big quantities, contact your local authorities, please.

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.