

Basis	<b>Lightweight backfilling system</b>
Resin	<b>HFG</b>
Hardener	<b>PUR 11 Comp. B</b>
Colour	grey

## Applications

- Backfillings for core boxes
- Backfillings for negatives

## Properties

- very thick castable
- fast curing
- impact resistant
- dimensionally accurate
- for large volume back fillings

## Processing data

Product		Mixture HFG / PUR 11	Resin HFG	Hardener PUR 11 Comp. B
Colour		grey	grey	yellow
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>33</b>
Viscosity at 25°C	mPas	20000 ± 5000	pastös	25 ± 10
Density at 20°C	g / cm <sup>3</sup>	0,97 ± 0,02	0,90 ± 0,02	1,10 ± 0,02
Pot life 200 g / 20°C	min.	7 - 9	-	-
Curing time at RT	hrs.	4 - 5	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	22 ± 2
Flexural elongation at break	EN ISO 178	%	1,00 ± 0,02
Flexural modulus	EN ISO 178	MPa	2200 ± 250
Tensile strength	EN ISO 527-1	MPa	-
Elongation	EN ISO 527-1	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	2 ± 0,2
Compressive strength	EN ISO 604	MPa	29 ± 3
Heat resistance (Martens)	DIN 53458	°C	65 ± 2
TG in TMA T <sub>g</sub>	Methode TMA	°C	-
Shore hardness	DIN ISO 7619-1	Shore D	74 ± 2
Coefficient of thermal expansion	internal test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	-
Linear shrinkage	internal	%	-

## Sales units (packages)

Units	Comp. A	HFG	15,000 kg
	Hardener	PUR 11 Comp. B	1,000 kg / 5,000 kg / 50,000 kg

## Processing instructions

Material- and working- temperature: between 18 - 25 °C.

Close containers after use.

Seal porous mould surfaces first (**ebalta** mould sealer).

For optimum mould releasing we recommend a special release agent (like T1-1), which can be applied easily with a brush or be sprayed. Releasing of the mould 2-3 times, evaporate for about 20 min. after each releasing.

Mixing ratio resin/hardener according to instructions.

Stirring rods etc. with residual resin can be easily cleaned with **ebalta** cleaning agent.

1. brush gel coat, e.g. OH 11
2. Gelling of surface
3. Brush gel coat together with chopped glass strand
4. Cast comp. B into comp. A
5. Stir with spiralmixer
6. Cast immediately

## In General

**ebalta** HFG is a light filled 2-components-polyurethane casting compound, which cures fast at room temperature. After curing this material is dimensional accurate light weight but anyway resistant, which is especially suitable for big volume backfilling of coreboxes and negative moulds.

For bigger wall thickness it is possible to mix about 35 volume parts "Kunststoffgranulat" (=synthetic granules) in comp. A in advance

## 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 is indicated on the 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.