

Basis	High temperature resistant coupling paste
Resin	KP 7-1
Hardener	TM
Colour	grey

Applications

- Couplingpaste for OH 33/H 2017
- Couplingpaste for OH 35/H 2017
- Couplingpaste for OH 38/H 2017
- Couplingpaste for LH28-1/TM

Properties

- high heat resistance
- aluminium filled

Processing data

Product		Mixture KP 7-1 / TM	Resin KP 7-1	Hardener TM
Colour		grey	grey	brown transparent
Mixing ratio	p. b. w.		100	32
Viscosity at 25°C	mPas	thixotrope	thixotrope	375 ± 75
Density at 20°C	g / cm ³	1,3 ± 0,05	-	0,97 ± 0,02
Pot life 200 g / 20°C	min.	240 - 360	-	-
Curing time at RT	hrs.	24 - 48	-	-
Post curing	Time in h/ Temperature in °C	post curing necessary (look back side)	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural elongation at break	EN ISO 178	%	-
Flexural modulus	EN ISO 178	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
Compressive strength	EN ISO 604	MPa	-
Shore hardness	DIN ISO 7619-1	Shore D	-
Heat resistance (HDT)	DIN EN ISO 75 B	°C	135 ± 3 gradual post curing till 100 °C 175 ± 3 gradual post curing till 135 °C
Coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Packing size A-Pack KP 7-1 / TM Resin 12 x 0,200 kg / hardener 12 x 0,064 kg = 3,168 kg

Processing instructions

The coupling paste is applied in a 1 mm layer on the gelled but still sticky surface.

In General

ebalta KP 7-1 is an aluminium powder-filled coupling paste, precuring at room temperature and can be used till 150°C after thermal treatment.

KP 7-1 serves as coupling paste for our reeinforcing paste PS 07-1 and our laminating resin LH 28-1.

We recommend to perform the complete postcuring on the master model, at least the first one should be made this way. Not more than 20°C/h for heating up and cooling down.

Moreover the heating up time of the moulding has to be considered too!

High heat resistance is reached by step-by-step curing (at about 20°C/h).

Glass transition temperature (TG) 95 °C: after curing 4 h at 40 °C + 4 until 10 h at 60 °C

Glass transition temperature (TG) 139 °C: after curing 4 h at 40 °C + 4 until 10 h at 60 °C + 4 h at 100 °C

Glass transition temperature (TG) 156°C: After postcuring 4 hrs. at 40°C + 4-10 hrs. at 100°C

+ 4 hrs. at 135°C

Glass transition temperature (TG) 175 °C: after curing 4 h at 40 °C + 4 until 10 h at 60 °C + 4 h at 100 °C + 4 h at 135 °C + 4 h at 160 °C

Storing

At appropriate storage 18-25°C.

Occuring crystallization due to disadvantageous storage conditions can be made return by warming up the material at approx. 60° C.

Opened containers should be closed immediately after use and be protected against moisture. This material 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.