

Basis	well polishable, heat resistant gel coat
Resin	OH 38
Hardener	HM
Colour	alu grey

Applications

- Vacuum forming tools
- PU-foaming tools
- Prepreg tools
- Bonding fixtures

Properties

- well grindable
- aluminium-like
- well polishable
- dense surface
- high heat resistance

Processing data

Product		Mixture OH 38 / HM	Resin OH 38	Hardener HM
Colour		alu grey	grey	amber
Mixing ratio	p. b. w.		100	13
Viscosity at 25°C	mPas	thixotrop	thixotrop	2000 ± 500
Density at 20°C	g / cm ³	1,60 ± 0,05	1,65 ± 0,05	1,03 ± 0,02
Pot life 200 g / 20°C	min.	20 - 30	-	-
Curing time at RT	hrs.	16 - 24	-	-
Post curing	Time in h/ Temperature in °C	6 / 60 4 / 80 4 / 120	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	75 ± 5
Flexural elongation at break	EN ISO 178	%	2,5 ± 0,3
Flexural modulus	EN ISO 178	MPa	3800 ± 500
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	16 ± 2
Compressive strength	EN ISO 604	MPa	130 ± 10
Shore hardness	DIN ISO 7619-1	Shore D	90 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	145 ± 5
Glass transition temperature T _g	DSC	°C	122

Sales units (packages)

Units	resin	OH 38	6,000 kg
	hardener	HM	1 kg

Processing instructions

The material and processing temperature should be between 18 and 25 °C.

Due to its thixotropic consistency, the resin/hardener mixture can be easily applied with a short-haired brush without bubbles and without running off edges, corners and vertical surfaces.

As soon as the surface resin has gelled but is still slightly tacky, you can proceed with your buildup.
We recommend our coupling paste KP 6/TGL or KP 7/TM as a coupling layer for the subsequent backing.

After use, the containers should be resealed.

Porous mould surfaces should be sealed first (e.g. **ebalta** Pore Sealer or **ebalta** Sealer 02).
For optimal mould release, we recommend a suitable release agent (e.g. T 1-1), which can be applied very easily with a brush.
The mould should be coated 2-3 times and allowed to evaporate for approx. 20 min. after each application.

The mixing ratio of resin and hardener must be kept according to the instructions.
Resin residues on stirring rods etc. can easily be cleaned with **ebalta** ebaclean.

In General

ebalta OH 38 is a two components epoxy gel coat which cures at room temperature without almost any shrinkage. It shows a polishable very dense surface with aluminium-like character.
Due to its good sandability, damaged areas can be repaired well without transitions.
Matt surfaces from wear-out effects can be silk-finish polished.

The physical data are achieved according to the thermal treatment specified on the front side under "Processing data".
We recommend to heat up and cool down at a rate of approx. 10°C/h.
Depending on the geometry, different parameters may be operated.

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: 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.