

Basis	machinable epoxy lay-up paste
Resin	P 28 resin
Hardener	P 28 hardener
Colour	light grey

Applications

- Master models for big laminating tools
- Large-area laminating moulds
- Aircraft and boat building, wind engery
- Post curing shelves

Properties

- 10 - 25 mm layer possible
- dimensionally stable
- almost odourless
- very easy to work
- fine structure
- no sagging on vertical surfaces

Processing data

Product		Mixture P 28 / resin + hardener	Resin P 28 resin	Hardener P 28 hardener
Colour		light grey	light grey	white
Mixing ratio	p. b. w.		100	100
Viscosity at 25°C	mPas	thixotrop	thixotrop	thixotrop
Density at 20°C	g / cm ³	0,75 ± 0,03	0,75 ± 0,03	0,75 ± 0,03
Pot life 500 g / 20°C	min.	45 - 60	-	-
workable at RT after	h	20	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	22 ± 0,72
Flexural elongation at break	EN ISO 178	%	3 ± 0,1
Flexural modulus	EN ISO 178	MPa	958 ± 40
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	3,18 ± 0,3
Compressive strength	EN ISO 604	MPa	19 ± 0,6
Shore hardness	DIN ISO 7619-1	Shore D	62 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	82 ± 3
Glass transition temperature T _g	DSC	°C	ca. 102
Coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	approx. 65
Linear shrinkage	internal	%	approx. 0,15

Sales units (packages)

Units	Resin	P 28 resin	30,000 kg / 130,000 kg
	Hardener	P 28 hardener	30,000 kg / 130,000 kg

Processing instructions

Processing only by means of standard 2K metering mixing systems for applying pastes.

Before processing make sure that the base construction is solid, stable and dust free. Material-, processing- and supporting frame-temperature between 19 - 24 °C.

Machining of surfaces not before 20h after curing at room temperature.

As base construction we recommend our **ebazell 80** or **ebazell 160**.

P 28 can be processed overhead.

1) Output

Depending on the contour and surface the output is between 1.5 liters and 2.5 liters.

2) Spindle speed of mixer

Employment of a dynamic, static mixer, according to output volume the spindle speed is between 1000 speed/min and 3500 speed/min, depending on the used machine.

3) Pre-pressure on follower plate

Pressure not more than 3.5 bar

4) Operating pressure

The pressure within the material line during a discharge of 2.5 liters is typically between 20-30 bar.

5) Temperature

The processing temperature for the paste is 19-24°C. Temperature at the end of the output tube must not exceed 27°C.

6) Layer Thickness

Material can be applied in a layer of 10-25mm. All layers must be even, apply paste in corners radius-shaped.

Attention: material accumulations! Uneven layer thicknesses and material accumulations lead to cracks.

7) Evacuation in case of change of container

When using new material, take care that there are't any air entrapments between the container and the follower plate.

For this purpose we recommend to discharge 750 ml of the material directly at the follower plate as well as behind the pump in each case. Only when having uniform material flow you can continue application of the paste.

8) Mixing faults

Do not mix any material residues with the new material since this leads to uncontrolled air entrapments which cannot be removed by evacuation. Moreover this will cause faulty mixtures.

In General

ebalta P 28 is a thixotropic two-components system on epoxy base, which cures at room temperature.

The physical datas were measured at a postcuring, 8 h at 80°C.

Storing

At appropriate storage 18-25°C.

Opened containers should be closed immediately after use and should be used up as soon as possible.

Information about the expiration date you find on the sales packages.

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.