

Basis	abrasion resistant gel coat
Resin	OH 49-1 Comp. A (ISO)
Hardener	OH 49-1 Comp. B (Amine)
Colour	green

Applications

- fixtures
- Pattern plates
- Foundry patterns
- Core boxes
- Hammer form tools

Properties

- very abrasion resistant
- hard flexible
- Shore D hardness approx. 66

Processing data

Product		Mixture OH 49-1 /Comp. A+B	Resin OH 49-1 Comp. A (ISO)	Hardener OH 49-1 Comp. B (Amine)
Colour		green	transparent	green
Mixing ratio	p. b. w.		100	130
Viscosity at 25°C	mPas	thixotrop	pastös	pastös
Density at 20°C	g / cm ³	1,11 ± 0,02	1,12 ± 0,02	1,10 ± 0,02
Pot life 200 g / 20°C	min.	20 - 25	-	-
Curing time at RT	hrs.	14 - 20	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural elongation at flexural strength	EN ISO 178	%	28 ± 2
Flexural elongation at break	EN ISO 178	%	7 ± 0,1
Flexural modulus	EN ISO 178	MPa	640 ± 20
Shore hardness	DIN ISO 7619-1	Shore D	66 ± 3
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 21
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 26

Sales units (packages)

Packing size A-Pack OH 49-1 /Comp. A+B resin 8 x 0,100 kg / hardener 8 x 0,130 kg = 1,840 kg

Processing instructions

Material- and processing temperature between 18° and 25°C.

Close open containers properly and use up a.s.a.p.

Seal porous surfaces first (with pore sealer **ebalta**)

For optimum demoulding we recommend a suitable release agent (e.g. T1-1) which can be applied easily with brush. Apply release agent 2-3 times and evaporate for approx. 20 minutes after each application.

The mixture is viscid and doesn't sag on vertical surfaces unless applied thicker than 2 - 3 mm with a brush.

A second layer can be applied after approx. 60 minutes

Follow mixing ratio of resin/hardener according to instructions.

Resin residues on mixing rods can be easily removed with our cleaning agent.

In General

ebalta OH 49-1 is a rigid elastic polyurethane gel coat curing at room temperature.

Its rigid character means high abrasion resistance and impact strength as well as good release properties regarding foundry- and core sand.

To avoid possible surface defects, porous molds and cores should be sealed. For backfilling of large volumes, we recommend GM 727 with approx. 60-70 pbw. F-B filler to reduce temperature development and shrinkage.

For optimum bonding between layers apply coupling paste KP 8.

For covered back casting we recommend casting after 1 h.

For optimum bonding of epoxy laminate constructions or on laminate paste, apply coupling paste KP 6/BR wet-in wet or within 30 minutes.

Colour might vary which however does not affect any material properties.

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.