

Basis	Laminating system
Resin	ebacryl L-1
Hardener	ebacryl EM-1
Colour	light beige

Applications

- Hand laminating
- Negative shells
- Mould constructions
- Scenery for theater
- Supporting shells for heat treatment
- Supporting for laser cutting
- supporting shells
- Negative shells of clay models
- Casting of relief and figures

Properties

- free of shrinkage
- low thermal expansion
- low exothermic character
- no restriction in thickness of laminates
- tools can be washed with water
- no health and safety problems
- Can be cast bubble free

Processing data

Product		Mixture ebacryl L-1 / EM-1	Resin ebacryl L-1	Hardener ebacryl EM-1
Colour		light beige	light beige	whitish
Mixing ratio	p. b. w.		100	50
Viscosity at 25°C	mPas	-	-	-
Density at 20°C	g / cm ³	1,7 ± 0,05	-	1,05 ± 0,02
Pot life 200 g / 20°C	min.	ca. 35	-	-
Curing time at RT	hrs.	8 - 12	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural modulus	EN ISO 178	MPa	-
Flexural strength at breakage	EN ISO 178	%	-
Flexural strength at breakage	ISO 37	%	-
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
Heat resistance (Martens)	DIN 53458	°C	>100
Shore hardness	DIN 53505	Shore D	-
Shore hardness	DIN 53505	Shore A	-
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	ca. 11

Sales units (packages)

Units	ebacryl L-1	25 kg
	ebacryl EM-1	25 kg

Processing instructions

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

After use the containers are to be closed.

Porous mould surfaces should be sealed firstly (Release sealer , **ebalta**).

For an optimum mould release we recommend to use a suitable release agent. The mould should be treated three times with the release agent. After every application the evaporation time should be 20 minutes.

The mixing ratio has to be observed, although deviations are not so serious as with epoxy or polyurethane systems. By addition of more powder all systems can be given a trowelling consistency. In any case you start with the liquid and then the powder is added by mixing. Mechanical mixing is recommended. Working tools can be cleaned with tap water.

In General

Fire protection expert reports (B1) can be requested.

Polystyrene foams (e.g. „styrofoam“) are not corroded by the a/m systems. ebacryl shows a very good bonding with „styropor“ or styrodur“.

During processing of these water-based and environmentally friendly systems there is no development of harmful vapors or waste.

The combination with epoxy surfaces is possible and is recommended for mold making in case of heavy stress.

Coloring with powder or emulsion paint is possible. Due to the low exothermic character laminates in any thickness can be produced in one operation.

The systems show no shrinkage and have a very low thermal expansion coefficient. Even higher temperatures do not effect the stability.

Natural fiber can be used as reinforcing fabric. Spreadsheets and application examples can be requested.

Storing

Storage at room temperature 10 - 25 °C.

Protect against freeze.

Already opened containers should be closed immediately after use and should be used 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.

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