

Basis	Polishable, heat resistant gelcoat
Resin	OH 19
Hardener	SR
Colour	alu grey

Applications

- Vacuum forming tools
- PU-foaming tools

Properties

- polishable
- very low shrinkage
- heat resistant

Processing data

Product		Mixture OH 19 / SR	Resin OH 19	Hardener SR
Colour		alu grey	alu grey	amber
Mixing ratio	p. b. w.		100	10
Viscosity at 25°C	mPas	thixotrop	thixotrop	1650 ± 50
Density at 20°C	g / cm ³	1,75 ± 0,05	1,85 ± 0,03	1,07 ± 0,02
Pot life 200 g / 20°C	min.	20 - 30	-	-
Curing time at RT	hrs.	12 - 15	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	95 ± 5
Flexural modulus	EN ISO 178	MPa	8500 ± 650
Flexural strength at breakage	EN ISO 178	%	1,6 ± 0,2
Tensile strength	EN ISO 527	MPa	-
Tensile strength / test piece type 2	ISO 37	MPa	-
Elongation at break	ISO 37	%	-
Compressive strength	EN ISO 604	MPa	115 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	13,5 ± 3
Heat resistance (Martens)	DIN 53458	°C	90 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	-
Glass transition temperature TG	methode DSC	°C	-
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Packing size	A-Pack	OH 19 / SR	resin 12 x 0,450 kg / hardener 12 x 0,045 kg = 5,940 kg
Units	Resin	OH 19	6,000 kg
	Hardener	SR	1,000 kg / 5,000 kg / 50,000 kg

Processing instructions

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

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before (**ebalta** sealant).

For an optimum mould release we recommend a suitable release agent (e.g. T 1-1) which can be easily applied with a brush.

The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

Stirring rods etc. with residual resin can be easily cleaned with **ebalta** cleaning agent.

In General

ebalta OH 19 is a 2-component epoxy gelcoat curing at room temperature with almost no shrinkage, yielding a polishable very dense surface with aluminium-like characteristics.

Due to its thixotropic consistency the resin/hardener mixture can be easily applied without any bubbles with a short-haired brush in a layer of 1 mm. No sagging at edges, corners and vertical surfaces. Apply two layers, the second one about 60 min. after the first one.

As coupling paste for the rear construction we recommend coupling paste KP 6/TGL.

After single curing at 50 - 60 °C for 10 - 12 hrs OH 19/SR is heat resistant up to about 110 °C.

Storing

Storage at room temperature 18-25 °C.

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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