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| Basis | good grinding, chemical resistant gelcoat |
| Resin | OH 35 |
| Hardener | CH-1 |
| Colour | black |

Applications

- PU-foaming tools
- RIM foam tools
- Polyester press forms
- Prepreg tool
- Adhesive probes
- Vacuum forming tools

Properties

- chemical resistant
- polishable
- grinding possible
- dense surface
- heat resistant

Processing data

| Product | | Mixture OH 35 / CH-1 | Resin OH 35 | Hardener CH-1 |
|-----------------------|------------------------------------|-------------------------|----------------|--------------------|
| Colour | | black | black | yellow transparent |
| Mixing ratio | p. b. w. | | 100 | 16 |
| Viscosity at 25°C | mPas | thixotrop | thixotrop | 3500 ± 500 |
| Density at 20°C | g / cm ³ | 1,60 ± 0,05 | 1,70 ± 0,05 | 1,08 ± 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 | 10 - 12 / 60 - 80 | - | - |

Physical data

| Properties | Inspect. requirem. | Unit | Value |
|---------------------------------|--------------------|----------------------------------|-------------|
| Flexural strength | EN ISO 178 | MPa | 110 ± 10 |
| Flexural modulus | EN ISO 178 | MPa | 5500 ± 500 |
| Flexural strength at breakage | EN ISO 178 | % | 2,55 ± 0,25 |
| Tensile strength | EN ISO 527 | MPa | - |
| Compressive strength | EN ISO 604 | MPa | 105 ± 10 |
| Impact resistance (Charpy) | EN ISO 179 | kJ/m ² | 13,5 ± 3 |
| Heat resistance (HDT) | DIN EN ISO 75 B | °C | 98 ± 3 |
| Glass transition temperature TG | methode DSC | °C | 108 |
| Shore hardness | DIN 53505 | Shore D | 88 ± 3 |
| Coefficient of linear expansion | DIN 53752 | 10 ⁻⁶ K ⁻¹ | ca. 55 |

Sales units (packages)

| | | | |
|--------------|----------|--------------|---|
| Packing size | A-Pack | OH 35 / CH-1 | Resin 12 x 0,400 kg / Hardener 12 x 0,064 kg = 5,568 kg |
| Units | resin | OH 35 | 6,000 kg / 20,000 kg |
| | Hardener | CH-1 | 1,000 kg / 5,000 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 35 is a gelcoat which yields a very dense chemical resistant surface.

Due to its good grinding ability, damages can be amended very well without and any junctions.

Matt surfaces from wear-out effects can be silk-finish polished.

After curing at room temperature OH 35 isn't brittle, the moulds' edges are stable.

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

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.

We recommend postcuring for 10-12 hrs. at 60-80°C for long potlife and good heat resistance.

Storing

Storage at room temperature (18-25 °C) in closed original container 6 months.

Already opened containers should be closed immediately after use and should be used as soon as possible

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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