

Basis	gel coat
Resin	OH 4
Hardener	SL
Colour	white
Further colours	blue
Further hardeners	CH-1

Applications

- Negatives
- Master models
- jig
- Foundry patterns

Properties

- multi purpose useable
- longer processing time
- very good spreadable
- impact resistant surface
- easy to grind

Processing data

Product		Mixture OH 4 / SL	Resin OH 4	Hardener SL
Colour		white	white	amber
Mixing ratio	p. b. w.		100	14
Viscosity at 25°C	mPas	thixotrope	pasty	2200 ± 450
Density at 20°C	g / cm ³	1,4 ± 0,05	1,45 ± 0,02	1,05 ± 0,02
Pot life 200 g / 20°C	min.	25 - 30	-	-
Curing time at RT	hrs.	6 - 8	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	98 ± 5
Flexural elongation at break	EN ISO 178	%	2,7 ± 0,4
Flexural modulus	EN ISO 178	MPa	4500 ± 300
Tensile strength	EN ISO 527-1	MPa	-
Tensile strength / test piece type 2	ISO 37	MPa	-
Elongation at break	ISO 37	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	11 ± 4
Compressive strength	EN ISO 604	MPa	95 ± 5
Heat resistance (Martens)	DIN 53458	°C	63 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	-
Glass transition temperature TG	method DSC	°C	-
Shore hardness	DIN ISO 7619-1	Shore D	89 ± 3
coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Packing size	A-Pack	OH 4 / SL	resin 12 x 0,325 kg + hardener 12 x 0,046 kg = 4,452 kg
Units	Resin	OH 4	6,000 kg / 20,000 kg
	Hardener	SL	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 4 is a very well brushable epoxy gelcoat, curing at room temperature with almost no shrinkage.

Due to its thixotropic, but soft consistency, the resin/hardener mixture can be applied without any bubbles with a short-haired brush in a 1-3 mm layer. No sagging at edges, corners or at vertical surfaces. For this reason thicker layers can be applied which in general cannot easily be made in one step.

After curing the gelcoat is not brittle, the surface is well polishable.

With **ebalta** OH 4/SL the surface shows more impact resistance with a longer potlife, which is especially suitable for big surfaces.

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

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 is indicated on the 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.