Technical Datasheet

OH 4 / SL

Basis	**universally usable gel coat**
Resin	**OH 4**
Hardener	**SL**
Colour	white
Further colours	blue
Further hardeners	**VP H 2017**

Applications

- Negatives
- Master models
- Jigs
- Foundry patterns

Properties

- universally applicable
- longer processing time
- very good spreadable
- impact resistant surface
- well grindable

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	thixotrop	thixotrop	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	24 / RT + 8 / 80	-	-

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

Due to its thixotropic consistency, the resin/hardener mixture can be easily applied with a short-haired brush without bubbles and without running off edges, corners and vertical surfaces.

As soon as the surface resin has gelled but is still slightly tacky, you can proceed with your buildup.
We recommend our coupling paste KP 6/TGL as a coupling layer for the subsequent backing.

After use, the containers should be resealed.

Porous mould surfaces should be sealed first (e.g. **ebalta** Pore Sealer or **ebalta** Sealer 02).
For optimal mould release, we recommend a suitable release agent (e.g. T 1-1), which can be applied very easily with a brush.
The mould should be coated 2-3 times and allowed to evaporate for approx. 20 min. after each application.

The mixing ratio of resin and hardener must be kept according to the instructions.
Resin residues on stirring rods etc. can easily be cleaned with **ebalta** ebaclean.

In General

ebalta OH 4 is an easy spreadable epoxy gel coat, 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. No sagging at edges, corners or at vertical surfaces.As soon as the gel coat has gelled, but is still slightly tacky you can proceed with your buildup.

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

The physical data are achieved according to the thermal treatment specified on the front side under "Processing data".
We recommend to heat up and cool down at a rate of approx. 10°C/h.
Depending on the geometry, different parameters may be operated.

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.