

Basis	<b>epoxy board</b>
Colour	light blue

### Applications

- Prepreg tooling
- Composite moulds
- Vacuum forming tools

### Properties

- low coefficient of thermal expansion
- very fine surface structure
- very good dimension stability
- good milling properties
- very high heat resistance

### Processing data

<b>Product</b>	<b>ebaboard EP 978</b>		
Colour	light blue		
Density at 20°C	g / cm <sup>3</sup>	0,68 ± 0,02	

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	38 ± 4
Flexural modulus	EN ISO 178	MPa	2200 ± 100
Tensile strength	EN ISO 527-1	MPa	23 ± 4
Tensile modulus	EN ISO 527-1	MPa	2400 ± 100
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	5,3
Compressive strength	EN ISO 604	MPa	50 ± 4
Heat resistance (HDT)	DIN EN ISO 75 B	°C	145 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	70 ± 3
coefficient of thermal expansion	BS EN ISO 11359-2	10 <sup>-6</sup> K <sup>-1</sup> °C	ca. 39

### Sales units (packages)

<b>ebaboard EP 978</b>	1524 x 609 x 50 mm
	1524 x 609 x 75 mm
	1524 x 609 x 100 mm
	1524 x 609 x 150 mm

## Processing instructions

Advices for machining of board material

- Making even of milling support
- Roughing of geometry
- Removing of clamps, if possible over night
- Clamping
- Finishing

**Bonding:** Adhesive 552 for epoxy boards, Mixing Ratio 100 : 14 p. b. w.

**Sealing:** Sealer 02 or Sealer 09

**Release:** Release Agent 17

After gluing the blocks have to be kept at room temperature for 12-16 hours. To cure the adhesive gently heat up the glued blocks at about 5°C/ hour and keep them at 80°C for 10 hours. Leave the blocks one more hour at 80°C for every 100 mm thickness.

After cooling down at a rate of 5°C/ hour the block should remain at the autoclave with closed doors overnight, till he reaches room temperature also in the core.

Take the same procedure for curing prepregs on the mould. When taking the block out of the autoclave don't lay it on a cold surface. An isolating layer may be placed in between. Depending on the geometry of the tool different parameters may be necessary.

## In General

**ebaboard** material is available in specified sizes. The surface is machined on all sides. **ebaboard** is a synthetic, post-cured board material on epoxy base. It has an even structure and plane parallel machined surfaces.

Advantages:

- Dense structure
- Good edge strength
- Low strain
- Good workability
- Low dust development when milling

Dimension tolerances of 3 mm in length and width and 0,5 mm in thickness are possible.

## Safety measure

**ebaboard** material is a cured filled polyaddition product, no hazardous dusts when grinding.

According to regulations for hazardous goods **ebaboard** products don't have to be marked during transport and storage.

According to regulations for hazardous products all **ebaboard** products are not to be marked for transport and storage. Please follow safety advices !

## Waste Disposal

Small quantities can be disposed as domestic waste. For big quantities, contact your local authorities, please.

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.