

Basis	abrasion resistance gel coat
Resin	OH 49 Comp. A (ISO)
Hardener	OH 49 Comp. B (Amin)
Colour	green
Further colours	beige

Applications

- fixtures
- Pattern plates
- Foundry patterns
- Core boxes
- Hammer form tools

Properties

- very abrasion resistant
- hard flexible
- Shore D hardness approx. 66

Processing data

Product		Mixture OH 49 / Comp. A+B	Resin OH 49 Comp. A (ISO)	Hardener OH 49 Comp. B (Amin)
Colour		green	white	green
Mixing ratio	p. b. w.		100	36
	volume		100	33
Viscosity at 25°C	mPas	thixotrop	pastös	pastös
Density at 20°C	g / cm ³	1,15 ± 0,02	1,12 ± 0,02	1,22 ± 0,02
Pot life 200 g / 20°C	min.	12 - 16	-	-
Curing time at RT	hrs.	14 - 20	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural enlongation at flexural strength	EN ISO 178	%	20 ± 2
Flexural elongation at break	EN ISO 178	%	8,8 ± 0,2
Flexural modulus	EN ISO 178	MPa	480 ± 50
Tensile strength / test piece type 2	ISO 37	MPa	32 ± 3
Elongation at break	ISO 37	%	330 ± 50
Shore hardness	DIN ISO 7619-1	Shore D	66 ± 3
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 28
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 28

Sales units (packages)

Packing size A-Pack OH 49 / Comp. A+B 12 x 0,200 kg / 12 x 0,072 kg = 3,264 kg

Processing instructions

For optimal results please consult one of our technicians before use.

Material- and processing temperature between 18 and 25° C.

Please relock recipients with care after use. Partially used packages must be used up soon.

Close containers after use.

Seal porous mould surfaces first (ebalta mould sealer).

For optimum mould releasing we recommend a special release agent (like T1-1), which can be applied easily with a brush or be sprayed. Releasing of the mould 2-3 times, evaporate for about 20 min. after each releasing.

The mixture is very viscid, so that it doesn't run down on edges, corners and vertical surfaces if it has been applied with a short haired brush in a thickness of not more than 1 mm. A second layer can be applied after approx. 55 minutes.

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 49 is a very hard elastic polyurethane gelcoat, curing at room temperature. The hard- elastic consistency leads to an extremely good abrasion- and impact -resistance as well as to good dissolving power of mould- and coresand.

To avoid any surface defects by temperature increase when casting big volumes, we recommend GM 727 with addition of about 60-70 weight contents filler F-B.

To get an optimal bonding of the interlayers our coupling paste KP 8 should be applied. In case of a hidden back casting we recommend to cast after at least 2 hours.

An optimal adhesion on PU-resins can be achieved by laying up the coupling paste KP 8.

For optimum bonding of the epoxy resin or of laminating paste, apply coupling paste KP 6/BR wet-in-wet or within 30 min.

This product is not colour stable, possibly yellowing. This doesn't have any influence on properties.

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.