

Basis	good grinding gelcoat
Resin	OH 35
Hardener	CH-3
Colour	black

Applications

- PU-foaming tools
- RIM foam tools
- Prepreg tools
- Adhesive probes
- Vacuum forming tools

Properties

- polishable
- grinding possible
- dense surface
- heat resistant

Processing data

Product		Mixture OH 35 / CH-3	Resin OH 35	Hardener CH-3
Colour		black	black	yellow transparent
Mixing ratio	p. b. w.		100	18
Viscosity at 25°C	mPas	thixotrope	thixotrope	1450 ± 200
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 - 25	-	-
Curing time at RT	hrs.	16 - 24	-	-
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 ± 7
Flexural elongation at break	EN ISO 178	%	2,1 ± 0,3
Flexural modulus	EN ISO 178	MPa	5300 ± 100
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	12 ± 3
Compressive strength	EN ISO 604	MPa	118 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	94 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	88 ± 3

Sales units (packages)

Packing size	A-Pack	OH 35 / CH-3	resin 12 x 0,400 kg / hardener 12 x 0,072 kg = 5,664 kg
Units	resin	OH 35	6,000 kg
	hardener	CH-3	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.

Physical data mentioned in the data sheet are reached after a thermal Treatment of 24 h at room Temperatur + 8 h at 80°C. We recommend to heat up and cool down at a rate of appr. 10°C/h.

Depending on the tooling 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 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.