

Basis	solvent and heat resistant gel coat
Resin	OH 33
Hardener	CH-3
Colour	black

Applications

- RTM Tools
- Hand lay-up models
- PU-foaming tools

Properties

- good grinding
- resistant against solvent
- dense surface
- heat resistant

Processing data

Product		Mixture OH 33 / CH-3	Resin OH 33	Hardener CH-3
Colour		black	black	yellow transparent
Mixing ratio	p. b. w.		100	20
Viscosity at 25°C	mPas	thixotrope	thixotrope	1450 ± 200
Density at 20°C	g / cm ³	1,55 ± 0,05	1,65 ± 0,05	1,08 ± 0,02
Pot life 200 g / 20°C	min.	ca. 20	-	-
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	110 ± 10
Flexural elongation at break	EN ISO 178	%	3,4 ± 0,3
Flexural modulus	EN ISO 178	MPa	4800 ± 50
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	13 ± 2
Compressive strength	EN ISO 604	MPa	120 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	96 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	90 ± 3

Sales units (packages)

Packing size	A-Pack	OH 33 / CH-3	resin 12 x 0,400 kg / hardener 12 x 0,080 kg = 5,760 kg
Units	resin	OH 33	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 33 is an epoxy gelcoat with very good chemical resistance to solvents. After curing the surface is well polishable, very smooth, dense and shiny.

After curing at room temperature OH 33 isn't brittle, the moulds' edges are stable.

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.

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.