Technical Datasheet

OH 50 / Hardener 03

Basis	**good grinding, heat resistant gelcoat**
Resin	**OH 50**
Hardener	**Hardener 03**
Colour	black

Applications

- RTM Tools
- Polyester tools
- Hand lay-up models

Properties

- styrene resistant
- chemical resistant
- very dense surface
- polishable
- good heat resistance

Processing data

Product		**Mixture OH 50 / Hardener 03**	**Resin OH 50**	**Hardener Hardener 03**
Colour		black	black	yellow transparent
Mixing ratio	**p. b. w.**		**100**	**20**
Viscosity at 25°C	mPas	thixotrop	thxotrope	1200 ± 300
Density at 20°C	g / cm^3	1,13 ± 0,02	1,15 ± 0,02	1,06 ± 0,02
Pot life 200 g / 20°C	min.	12 - 18	-	-
Curing time at RT	hrs.	16 - 24	-	-
Post curing	Time in h/ Temperature in °C	8 - 12 / 80	-	-

Physical data

Properties	**Inspect. requirem.**	**Unit**	**Value**
Flexural strength	EN ISO 178	MPa	135 ± 10
Flexural elongation at break	EN ISO 178	%	4,6 ± 0,3
Flexural modulus	EN ISO 178	MPa	3675 ± 350
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	15 ± 3
Compressive strength	EN ISO 604	MPa	110 ± 10
Heat resistance (HDT)	DIN EN ISO 75 B	°C	93 ± 3
Glass transition temperature TG	method DSC	°C	-
Shore hardness	DIN ISO 7619-1	Shore D	85 ± 3
Coefficient of thermal expansion	internal test / Dilatometer	$10^{-6}K^{-1}$	ca. 73

Sales units (packages)

Packing size	A-Pack	OH 50 / Hardener 03	Resin 12 x 0,200 kg / Hardener 12 x 0,040 kg = 2,880 kg
Units	Resin	OH 50	20,000 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** ebaclean.

In General

ebalta OH 50 is an epoxy gelcoat with very good chemical resistance to solvents, especially to styrene. After curing the surface is well polishable, very smooth, dense and shiny.

For long potlife and good heat resistance of the moulds wer ecommend postcuring for 12-16 hrs. at 80 °C.

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.