

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
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>20</b>
Viscosity at 25°C	mPas	thixotrop	thxotrope	1200 ± 300
Density at 20°C	g / cm <sup>3</sup>	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 <sup>2</sup>	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 <sup>-6</sup> K <sup>-1</sup>	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** cleaning agent.

## 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 we recommend 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.

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.