

Basis	<b>Laminating resin</b>
Resin	<b>LH 22</b>
Hardener	
Colour	white
<b>Further hardeners</b>	<b>GL</b>

## Applications

- Control gauges
- Laminate molds
- Fixtures
- Foundry patterns

## Properties

- dimensionally accurate
- shorter potlife
- low exothermic character

## Processing data

Product		Mixture LH 22 / GR	Resin LH 22	Hardener
Colour		white	white	yellow
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>23</b>
Viscosity at 25°C	mPas	1300 ± 200	1800 ± 200	900 ± 0,02
Density at 20°C	g / cm <sup>3</sup>	1,35 ± 0,03	1,42 ± 0,03	1,00 ± 0,02
Pot life 200 g / 20°C	min.	25 - 30	-	-
Curing time at RT	hrs.	12 - 16	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	105 ± 10
Flexural elongation at break	EN ISO 178	%	3,4 ± 0,4
Flexural modulus	EN ISO 178	MPa	4300 ± 150
Flexural elongation at break	ISO 37	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	16 ± 3,5
Compressive strength	EN ISO 604	MPa	102 ± 0,8
Heat resistance (HDT)	DIN EN ISO 75 B	°C	65 ± 2
Shore hardness	DIN ISO 7619-1	Shore D	87 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-
Linear shrinkage	internal	%	-

## Sales units (packages)

Packing size	B-Pack	LH 22 / GR	resin 6 x 0,800 kg / hardener 6 x 0,184 kg = 5,904 kg
Units	Resin	LH 22	6,000 kg / 20,000 kg / 220,000

## Processing instructions

The temperature of material and processing should be between 18 and 25° C.

The mixing of resin and hardener should be made intensively and if possible without any bubbles at room temperature.

We recommend a post curing with a temperature rise of about 10°C/hour. Difficult geometries should be supported during the curing cycle. Afterwards the part should be cooled down at about 20°C/hour.

## Storing

At appropriate storage 18-25°C.

Occuring crystallization due to disadvantageous storage conditions can be made return by warming up the material at approx. 60° C for some hours.

Opened containers should be closed immediately after use and be protected against moisture. This material 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.

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