

Basis	<b>Porous backfilling system</b>
Resin	<b>PS 08</b>
Hardener	<b>TL-1</b>
Colour	alu grey

### Applications

- Bulking material for vacuum forming tools

### Properties

- aluminium filled
- glassfibre filled
- air permeable

### Processing data

Product		Mixture PS 08 / TL-1	Resin PS 08	Hardener TL-1
Colour		alu grey	grey	Yellowish transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>3</b>
Viscosity at 25°C	mPas	pasty	pasty	35 ± 10
Density at 20°C	g / cm <sup>3</sup>	1,75 ± 0,05	1,80 ± 0,05	0,940 ± 0,02
Pot life 200 g / 20°C	min.	45 - 60	-	-
Curing time at RT	hrs.	16 - 24	-	-
Post curing	Time in h/ Temperature in °C	10 - 12 / 50 - 60 3 - 6 / 90 - 110	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	10 ± 2
Flexural elongation at break	EN ISO 178	%	0,5 ± 0,06
Flexural modulus	EN ISO 178	MPa	2700 ± 355
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	2 ± 0,5
Compressive strength	EN ISO 604	MPa	16 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	80 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	84 ± 3
coefficient of thermal expansion	internal test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	-

### Sales units (packages)

Units	Resin	PS 08	25,000 kg
	hardener	TL-1	0,975 kg / 5,000 kg' / 50,000 kg

## Processing instructions

The mixing of the glass fiber and aluminium particle filled reinforcing paste PS 08 with the hardener TL should be made in a mechanical kneader. Smaller quantities can also be mixed with a spiral stirrer in a hand drilling gun or by hand. The mixed paste should be applied directly on the second still fresh surface layer or on the coupling layer and should be well compressed.

Heating and cooling coils can be inserted into the paste.

## In General

**ebalta** PS 08/TL-1 is an aluminium- and glass fiber consisting, temperature-resistant two-component-epoxy paste, which cures at room temperature.

After curing you get an air-permeable system.

**ebalta** PS 08/TL-1 can be applied in nearly any thickness. But the thickness for one operation should be only 50-70 mm and be compressed by stamping.

After a single post-curing at 50-60°C for 10-12 hours and 3-6 hours at 90-110°C the compact compound is temperature resistant up to 110°C.

Due to the very low content of resin, PS 08/TL-1 cures only very slowly within several days at room temperature. Therefore non-post-cured moulds should be set very slowly and gradually to working temperature range before first use.

## 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.

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.