

Basis **ebaboard 1204**

Colour yellow

### Applications

- Pattern plates
- Foundry patterns
- Core boxes

### Properties

- high abrasion resistance
- impact resistant
- dense surface
- good edge stability

### Processing data

<b>Product</b>	<b>ebaboard 1204</b>		
Colour	yellow		
Density at 20°C	g / cm <sup>3</sup>	1,20 ± 0,02	

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	120 ± 5
Flexural elongation at break	EN ISO 178	%	6,9 ± 0,5
Flexural modulus	EN ISO 178	MPa	2950 ± 300
Tensile strength	EN ISO 527-1	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	66 ± 9
Compressive strength	EN ISO 604	MPa	90 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	87 ± 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>	ca. 77
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	approx. 82
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 44

### Sales units (packages)

**ebaboard 1204**

1000 x 500 x 50 mm  
 1000 x 500 x 75 mm  
 1000 x 500 x 100 mm  
 Block material, eblock 1204  
 dimensions variable

## Processing instructions

Advices for machining of board material

- Making even of milling support
- Roughing of geometry
- Remove clamps, if possible allow to relax over night
- Clamping
- Finishing

For bonding and repairing we recommend our adhesive yellow as well as our repair putty yellow.

The repair putty can also be used as fast adhesive and can be mixed individually with the adhesive following the indications of a mixing table in order to set up the pot-life.

## In General

**ebaboard** material is available in specified sizes. The surface is machined on all sides. **ebaboard** is a synthetic, post-cured board material on polyurethane base. It has an even structure and plane parallel machined surfaces.

Advantages:

- Dense structure
- Good edge strength
- Low tension
- Good workability
- Low dust development when milling

Dimension tolerances of 3 mm in length and width and 0,5 mm in thickness are possible.

## Safety measure

**ebaboard** material is a cured filled polyaddition product, no hazardous dusts when grinding.  
According to regulations for hazardous goods **ebaboard** products don't have to be marked during transport and storage.

According to regulations for hazardous products all **ebaboard** products are not to be marked for transport and storage. Please follow safety advices !

## Waste Disposal

Small quantities can be disposed as domestic waste. For big quantities, contact your local authorities, please.

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.