

Basis **ebablock® 1350**

Colour blue

### Applications

- Foundry patterns
- Core boxes
- Pattern plates

### Properties

- low coefficient of thermal expansion
- high abrasion resistance
- very fine structure
- very well workable
- low generation of dust during machining
- high quality surface

### Processing data

<b>Product</b>	<b>ebablock® 1350</b>		
Colour	blue		
Density at 20°C	g / cm <sup>3</sup>	1,35 ± 0,03	

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	100 ± 5
Flexural elongation at break	EN ISO 178	%	4,7 ± 0,3
Flexural modulus	EN ISO 178	MPa	3840 ± 150
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	22 ± 2
Compressive strength	EN ISO 604	MPa	90 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	88 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	85 ± 3
coefficient of thermal expansion 20 - 50 °C	internatl test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	ca. 74
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	ca. 99

### Sales units (packages)

**ebablock® 1350**

Block, sizes variabel  
board material, ebaboard 1350  
1000 x 500 x 50 mm  
1000 x 500 x 75 mm  
1000 x 500 x 100 mm

## Processing instructions

Advices for machining of block material

- Making even of milling support
- Roughing of geometry
- Removing of clamps, if possible over night
- Clamping
- Finishing

Milling parameters available.

## In General

Due to its low weight this block material is best suitable for big moulds and medium numbers of castings.

**ebablock®** is available as non-machined boards and blank blocks.

Advantages:

dense structure

seamless

low stress/tension

available: contour shaped and variably shaped

Please add a sufficient measurement allowance for machining

We recommend to add 10 mm to each measurement

Dimensional deviations of 1-2% are possible.

Possible air bubbles or colour variations during casting. We cannot guarantee an absolutely bubble free casting of a block/blank. For a casting thickness of more than 400 mm or work-intensive contours we reserve the right to cast separate parts. Colour variations, air bubbles and joints don't mean inferior quality.

## Safety measure

**ebablock®** material is a cured filled polyaddition product, no hazardous dusts when grinding.

According to regulations for hazardous products all **ebablock®** 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 please contact your local authorities.

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.