

Basis	well polishable, heat resistant gel coat
Resin	
Hardener	Hardener 03
Colour	black

### Applications

- PU-foaming tools
- RIM foam tools
- Prepreg tools
- Bonding fixtures
- Vacuum forming tools

### Properties

- polishable
- grindable
- dense surface
- heat resistant

### Processing data

Product		Mixture OH 35 / Hardener 03	Resin	Hardener Hardener 03
Colour		black	black	yellow transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>12</b>
Viscosity at 25°C	mPas	thixotrope	thixotrop	1200 ± 300
Density at 20°C	g / cm <sup>3</sup>	1,63 ± 0,05	1,70 ± 0,05	1,06 ± 0,02
Pot life 200 g / 20°C	min.	15 - 20	-	-
Curing time at RT	hrs.	16 - 24	-	-
Post curing	Time in h/ Temperature in °C	24 / RT 8 / 80	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	99 ± 8
Flexural elongation at break	EN ISO 178	%	2 ± 0,5
Flexural modulus	EN ISO 178	MPa	5460 ± 87
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	11 ± 5
Compressive strength	EN ISO 604	MPa	123 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	101 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	91 ± 3

### Sales units (packages)

## Processing instructions

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

Due to its thixotropic consistency, the resin/ hardener mixture can be easily applied with a short-haired brush without bubbles and without running off on edges, corners and vertical surfaces. As soon as the gel coat has gelled, but is still slightly tacky you can proceed with your buildup. We recommend our coupling paste KP 6 / TGL as a coupling layer for the subsequent backing.

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before ( **ebalta** sealer).

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** ebaclean.

## In General

**ebalta** OH 35 is a gelcoat which yields a very dense surface.

Due to its good sandability, damaged areas can be repaired well without transitions.

Physical data mentioned in the data sheet are reached after a thermal treatment of 24 h at room temperature + 8 h at 80°C. We recommend to heat up and cool down at a rate of appr. 10°C/h.

Depending on the tooling geometry different parameters may be operated.

## 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.