

Product Type **High Quality PU Casting Resin**
 Resin **EB Flex 85 Comp. A**
 Hardener **EB Flex 85 Comp. B**
 Colour **Ivory**

Applications

- Decorative Parts
- Duplicate Masters
- Production Parts
- Models
- Patterns

Properties

- Flexible Shore A
- Low Exotherm
- Low Shrinkage
- Easy to Process

Processing Data

Product		Mixture EB Flex 85 A/B	Resin EB Flex 85 Comp. A	Hardener EB Flex 85 Comp. B
Colour		Ivory	Amber	Pale Amber
Mixing Ratio	P.B.W		100	100
	Volume		100	100
Viscosity at 25°C	cPs	500 - 700	600 - 1000	400 - 800
Density at 20°C	g / cm ³	1.06 +/- 0.04	1.06 +/- 0.4	1.06 +/- 0.04
Pot Life 100g / 20°C	Min.	Up To 6	-	-
Demould Time	Hrs.	2 - 4	-	-

Physical Data

Properties	Test Method	Unit	Value
Shore Hardness		Shore A	85
Specific Gravity			1.03
Tensile Strength		psi	1065
Elastic Modulus		psi	2700
Elongation		%	200
Tear Strength		pli	190

Sales Units (Packages)

Units	Resin	EB Flex 85 Comp. A	1.00 kg / 5.00 kg / 20.00 kg
	Hardener	EB Flex 85 Comp. B	1.00 kg / 5.00 kg / 20.00 kg

Processing Instructions

Prior to use only gentle agitation should be required to ensure the polyol component is completely mixed. The isocyanate component requires no agitation prior to use. Measure (by weight) the polyol and the isocyanate quantity required. Add the isocyanate to the polyol making sure that the required amount of isocyanate is transferred to the polyol.

Weighing tolerance of + or – 1% should be applied. Mix the two components thoroughly until mixing is complete, taking care to avoid excessive air-bubble inclusion. Mixed material should be degassed under full vacuum to remove air introduced during the mixing stage. Without degas the mixed material will contain air-bubbles and the final appearance and mechanical strength of the moulded part may be detrimentally affected

In General

Once mixed and degassed cast into mould at room temperature immediately. Castings should be de-mouldable after 2-4 hours at 20-30°C although they will not yet have reached full hardness. Care should be taken when demoulding items as the hardness and strength of the elastomer is still developing. Please allow up to 7 days for the achievement of full hardness. Use of release agent is required. Silicone release agents specifically designed for use with polyurethane are recommended. If in any doubt, please consult **ebalta** Distribution Technical Department.

Although not considered essential the use of an elevated temperature post-cure schedule will accelerate the cure and reduce the time taken to achieve final cure properties. **ebalta** Distribution suggest a cure schedule of 12- 16 hours at 60°C – 80°C. Alternatively, castings should be fully cured after 7 days at room temperature (20-30°C).

Low temperature will slow the rate of cure and so the end-user should avoid casting/curing this system in areas where the temperature is likely to fall below 15°C at any time.

Handling Precautions

For further questions, relating to processing and application, please contact our technical department. The end-user should always familiarise themselves with the material safety datasheets before use of these materials.

Storing

The polyol and isocyanate described in this instruction sheet have six-month shelf lives provided they are stored at 15 - 30°C in a dry place, out of direct sunlight and in suitable sealed containers, preferably those in which they are supplied. Neither component should be stored at a temperature above 40°C.

Shelf life is indicated on the labels.

tooling resins	.	blocks	.	ancillaries	.	silicone
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Safety Measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advice.

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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