

Basis universally usable gel coat  
Resin OH 4  
Hardener H 2017

Colour white  
Further colours blue

## Applications

- Negatives
- Master models
- Jigs
- Foundry patterns

## Properties

- universally applicable
- very good spreadable
- well grindable
- impact resistant surface

## Processing data

| Product               |                                    | Mixture<br>OH 4 / H 2017 | Resin<br>OH 4 | Hardener<br>H 2017 |
|-----------------------|------------------------------------|--------------------------|---------------|--------------------|
| Colour                |                                    | white                    | white         | amber              |
| Mixing ratio          | p. b. w.                           |                          | 100           | 13                 |
| Viscosity at 25°C     | mPas                               | thixotrop                | thixotrop     | 440 ± 100          |
| Density at 20°C       | g / cm <sup>3</sup>                | 1,39 ± 0,02              | 1,45 ± 0,02   | 1,04 ± 0,02        |
| Pot life 200 g / 20°C | min.                               | 20 - 25                  | -             | -                  |
| Curing time at RT     | hrs.                               | 12- 16                   | -             | -                  |
| Post curing           | Time in h/<br>Temperature in<br>°C | 24 / RT<br>+ 8 / 80      | -             | -                  |

## Physical data

| Properties                   | Inspect. requirem. | Unit              | Value      |
|------------------------------|--------------------|-------------------|------------|
| Flexural strength            | EN ISO 178         | MPa               | 100 ± 10   |
| Flexural elongation at break | EN ISO 178         | %                 | 2,5 ± 0,4  |
| Flexural modulus             | EN ISO 178         | MPa               | 4700 ± 100 |
| Impact resistance (Charpy)   | EN ISO 179         | kJ/m <sup>2</sup> | 16 ± 4     |
| Compressive strength         | EN ISO 604         | MPa               | 101 ± 5    |
| Shore hardness               | DIN ISO 7619-1     | Shore D           | 90 ± 3     |
| Heat resistance (HDT)        | DIN EN ISO 75 B    | °C                | 85 ± 5     |

## Sales units (packages)

|              |          |               |                                                       |
|--------------|----------|---------------|-------------------------------------------------------|
| Packing size | A-Pack   | OH 4 / H 2017 | 12 x 0,325 kg OH 4/12 x 0,045 kg VP H 2017 = 4,440 kg |
| Units        | Resin    | OH 4          | 6,000 kg/ 20,000 kg                                   |
|              | Hardener | H 2017        | 1,000 kg / 5,000 kg                                   |

## Processing instructions

The material and processing temperature 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 edges, corners and vertical surfaces.

As soon as the surface resin 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 use, the containers should be resealed.

Porous mould surfaces should be sealed first (e.g. **ebalta** Pore Sealer or **ebalta** Sealer 02).

For optimal mould release, we recommend a suitable release agent (e.g. T 1-1), which can be applied very easily with a brush.  
The mould should be coated 2-3 times and allowed to evaporate for approx. 20 min. after each application.

The mixing ratio of resin and hardener must be kept according to the instructions.  
Resin residues on stirring rods etc. can easily be cleaned with **ebalta** ebaclean.

## In General

**ebalta** OH 4 is an easy spreadable epoxy gel coat, curing at room temperature with almost no shrinkage.

After curing the gel coat is not brittle, the surface is well polishable.  
The physical data are achieved according to the thermal treatment specified on the front side under "Processing data".  
We recommend to heat up and cool down at a rate of approx. 10°C/h.  
Depending on the 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: see 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.