

# ebalta

*Distribution Ltd.*

## PRODUCT GUIDE



*Styling, Modelling and Tooling Boards*



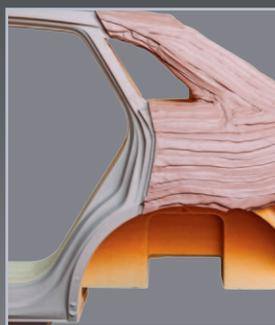
*Epoxy Tooling Boards*



*PU Casting Resin*



*Rapid Prototyping*



*Paste Materials*



*Epoxy Resins*



*Gel Coats*



*Silicones*



*Adhesives*



*Ancillaries*

**ebalta**

*Distribution Ltd.*

# Board and Block Material

# Board and Block Material

	Colour	Properties	Applications	Density g/cm <sup>3</sup>	Linear thermal expansion coefficient 10 <sup>-6</sup> K 20-50 °C	Temperature resistance Martens °C	Available sizes mm	Adhesive, repair putty and casting resins
<b>ebaboard L-1</b>	ochre	easy to work, good edge strength, good compressive strength	master / design models, laminating tools	0.45	approx. 66	92 ± 2	1500 x 500 x 50 / 75 / 100 / 200	<b>adhesive ochre</b>
<b>ebaboard 0600</b>	brown	dense surface, fine structure, easy to work	master models, design models, foundry patterns, vac form tooling	0.60	approx. 53	77 ± 5	1500 x 500 x 30 / 50 / 75 / 100 / 150 / 200	<b>adhesive and repair putty brown</b>
<b>ebaboard 0700</b>	brown	dense surface, very fine structure, easy to work	master models, foundry patterns, design models, vac form tooling	0.70	approx. 49	78 ± 3	1500 x 500 x 30 / 50 / 75 / 100 / 150 / 200	<b>adhesive and repair putty brown</b>
<b>ebaboard 0780</b>	turquoise	very fine structure, high strength values, good edge strength	master models, foundry patterns, laminating tools	0.78	approx. 63	86 ± 1	1500 x 500 x 50 / 75 / 100	<b>adhesive, repair putty and casting resin green</b>
<b>ebablock® M 007</b>	brown	dense surface, fine structure, easy to work	cubing / master / design models	0.82	approx. 67	68 ± 2	ebablock®: individual sizes	<b>adhesive and repair putty brown</b>
<b>ebaboard 1050</b> <b>ebablock® 1050</b>	light grey	easy to work, fine structure	foundry patterns, core boxes, jigs, vac form tooling	1.05	approx. 60	98 ± 3	ebaboard: 1000 x 500 x 50 / 75 / 100 ebablock®: individual sizes	<b>adhesive and repair putty light grey</b>
<b>ebaboard 1220</b>	orange	high abrasion resistance, dimensionally accurate	foundry patterns, core boxes pattern plates	1.21	approx. 73	82 ± 4	1000 x 500 x 50 / 75 / 100	<b>adhesive and repair putty orange</b>
<b>ebaboard PW 920</b> <b>ebablock® 920</b>	green	high quality surface, high abrasion resistance, good edge strength	foundry patterns, core boxes, pattern plates, vac form tooling, RIM tooling, hammer forms	1.22	approx. 87	80 ± 3	ebaboard: 1000 x 500 x 30 / 50 / 75 / 100 ebablock®: individual sizes	<b>adhesive, repair putty and casting resin green</b>
<b>ebaboard 1200</b> <b>ebablock® 1200</b>	beige	low thermal expansion, good edge strength, high quality surface	gauges, fixtures, moulding tools	1.25	approx. 54	97 ± 3	ebaboard: 1000 x 500 x 50 / 75 / 100 ebablock®: individual sizes	<b>adhesive and repair putty beige</b>
<b>ebablock® K 08</b>	orange	very high abrasion resistance, very shock resistant, dense surface	core boxes	1.35	approx. 150	-	ebablock®: individual sizes	<b>adhesive for Ebablock® K 08</b>
<b>ebaboard 1350</b> <b>ebablock® 1350</b>	blue	low coefficient of linear expansion, high abrasion resistance, very fine structure, easy to work	foundry patterns, core boxes, pattern plates	1.35	approx. 74	88 ± 3	ebaboard: 1000 x 500 x 50 / 75 / 100 ebablock®: individual sizes	<b>adhesive, repair putty and casting resin blue</b>
<b>ebaboard 1400</b> <b>ebablock® 1400</b>	blue	low thermal expansion, high abrasion resistance, fine structure, vac forming tooling, RIM tooling	foundry patterns, core boxes, pattern plates, vac form tooling, RIM tooling	1.38	approx. 69	87 ± 2	ebaboard: 1000 x 500 x 30 / 50 / 75 / 100 ebablock®: individual sizes	<b>adhesive, repair putty and casting resin blue</b>
<b>ebaboard 1700</b>	grey	good heat resistance, low thermal expansion	jigs, moulding tools, vac form tooling	1.70	approx. 45	85 ± 2	1000 x 500 x 50 / 75 / 100	<b>adhesive and repair putty grey</b>
<b>ebaboard 1750</b>	beige	low coefficient of linear expansion, good edge strength	jigs, moulding tools	1.75	approx. 43	90 ± 3	1000 x 500 x 50 / 75 / 100	<b>adhesive beige</b>
<b>ebaboard W</b> <b>ebablock® W</b>	grey	high strength, wear resistant, low thermal expansion	sheet metal forming, vac form tooling, hammer form tools, jigs, mould constructions	1.76	approx. 50	76 ± 2	ebaboard: 1000 x 500 x 50 / 75 / 100 ebablock®: individual sizes	<b>adhesive and repair putty grey</b>
<b>ebablock® P 185</b>	blue	low thermal expansion, high heat resistance	nickel shell models, tools for low temperature prepreg	1.86	approx. 39	115 ± 5	ebablock®: individual sizes	<b>adhesive and putty P 185 blue</b>

<b>ebazell 50</b>	light beige	very low weight, easy to work	styling models, negatives, base construction	0.05	approx. 41	-	2000 x 1000 x 50 / 75 / 100 further dimensions on request	<b>adhesive for ebazell Kieber 1K Foam Adhesive</b>
<b>ebazell 80</b>	light beige	fine structure, easy to work	styling models, master models, design models	0.08	approx. 58	-	2000 x 1250 x 50 / 100 / 150 / 200 / 300 / 400 further dimensions on request	<b>adhesive for ebazell Kieber 1K Foam Adhesive</b>
<b>ebazell 160</b>	light green	very fine structure, easy to work	master models, design models, arts and crafts	0.16	approx. 57	-	2000 x 1000 x 100 / 150 / 200 / 300 / 400 further dimensions on request	<b>adhesive for ebazell Kieber 1K Foam Adhesive</b>
<b>ebazell 260</b>	light grey	very fine structure, easy to work, dimensionally stable	master models, design models, arts and crafts	0.25	approx. 72	-	2000 x 1000 x 50 / 100 / 150 / 200 further dimensions on request	<b>adhesive for ebazell Kieber 1K Foam Adhesive</b>

ebaboard - board material | ebablock® - block material

ebaboard - board material | ebablock® - block material

ebazell | foam boards

ebazell | foam boards



epoxy boards	Colour	Properties	Applications	Density g/cm <sup>3</sup>	Heat Distortion Temperature °C	Coefficient of Thermal Expansion 10 <sup>-6</sup> /°C	Available sizes mm		Comments	
	EP 700	pink	excellent dimensional stability, low coefficient of thermal expansion, inert surface	master models, lay-up tools for low, medium temperature prepregs and vac form tooling	0.67	129	45	1524 x 609 x 50.8 1524 x 609 x 76.2	1524 x 609 x 101.6 1524 x 609 x 152.4	<i>suitable for use up to 129°C</i>
	EP 678	blue	excellent dimensional stability, low coefficient of thermal expansion, inert surface	master models, lay-up tools for low, medium temperature prepregs and vac form tooling	0.70	135	37	1524 x 609 x 50.8 1524 x 609 x 76.2	1524 x 609 x 101.6 1524 x 609 x 152.4	<i>suitable for use up to 135°C</i>
	TC 760	grey	excellent dimensional stability, low coefficient of thermal expansion, inert surface	master models, lay-up tools for low and medium temperature prepregs	0.74	145	34	1524 x 609 x 50.8 1524 x 609 x 76.2	1524 x 609 x 101.6 1524 x 609 x 152.4	<i>suitable for use up to 145°C</i>
	TC 460	purple	very high temperature resistance, excellent dimensional stability, low coefficient of thermal expansion, inert surface	master models, lay-up tools for low and medium temperature prepregs	0.74	232	31	1524 x 609 x 50.8 1524 x 609 x 76.2	1524 x 609 x 101.6 1524 x 609 x 152.4	<i>suitable for use up to 232°C</i>
	TB 650	green	premium quality, excellent dimensional stability, low coefficient of thermal expansion, inert surface	master models, lay-up tools for low and medium temperature prepregs	0.68	111	38	500 x 1000 x 123 500 x 1500 x 123	1000 x 1000 x 49 1000 x 1000 x 123	<i>suitable for use up to 120°C</i>
	TB 650HT	green	premium quality, excellent dimensional stability, low coefficient of thermal expansion, inert surface	master models, lay-up tools for low and medium temperature prepregs	0.69	155	42		1000 x 1000 x 49 1000 x 1000 x 123	<i>suitable for use up to 150°C</i>

sealer	Colour	Finish	Applications	Solids Content	Shelf Life	Flashpoint [°C]	Coverage	Pack Size	Comments
	ES 930	clear	high gloss	hand wipe or spray applied	15%	12 months	< 21	9-10 coats (20-25m <sup>2</sup> /L)	Pack size: 250ml & 1L

adhesives	Colour	Mixed Viscosity at 25°C cP	Pot Life at 25°C Mins	Mix Ratio by Weight	Shore D Hardness ASTM D-2240	Flexural Modulus ISO178 MPa	Coefficient of Thermal Expansion 10 <sup>-6</sup> /°C	Pack Size	Comments	
	EP 551	clear	1800	30	100 : 14	88	3275	48 x	5kg & 1kg kit	<i>clear, unfilled for use with EP 678, EP 700 and TB 650</i>
	EP 552	amber	thixotropic	25	100 : 28	68	2900	45	5kg & 1kg kit	<i>thixotropic for use with EP 678, EP 700 and TB 650</i>
	EP 553	grey	thixotropic	80	100 : 20	75	-	-	5kg kit	<i>thin bond line on all epoxy boards</i>
	EP 559	blue	thixotropic	25	100 : 8	68	2330	-	3.5kg kit	<i>low slump adhesive for all epoxy boards</i>
	EP 559-1	blue	thixotropic	80	100 : 12	68	2260	-	3.5kg kit	<i>low slump adhesive for all epoxy boards</i>
	EP 661	ivory	1900	30	100 : 40	85	2900	48	1Kg kit	<i>high temperature adhesive for all epoxy boards</i>

colour additives	Colour	Mixed Viscosity at 25°C cP	Pot Life at 25°C Mins	Mix Ratio by Weight (adhesive paste EP551 or EP552)	Shore D Hardness ASTM D-2240	Specific Gravity ASTM D-792	Coefficient of Thermal Expansion 10 <sup>-6</sup> /°C	Pack Size	Comments	
	CP 700	pink	1800/thixotropic	25 / 30	100 : 2	88 / 84	1.15 / 1.1	48 / 45	5g pack	<i>pink paste, for use with EP 700</i>
	CP 678	blue	1800/thixotropic	25 / 30	100 : 2	88 / 84	1.15 / 1.1	48 / 45	5g pack	<i>blue paste, for use with EP 678</i>
	CP 650	green	1800/thixotropic	25 / 30	100 : 2	88 / 84	1.15 / 1.1	48 / 45	5g pack	<i>green paste, for use with TB 650</i>

# Polyurethane Casting Resins

# Polyurethane Casting Resins

fast casting resins unfilled

Resin / Hardener	Properties + Applications				Special mixtures			
	Colour			Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio
SG 140 / PUR 11	ivory	unfilled, impact resistant, high strength	foundry patterns, core boxes, negatives, vacuum forming tools	2,5 - 3,5	100 : 100	SG 130 L	pot life 5 - 7 min.	100 : 100
						SG 131	pot life 9 - 15 min.	100 : 100
SG 140 / PUR 12	beige	high filler content possible, unfilled, high strength	foundry patterns, core boxes, negatives, control castings, vacuum forming tools	4 - 5	100 : 100	SG 140 L	pot life 7 - 9 min.	100 : 100
SG 141 / PUR 11	white	unfilled impact, resistant, high strength, long process time	foundry patterns, core boxes, negatives, control castings, vacuum forming tools	9 - 15	100 : 100	-	-	-
SG 145 A/B	beige	good strength, low shrinkage, low viscosity	foundry patterns, core boxes, negatives, control castings, vacuum forming tools	5 - 7	100 : 100	-	-	-
SG 197 A / B	ivory	high impact strength, easy to cast, low viscosity	prototypes, toys, decoration pieces, models, figurines	4 - 6	100 : 100	SG 198	pot life 2-3,5 Min	100 : 100
SG 2000 A / B	ivory	unfilled, very thin liquid, high filler content possible, good curing, very high strength, very heat resistant	foundry patterns, core boxes, negatives, control castings, models, figurines	2,5 - 3,5	100 : 100	SG 2000 S	pot life 1.5 - 2.5 min.	100 : 100
						SG 2000 L	pot life 7 - 8 min.	100 : 100
						SG 2015	pot life 14 - 18 min.	100 : 100
VP GM 1720 A / B	ivory	abrasion resistant, good impact strength, easy to pigment	climbing wall holds	7 - 10	100 : 70	-	-	-

fast casting resins filled

SG 150 A / B / C	grey	heat resistant, fast curing	vacuum forming tools, foam tools, polyester press tools	18 - 22	100 : 200 : 9 : 450	-	-	-
SG 600 / PUR 4	red	fine structure, easy to work, easy to cast	foundry patterns, core boxes, control castings, negatives	4 - 6	100 : 15	-	-	-
SG 700 / PUR 5	blue	easy to cast, fine structure, dimensionally accurate, fast curing, versatile	foundry patterns, core boxes, jigs, negatives, control castings	5 - 6	100 : 15	SG 700 A	abrasion resistant, pot life 5 - 7 min.	100 : 15
	black							
	white							
	red							
	green							
	brown							
ebatemp / PUR 5	alu-grey	very smooth surface, easy to polish, easy to work, easy to cast, aluminium filled	vacuum forming tools, foundry patterns, negatives	4,5 - 5,5	100 : 16	-	-	-

polyurethane casting resins flexible

Resin / Hardener	Properties + Applications				Special mixtures			
	Colour			Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio
GM 900-1 A / B	black	Shore A hardness 13, highly flexible, good tear propagation resistance	casting mould for gypsum, plastic, ceramic materials, wax	17 - 27	100 : 10	-	-	-
	beige							
GM 951-1 A / B	black	Shore A hardness 45, good tear propagation resistance, easy to cast	casting mould for gypsum, plastic, wax, ceramic materials, cement, gaskets	17 - 27	100 : 10	GM 951-Thix	50 Shore A, easy to brush	100 : 10
	beige							
GM 956 / GM 956-30	transparent	Shore A hardness about 30, Shore hardness (flexibility) variable, excellent flow properties, odourless	prototypes with rubber-like properties, flexible parts	20 - 30	100 : 205	GM 956-45	45 Shore A	100 : 180
						GM 956-60	60 Shore A	100 : 150
						GM 956-70	70 Shore A	100 : 110
						GM 956-80	83 Shore A	100 : 80
GM 956-90 A / B	transparent	Shore A hardness 90, Shore A hardness (flexibility) variable, excellent low properties, high tear strength, odourless	prototypes with rubber-like properties, flexible parts	-	100 : 125	-	-	-
GM 965-55 A / B	pink	Shore A hardness about 55, filled	casting moulds for ceramic, concrete, cement, gypsum	15 - 20	100 : 11	GM 965-40	Shore A hardness ca. 40	100 : 11,5
						GM 965-70	Shore A hardness ca. 70	100 : 15
GM 973 A / B	black	Shore A hardness 90, high tear strength, easy to cast, flexible	flexible parts, jigs	12 - 15	100 : 15	-	-	-
	beige							
GM 984-1 A / B	reddish transparent	Shore D hardness approx. 65, long pot life, large volumes, high abrasion resistance	core boxes, jigs	30 - 45	100 : 130	-	-	-
GM 984-2 A / B	reddish transparent	Shore D hardness approx. 67, very good dimensional stability, high abrasion resistance	core boxes, jigs	17 - 20	100 : 130	-	-	-
GM 986-1 A / B	yellow-opaque	Shore D hardness approx. 70, dimensionally stable at high temperatures, high abrasion resistance	foundry patterns, pattern plates	16 - 20	100 : 26	-	-	-
GM 987 A / B	orange-opaque	Shore D hardness approx. 65, excellent abrasion resistance	foundry patterns, pattern plates	14 - 17	100 : 21	-	-	-
EB Flex 40	ivory	Shore A40, low exotherm, low shrinkage, easy to process, easy to pigment	decorative parts, models, prototypes and production parts	4 - 6	100 : 100	-	-	-
EB Flex 50	ivory	Shore A50, low exotherm, low shrinkage, easy to process, easy to pigment	decorative parts, models, prototypes and production parts	4 - 6	100 : 100	-	-	-
EB Flex 60	ivory	Shore A60, low exotherm, low shrinkage, easy to process, easy to pigment	decorative parts, models, prototypes and production parts	4 - 6	100 : 100	-	-	-
EB Flex 70	ivory	Shore A70, low exotherm, low shrinkage, easy to process, easy to pigment	decorative parts, models, prototypes and production parts	4 - 6	100 : 100	-	-	-
EB Flex 85	ivory	Shore A80, low exotherm, low shrinkage, easy to process, easy to pigment	decorative parts, models, prototypes and production parts	4 - 6	100 : 100	-	-	-

# Polyurethane Casting Resins

# Paste Materials

polyurethane casting resins rigid

Resin / Hardener	Properties + Applications				Special mixtures			
	Colour			Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio
<b>GM 708 / PUR 4</b>	brown	unfilled, slow curing	sheet metal forming, foundry patterns, negatives, jigs	45 - 60	100 : 75	-	-	-
<b>GM 714 / PUR 4</b>	grey	cast thick sections, wear resistant, abrasion resistant, dimensionally accurate	foundry patterns, pattern plates and moulding tools	40 - 45	100 : 15	-	-	-
<b>GM 727 A/B</b>	beige	easy to work, thick easy to cast, dimensionally accurate, heat resistant	jigs, pattern plates foundry patterns, control casting, negatives	25 - 35	100 : 22	-	-	-
<b>GM 978 / D</b>	black white	very shock resistant, easy to cast, easy to cast until 8mm	prototypes with thermoplastic like properties, core boxes, foundry patterns	35 - 45	100 : 17	GL	thicker easy to cast	100 : 25
<b>GM 979 / PUR 1</b>	green	wear resistant, good compressive strength, impact resistant, heat resistant, excellent dissolving of mould and core sand properties	foundry patterns, core boxes, pattern plates, negatives	25 - 35	100 : 25	-	-	-
<b>HFG / PUR 11</b>	grey	very thick easy to cast, fast curing, impact resistant, dimensionally accurate, for large volume back fillings	backfilling for core boxes, backfilling for negatives	7 - 9	100 : 33	-	-	-

casting foams

<b>PU 20 A/B</b>	beige	density 200g/l, fine structure	styling models, core material, base constructions, negatives	60 - 90	100 : 90	-	-	-
<b>PU soft cast foam</b>	white	self skinning, excellent softness, resilient	prop making, lightweight models, theatrical sets	3 - 10	200 : 100	-	-	-
<b>PU gunn foam</b>	cream black	self skinning, can be processed by hand	prop making, lightweight models, theatrical sets	2 - 3	300 : 100	-	-	-
<b>PU 160</b>	dark cream	self skinning, high density, closed cell, rigid	deep water buoyancy, prop making, lightweight models and theatrical sets	3 - 4	87 : 100	PU 100	density 100	87 : 100
						PU 120	density 120	87 : 100

clear casting resin

<b>Clear Cast</b>	clear	UV stable, impact resistant, easy processing	transparent prototypes, art and decoration parts	8 - 15	100 : 100	medium	pot life 35 - 50 min	100 : 120
						slow	120 - 180 min	100 : 100

laminating pastes

Resin / Hardener	Properties + Applications				Special mixtures			
	Colour			Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio
<b>PS 03-1 resin / hardener</b>	blue grey	glassfibre filled, heat resistant until 68°C	core boxes, negatives, foundry patterns	40 - 50	100 : 11	-	-	-
<b>PS 05/TLB</b>	grey	glassfibre filled, low shrinkage, heat resistant until 105°C	vacuum forming tools, PU-foaming tools, prepreg tools	50 - 60	100 : 13	-	-	-
<b>PS 06 / TL</b>	alu-grey	heat resistant until 120°C, good conductivity, good compressive strength, glassfibre filled, aluminium filled	foam tools, polyester press tools, bulking compound for vacuum forming tools	50 - 60	100 : 4	-	-	-
<b>PS 07-1 / TM</b>	alu-grey	heat resistant until 175°C, glassfibre filled, aluminium filled	vacuum forming tools, prepreg tools	70 - 80	100 : 6	-	-	-
<b>PS 08 / TL</b>	alu-grey	aluminium filled, glassfibre-filled, air permeable	bulking material for vacuum forming tools	45 - 60	100 : 3	-	-	-

coupling pastes

<b>KP 6 / TGL</b>	grey	aluminium filled, heat resistant up to 100°C	coupling paste EP resin / backfilling	30 - 40	100 : 18	BR	coupling paste for OH 49 and EP-back filling	100 : 26
<b>KP 7-1 / TM</b>	grey	aluminium filled, heat resistant up to 175°C	coupling paste for OH 33/HM, OH 35/HM, OH 38/HM, OH 82-1/TM	240 - 360	100 : 32	-	-	-
<b>KP 8 A/B</b>	grey	easy to apply, good bonding agent	coupling paste hard elastic PU resin	20 - 25	100 : 28	-	-	-
<b>HV 55 / PUR 1</b>	green	good bonding on: steel, stainless steel, aluminium, flexible PU casting resins, wood	bonding agent and adhesive for matrix for elastic PU resins	25 - 35	100 : 25	-	-	-

modelling and lay-up pastes

<b>P 22 resin / hardener</b>	brown	good manual modelling, dimensionally accurate, very easy to work, long processing time	master models for the automotive field, aircraft construction, industrial design	40 - 50	100 : 100	-	-	-
<b>P 26 resin / hardener</b>	light brown	modelling EP lay-up paste, density 0,75 g/cm <sup>3</sup> , jointless, 10-35mm layer possible in one step, low exotherm, dimensionally stable, very easy to work, dense surface	close to final shape models for boat building, in the wind energy industry, aircraft industry, automotive industry	45 - 60	100 : 100	-	-	-
<b>P 26 repair paste</b>	light brown	easy to work, no sagging on vertical surface, fast curing	repair paste for P26, joint repair, surface correction	14 - 20	100 : 17	-	-	-

# Prototype and Component Resins

# Prototype and Component Resins

RIM casting systems

Systems	Resin	Colour	Properties	Mixing Ratio p.b.w	Properties in volume	Pot Life (sec.)	Curing time (min.)	Viscosity of mixture (mPas)	*Shore D	*Flexural modulus of elasticity (Mpa)	*Flexural strength (Mpa)	*Flexural strength at breakage (%)	Impact Resistance [Charpy] (kJ/m <sup>2</sup> )	Heat Resistance HDT (°C)	*TG in TMA TG (°C)
semi-rigid	MG 400 / PUR 19	black	very low E-modulus, very high impact strength, low viscosity	100 : 80	100 : 69	50 - 60	20 - 30	750	74	630	28	7,6	k.B.	n.a.	65
	MG 475 / PUR 19	black	low E-modulus, very high impact strength, low viscosity	100 : 90	100 : 77	100 - 120	30 - 40	750	76	1050	43	7,2	k.B.	n.a.	74
hard	MG 128 A/B	black	long pot life, hand pour	100 : 105	100 : 91	360 - 420	180 - 210	1000	83	2750	112	7	38	81	100
		natural													
	MG 425 / PUR 19	black	high impact resistance, low viscosity	100 : 90	100 : 77	50 - 60	20 - 30	750	75	1550	62	6,8	80	73	80
	MG 426 A/B	black	long pot life, high E-modulus	100 : 100	100 : 89	150 - 160	1,5 - 2 Std.	700	80	2185	85	7,0 k.B.	42	95	n.a.
	MG 453 A/B	black	short demoulding time, high heat resistance	100 : 75	100 : 66	55 - 66	10 - 15	n.a.	80	1640	65	7,4	38	102	124
glass fibre	MG 453 GFA/B	black	glassfibre filled, high heat resistance	100 : 60	100 : 61	55 - 60	10 - 15	n.a.	84	2510	90	6,2	18	108	124
flame retardant	MG 321 FR-S A/B	black	self extinguishing, UL 94 V0 and 5 VA high heat resistance 120°C classification accord. to DIN 5510-2	100 : 50	100 : 51	50 - 60	15 - 20	2000	80	2000	64	7,2	21	120	133
		natural													
	MG 321 FR A/B	black	self extinguishing, UL 94 V0 and 5 VA high heat resistance 120°C classification accord. to DIN 5510-2	100 : 50	100 : 51	70 - 80	20 - 30	2000	80	2000	64	7,2	21	120	133
		natural													
light foam	MG 454 A/B	black	lightly foaming, density under 1, glassfibre filled	100 : 60	100 : 57	60 - 80	**5 - 15	n.a.	77	2100	57	6,3	11	95	107

Comp. A = Polyole; Comp. B = Isocyanate individual pot life and colours enquiry n.b. non breaking \* max. values will be reached after post curing according to the technical data sheets \*\* heated moulds (40-50 °C)

RIM casting systems

vacuum casting systems

Systems	Prop	Colour	Properties	Mixing Ratio p.b.w	Pot life (min.)	Mould temperature (°C)	Curing time (min.)	*Shore hardness	*Flexible modulus (Mpa)	*Flexible strength (Mpa)	*Flexible strength at breakage (%)	*Impact resistance [Charpy] (kJ/m <sup>2</sup> )	*Heat resistance HDT (°C)	*Glass transition temp T <sub>g</sub> (°C)	
hard	MG 703/ Z 400	black	high impact strength	100 : 31	8 - 12	40 - 60	40 - 45	D 77	1340	52	-	77	81	105	
	MG 707/Z 400	white	middle E-modulus	100 : 30	8 - 12	40 - 60	40 - 45	D 79	1500	63	-	24	107	120	
	MG 804 A/B	black	high impact strength, very well easy to cast, long pot life	100 : 100	10 - 13	60 - 70	45 - 60	D 78	2270	90	6,2	39	71	82	
	MG 804 A / MG 804-1 B	black		100 : 100	8 - 11	60 - 70	45 - 60	D 75	1975	80	6,3	31	82	87	
	MG 804 A / 804 GFA / MG 804-1B	black	glassfibre filled, E-modulus variable	100 : 100 : 150	7 - 9	60 - 70	45 - 60	D 78	2600	78	4,9	17	89	90	
		black													
	MG 804 GFA / MG 804-1 B	natural	glassfibre filled, very high E-modulus 4400 Mpa	100 : 50	7 - 9	60 - 70	45 - 60	D 80	4400	85	2,5	13	76	82	
		black													
	MG 815 A / B	black	high heat resistance, HDT 130°C, very high impact resistance	100 : 70	5 - 7	70	40 - 60	D 80	2100	100	8,6	75	130	122	
	MG 815 A / MG 815 FR B	black	flame retardant acc. to UL 94 V0,	100 : 120	5 - 7	70	40 - 60	D 83	2770	70	4,5	18	120	122	
	MG 807 FR A / B	natural	flame retardant acc. to UL 94 V0, very high E-modulus	100 : 100	6	40 - 70	35 - 45	D 85	4000	70	2,2	7,3	52	79	
	MG 807	black	very high impact resistance, high E-modulus	100 : 94	3 - 4	40 - 50	60 - 90	D 80	2500	90	6,2	75	65	84	
semi	MG 822	transparent	high impact, high heat resistance, medium E-modulus	100 : 45	7	70	60	D 72	1150	45	9,0	no break	120	n.a.	
		black													

flexible	EB Flex 40	ivory	low Shore A, low exotherm, easy to pigment	flexible prototypes	Mixing Ratio p.b.w	Pot life (min.)	Demould time (hrs.)	*Shore hardness	Elastic modulus psi	Elongation %	Tear resistance (psi)	Tensile strength psi
	EB Flex 50	ivory	low Shore A, low exotherm, easy to pigment	flexible prototypes	100 : 100	4 - 6	2 - 4	A 50	160	200	50	250
	EB Flex 60	ivory	medium Shore A, low exotherm, easy to pigment	flexible prototypes	100 : 100	4 - 6	2 - 4	A 60	190	235	70	345
	EB Flex 70	ivory	medium Shore A, low exotherm, easy to pigment	flexible prototypes	100 : 100	4 - 6	2 - 4	A 70	915	170	130	730
	EB Flex 85	ivory	high Shore A, low exotherm, easy to pigment	flexible prototypes	100 : 100	4 - 6	2 - 4	A 85	2700	200	190	1065

clear	Clear Cast	clear	UV stable, impact resistant, easy processing	transparent prototypes, art and decorative parts	Mixing Ratio p.b.w	Pot life (min.)	Special mixtures: Type	Special mixtures: Properties	Special mixtures: Mixing ratio
					100 : 100	8 - 15	medium	pot life: 35 - 50 min	100 : 120
							slow	pot life: 120 - 180 min	100 : 100

\* max. values will be reached after post curing according to the technical data sheets \*\* processing at room temperature possible

infiltrants

System	Prop	Colour	Properties	Applications	Mixing Ratio p.b.w	Pot life (min.)	Curing time (hrs.)	*Shore hardness	*Flexible modulus (Mpa)	*Flexible strength (Mpa)	*Flexible strength at breakage (%)	*Impact resistance [Charpy] (kJ/m <sup>2</sup> )	*Heat resistance HDT (°C)
3D printing	IH 16 Hardener Slow	clear	very long flow paths, very low viscosity, good wet-out characteristics	infiltration of 3D printed parts	100 : 30	300 - 400	36 - 48	D 85	3400	125	5,9	60	79
	IH 16 Hardener Fast	clear	very long flow paths, very low viscosity, good wet-out characteristic	infiltration of 3D printed parts	100 : 30	50 - 60	20 - 30	D 85	3520	135	5,8	47	78
	IH 16 Hardener Very Fast	clear	for machine processing, very low viscosity, good wet-out characteristic	infiltration of 3D printed parts	100 : 30	15 - 25	14 - 20	D 85	-	140	-	-	-

infiltrants

# Epoxy Resins

epoxy casting resins

Resin / Hardener	Properties + Applications				Special mixtures		
	Colour		Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio
<b>GH 705 /TL</b>	alu-grey	high heat resistance, aluminium-like	65 - 75	100 : 10	-	-	-
<b>GH 706 /GL</b>	blue	abrasion resistant, very hard, wear resistant, good compressive strength	30 - 40	100 : 10	-	-	-
<b>GH 706 /GLE</b>	blue	abrasion resistant, fine structure, good compressive strength, very hard, wear resistant, easy to cast, easy to cast up to 15mm	30 - 40	100 : 18	GL	thickly easy to cast	100 : 10
<b>GH 723 /D</b>	green	low viscosity, very easy to cast, well workable	55 - 65	100 : 7	-	-	-
<b>GH 730 /BR</b>	black	impact resistant, versatile	35 - 45	100 : 10	D GL CH2-Gel	thin liquid longer pot life easy to brush	100 : 5 100 : 8 100 : 7,5
<b>VF 2000 A/B</b>	alu-grey	heat resistant, well workable, very good ability to flow	100 - 120	100 : 10	-	-	-
<b>GH 760 /GL</b>	grey	dimensionally accurate, abrasion resistant, high strength, easy to cast up to 40mm, very good sliding properties	45 - 55	100 : 10	CH2-Gel	easy to brush	100 : 7,5
<b>GH 761 /D</b>	black	low viscosity, easy to cast	50 - 60	100 : 5	GL	thickly easy to cast	100 : 8
<b>GH 767 /GL</b>	green	workable, easy to cast up to 50mm	25 - 35	100 : 8	BR	impact resistant	100 : 10
<b>GH 781 / GH 781 S</b>	grey	heat resistant, short curing time, high strength, low thermal expansion	90 - 110	100 : 5	GH 781	longer processing time	100 : 5

# Epoxy Resins

general purpose and laminating resins

Resin / Hardener	Properties + Applications				Special mixtures		
	Colour		Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio
<b>AH 100 /TG</b>	yellow transparent	unfilled, low cost, low viscosity	40 - 50	100 : 20	D GL	high filler content possible versatile	100 : 19 100 : 29
<b>AH 110 /TL</b>	yellow transparent	unfilled, high strength, high heat resistance up to 100°C	85 - 95	100 : 24	TGL TGS	good curing fast curing	100 : 22 100 : 22
<b>AH 120 /TL</b>	white/ semi opaque	unfilled, high heat resistance up to 98°C, high strength	80 - 90	100 : 25	TGL LI 130-2	good curing long pot life	100 : 22 100 : 35
<b>AH 140 / TC 90-1</b>	yellow transparent	very thin liquid, good curing at room temperature, high heat resistance up to 100°C	90 - 105	100 : 32	LI 20 LI 130-2	cures tack free, high heat resistance	100 : 35 100 : 35
<b>AH 150 / IP 55</b>	yellow transparent	very low viscosity, good fibre wetting, long flow paths, low price	50 - 60	100 : 30	IP 25 IP 430	pot life 14 - 20 pot life 300 - 420min.	100 : 30 100 : 30
<b>AH 219 system</b>	yellow transparent	low viscosity, curing at room temperature, multi purpose resing system	25 - 360	100 : 50	accelerator	extends or reduces pot life	-
<b>LH 22 /GL</b>	white	excellent dimensional accuracy, long pot life, low exothermic character	40 - 45	100 : 25	GR	shorter pot life	100 : 23
<b>LH 25 resin/ hardener</b>	white	flammability classification S 4, smoke emission class SR-2, drippability class ST-2, dimensionally accurate	50 - 60	100 : 15	-	-	-
<b>LH 28-1 /TM</b>	brown transparent	high heat resistance up to 175°C, long processing time, low exothermic character	240 - 360	100 : 40	-	-	-
<b>LH 30 resin/ hardener</b>	brown transparent	low exothermic character, long processing time, very high heat resistance up to 181°C	160 - 200	100 : 42	-	-	-

# Gel Coats

Resin / Hardener	Properties + Applications				Special mixtures				
	Colour		Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio		
<b>OH 4 / CH-1</b>	white	universal, very good spreadable, good grinding, impact resistant surface	negatives, master models, jigs, foundry patterns	15 - 20	100 : 16	-	-	-	
<b>OH 4 / SL</b>	white	easy to spread, impact resistant, easy to grind, longer processing time	negatives, master models, jigs, foundry patterns	25 - 30	100 : 14	-	-	-	
	blue								
<b>OH 6-1 / CH-1</b>	blue	fine structure, very abrasion resistant, very hard	foundry patterns, coping models	20 - 25	100 : 11	-	-	-	
<b>OH 12 / CH2-Gel</b>	beige	very shock resistant, abrasion resistant, resistant	core boxes, pattern plates, foundry patterns, boards	20 - 25	100 : 17	-	-	-	
<b>OH 20/CH1</b>	red	fine structure, easy to work, easy to apply	master models, cubing models	15 - 20	100 : 15	-	-	-	
	brown								
<b>OH 20/CH2</b>	red	fine structure, easy to work, easy to apply	master models, carving mock ups	30 - 35	100 : 15	-	-	-	
	brown								
<b>OH 20 / CH-2 gel</b>	red	fine structure, jointless surface, well workable, well spreadable	master models, design models	30 - 35	100 : 15	-	-	-	
	brown								
<b>OH 30 resin / hardener</b>	black	long processing time, very high heat resistance until 170°C	high temperature resistant laminating tools, prepreg tools	160 - 200	100 : 20	-	-	-	
<b>OH 33 / CH-1</b>	black	styrene resistant, resistant against solvent, good grinding, dense surface	RTM tools, polyester tools, hand lay-up models	20 - 30	100 : 19	-	-	-	
<b>OH 35 / CH-1</b>	black	chemical resistant, easy to polish, grinding possible, dense surface, heat resistant	PU-foaming tools, RIM foam tools, polyester press forms, prepreg tools	20 - 30	100 : 16	-	-	-	
<b>OH 38 / CH-1</b>	alu-grey	chemical resistant, easy to polish	vacuum forming tools, PU-foaming tools, prepreg tools	20 - 30	100 : 15	-	-	-	
<b>OH 50 / hardener 03</b>	black	styrene resistant, chemical resistant, very dense surface, easy to polish	RTM tools, polyester tools, hand lay-up models	12 - 18	100 : 20	-	-	-	
<b>OH 82 / TM</b>	black	very low thermal expansion, very high heat resistance up to 175°C, dimensionally accurate	prepreg tools	220 - 260	100 : 31	-	-	-	
<b>PU gel coats</b>	<b>OH 11 / PUR 3</b>	red oxide	abrasion resistant, impact resistant, excellent dissolving properties of mould and core sand, on polyurethane base	foundry patterns, core boxes	20 - 25	100 : 40	OH 11 hard	very hard, tough	100 : 30
	<b>OH 11-hard / PUR 1</b>	red oxide	very resistant, abrasion & impact resistant, excellent dissolving properties of mould and core sand	pattern plates, foundry patterns, core boxes	20 - 25	100 : 30	-	-	-
	<b>OH 49 A/B</b>	green	very abrasion resistant, hard elastic, Shore D hardness approx. 66	foundry patterns, core boxes	12 - 16	100 : 36	-	-	-

epoxy gel coats

PU gel coats

# Silicone Casting Systems

Resin / Hardener	Properties + Applications				Special mixtures			
	Colour		Pot life approx. min.	Mixing ratio p.b.w.	Type	Properties	Mixing ratio	
<b>SR 15</b>	dark pink	condensation curing, 15 Shore A, long mould working life	flexible moulds for casting, gypsum, wax, plastics, encasing of electrical oil bleeding components	60 - 90	100 : 10	-	-	-
<b>SR 2-1</b>	blue	condensation curing, 24 Shore A, universal	flexible moulds, skin-like moulds	90 - 120	100 : 10	catalyst slow	slow curing red	100 : 10
						catalyst fast	very fast curing green	100 : 10
<b>SR 30</b>	white	condensation curing, 27 Shore A, long working life	flexible moulds for casting plastics, wax, gypsum and polyester resin	60 - 90	100 : 5	-	-	-
<b>SR 4</b>	transparent	addition curing, 38 Shore A	flexible moulds for casting, vacuum casting, gypsum, wax, plastics, encasing of electrical oil bleeding components	90	100 : 10	-	-	-
<b>SR 6</b>	blue	addition curing, 59 Shore A	flexible moulds for vacuum forming, gypsum, wax, plastic, casting of electrical parts, polyamide casting	60	100 : 10	-	-	-
<b>SR 2 Accelerator</b>	transparent	-	changes the curing time and pot life of SR 2-1	-	1-3 %	-	-	-
<b>SR 2-1 Thixotropic</b>	transparent	thixotropic	adjust silicones for spraying and brush application, thicken	-	1-3 %	-	-	-

Other Shore A hardness available on request. Silicone pigments available on request.

silicones



crestabond adhesives

crestabond adhesives

Product	Description	Colour	Mix ratio by volume	Viscosity (cP)	Working time (mins)	Fixture Time (mins)*	Elongation at break (%)	Tensile Strength (MPa)	Tensile Modulus (MPa)	Gap Fill	Adhesive + Activator	GRP	Stainless Steel	Aluminium	Powder Coated Steel	Cold Rolled Steel	Galvanised	ABS	Acrylic	Poly-carbonate	PVC	PP/PE & TPO
M1-02	universal bonder	grey	10 : 1	100K - 140K	1 - 2	2 - 3	80 - 100	12 - 16	600 - 1000	1 - 15	M1-02 Adhesive + Activator 4	•	•	•	•	•	•	•	•	•	•	•
M1-04	universal bonder	grey	10 : 1	100K - 140K	3 - 5	8 - 10	80 - 100	16 - 20	600 - 1000	1 - 15	M1-05 Adhesive + Activator 4	•	•	•	•	•	•	•	•	•	•	•
M1-05	universal bonder	grey black	10 : 1	100K - 140K	4 - 7	12 - 18	80 - 100	16 - 20	600 - 1000	1 - 15	M1-05 Adhesive + Activator 1 or Activator 1 Black	•	•	•	•	•	•	•	•	•	•	•
M1-10	universal bonder	black	10 : 1	100K - 140K	8 - 12	16 - 23	80 - 100	16 - 20	600 - 1000	1 - 15	M1-10 Adhesive + Activator 1 or Activator 1 Black	•	•	•	•	•	•	•	•	•	•	•
M1-20	universal bonder	grey black	10 : 1	100K - 140K	16 - 22	25 - 35	80 - 100	16 - 20	600 - 1000	1 - 25	M1-20 Adhesive + Activator 1 or Activator 1 Black	•	•	•	•	•	•	•	•	•	•	•
M1-30	universal bonder	grey black	10 : 1	200K - 240K	25 - 35	60 - 80	100 - 130	18 - 22	600 - 1000	1 - 50	M1-30 Adhesive + Activator 1 or Activator 1 Black	•	•	•	•	•	•	•	•	•	•	•
M1-60HV	universal bonder	green	10 : 1	340K - 380K	50 - 70	150 - 180	50 - 70	22 - 26	1200 - 1600	1 - 50	M1-60HV Adhesive + Activator 2 Green	•	•	•	•	•	•	•	•	•	•	•
M1-90HV	universal bonder	green	10 : 1	340K - 380K	80 - 100	210 - 240	50 - 70	22 - 26	1200 - 1600	1 - 50	M1-90HV Adhesive + Activator 2 Green	•	•	•	•	•	•	•	•	•	•	•
M7-05	universal bonder	off white black	1 : 1	30K - 70K	4 - 7	18 - 22	25 - 30	22 - 25	1200 - 1700	1 - 5	M7-05 Adhesive or M7-05 Adhesive Black + M7-05/15 Activator	•	•	•	•	•	•	•	•	•	•	•
M7-15	universal bonder	off white black	1 : 1	30K - 70K	10 - 20	30 - 45	25 - 30	22 - 25	1200 - 1700	1 - 5	M7-15 Adhesive or M7-15 Adhesive Black + M7-05/15 Activator	•	•	•	•	•	•	•	•	•	•	•
PP-04	low surface energy bonder	off white	1 : 1	150K - 200K	3 - 5	25 - 125	2 - 5	12 - 17	800 - 1200	0.5 - 5	Adhesive for difficult to bond plastic substrates	•	•	•	•	•	•	•	•	•	•	•





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*C3, Ford Airfield Ind. Est.  
Arundel, West Sussex  
United Kingdom  
BN18 0HY*

*Phone +44 (0)1243 53 99 10  
Fax +44 (0)1243 53 66 91  
Email [sales@ebaltadistribution.co.uk](mailto:sales@ebaltadistribution.co.uk)  
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