

Basis	ebaboard 1204
Colour	yellow
Further colours	black

Applications

- Pattern plates
- Foundry patterns
- Core boxes

Properties

- high abrasion resistance
- impact resistant
- dense surface
- good edge strength

Processing data

Product	ebaboard 1204		
Colour	yellow		
Density at 20°C	g / cm ³	1,20 ± 0,02	

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	120 ± 5
Flexural elongation at break	EN ISO 178	%	6,9 ± 0,5
Flexural modulus	EN ISO 178	MPa	2950 ± 300
Tensile strength	EN ISO 527	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	66 ± 9
Compressive strength	EN ISO 604	MPa	90 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	87 ± 3
Shore hardness	DIN ISO 7619-1	Shore D	84 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	ca. 77
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 105

Sales units (packages)

ebaboard 1204	1000 x 500 x 50 mm
	1000 x 500 x 75 mm
	1000 x 500 x 100 mm
	Block material, ebablock 1204
	dimensions variable

Processing instructions

Advices for machining of board material

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

For bonding and repairing we recommend our adhesive yellow as well as our repair putty yellow.

The repair putty can also be used as fast adhesive and can be mixed individually with the adhesive following the indications of a mixing table in order to set up the pot-life.

For changes we recommend the casting compound yellow

In General

ebaboard material is available in specified sizes. The surface is machined on all sides. **ebaboard** is a synthetic, post-cured board material on polyurethane base. It has an even structure and plane parallel machined surfaces.

Advantages:

- Dense structure
- Good edge strength
- Low tension
- Good workability
- Low dust development when milling

Dimension tolerances of 3 mm in length and width and 0,5 mm in thickness are possible.

Safety measure

ebaboard material is a cured filled polyaddition product, no hazardous dusts when grinding. Anyway the quantity of dusts coming from mechanical treatment of wood and metal 6 mg/m³ (MAC-value)- must not be exceeded.

According to regulations for hazardous goods **ebaboard** products don't have to be marked during transport and storage.

According to regulations for hazardous products all **ebaboard** 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, contact your local authorities, please.

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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