

Basis **ebaboard 1400**

Colour **blue**

### Applications

- Foundry patterns
- Core boxes
- Pattern plates

### Properties

- low thermal expansion
- high abrasion resistance
- fine structure
- well workable

### Processing data

<b>Product</b>	<b>ebaboard 1400</b>		
Colour	blue		
Density at 20°C	g / cm <sup>3</sup>	1,38 ± 0,03	

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	109 ± 5
Flexural elongation at break	EN ISO 178	%	3,8 ± 0,15
Flexural modulus	EN ISO 178	MPa	4175 ± 100
Tensile strength	EN ISO 527-1	MPa	-
Elongation at break	ISO 37	%	-
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	19,5 ± 2
Compressive strength	EN ISO 604	MPa	102 ± 5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	87 ± 2
Shore hardness	DIN ISO 7619-1	Shore D	85 ± 3
coefficient of thermal expansion 20 - 50 °C	internatl test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	ca. 69
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	ca. 99
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 62

### Sales units (packages)

**ebaboard 1400**

1000 x 500 x 30 mm  
1000 x 500 x 50 mm  
1000 x 500 x 75 mm  
1000 x 500 x 100 mm

blockmaterial, eblock 1400  
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 blue as well as our repair putty blue.

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.

Milling parameter completed for download on our homepage.

## 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.  
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.

**ebalta** Kunststoff GmbH . Erlbacher Straße 100 . 91541 Rothenburg ob der Tauber / Germany  
Tel.: +49 9861 7007-0 . Fax: +49 9861 7007-77 . info@**ebalta**.de . www.**ebalta**.de