

Basis	
Resin	<b>GH 730</b>
Hardener	<b>D</b>
Colour	black

### Applications

- Foundry patterns
- Core boxes
- Pattern plates
- fixtures
- Negatives

### Properties

- well castable
- versatile
- impact resistant

### Processing data

Product		Mixture GH 730 / D	Resin GH 730	Hardener D
Colour		black	black	colourless
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>5</b>
Viscosity at 25°C	mPas	8000 ± 1000	18000 ± 3000	5 ± 2
Density at 20°C	g / cm <sup>3</sup>	2,40 ± 0,10	2,50 ± 0,10	0,87 ± 0,02
Pot life 200 g / 20°C	min.	35 - 45	-	-
Curing time at RT	hrs.	10 - 14	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	80 ± 5
Flexural strength at breakage	EN ISO 178	%	1,0 ± 0,2
Flexural modulus	EN ISO 178	MPa	9500 ± 600
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	5 ± 2
Compressive strength	EN ISO 604	MPa	110 ± 10
Heat resistance (Martens)	DIN 53458	°C	57 ± 2
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	ca. 45
Linear shrinkage	internal	%	-

### Sales units (packages)

Units	Resin	GH 730	8,000 kg / 25,000 kg
	Hardener	D	4,000 kg

## Processing instructions

The temperature of material and processing should be between 18 and 25° C.

Filled systems should be stirred thoroughly before use.

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before ( **ebalta** sealant ).

For an optimum mould release we recommend a suitable release agent (e.g. T 1-1) which can be easily applied with a brush.

The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

To get a clean component part, we recommend upward flow casting and to take care of sufficient venting.

Resin residues at stirring rods and so on can be easily cleaned with our cleaning agent.

## 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 is indicated on the 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.

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