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| Basis | Dimensionally accurate, very wear resistant casting resin |
| Resin | GM 714 Komp. A |
| Hardener | PUR 4 Comp. B |
| Colour | grey |

Applications

- Foundry patterns
- Pattern plates
- Moulding tools

Properties

- very thick castable
- wear resistant
- dimensionally accurate
- abrasion resistant
- versatile

Processing data

| Product | | Mixture GM 714 / PUR 4 | Resin GM 714 Komp. A | Hardener PUR 4 Comp. B |
|-----------------------|---------------------|---------------------------|-------------------------|---------------------------|
| Colour | | grey | light grey | brown |
| Mixing ratio | p. b. w. | | 100 | 15 |
| Viscosity at 25°C | mPas | 5500 - 500 | - | 90 ± 20 |
| Density at 20°C | g / cm ³ | 2,1 ± 0,05 | 2,30 ± 0,05 | 1,22 ± 0,02 |
| Pot life 200 g / 20°C | min. | 40 - 45 | - | - |
| Curing time at RT | hrs. | 12 - 18 | - | - |

Physical data

| Properties | Inspect. requirem. | Unit | Value |
|--|--------------------|----------------------------------|-------------|
| Flexural strength | EN ISO 178 | MPa | 60 ± 5 |
| Flexural modulus | EN ISO 178 | MPa | 6250 ± 170 |
| Flexural strength at breakage | EN ISO 178 | % | 2,00 ± 0,30 |
| Tensile strength | EN ISO 527 | MPa | - |
| Elongation | EN ISO 527 | % | - |
| Compressive strength | EN ISO 604 | MPa | 63 ± 5 |
| Impact resistance (Charpy) | EN ISO 179 | kJ/m ² | 5,3 ± 0,6 |
| Heat resistance (Martens) | DIN 53458 | °C | 38 ± 3 |
| TG in TMA T _G | Methode TMA | °C | - |
| Shore hardness | DIN 53505 | Shore D | 88 ± 3 |
| Coefficient of linear expansion | DIN 53752 | 10 ⁻⁶ K ⁻¹ | - |
| Linear shrinkage | internal | % | - |
| Abrasion Taber Abraser CS 17 Application weight 1000g / 500 Rotations | internal | mg | 41 |

Sales units (packages)

| | | | |
|-------|----------|----------------|---------------------|
| Units | Resin | GM 714 Komp. A | 20,000 kg |
| | Hardener | PUR 4 Comp. B | 3,000 kg / 6,000 kg |

Processing instructions

Material- and processing temperature: between 18 - 25 °C.

Close containers after use.

Seal porous mould surfaces first (**ebalta** mould sealer).

For optimum mould releasing we recommend a special release agent (like T1-1), which can be applied easily with a brush or be sprayed. Releasing of the mould 2-3 times, evaporate for about 20 min. after each releasing.

Mixing ratio resin/hardener according to instructions.

Stirring rods etc. with residual resin can be easily cleaned with **ebalta** cleaning agent.

In General

ebalta GM 714 is a slow-curing versatile 2-components polyurethane casting compound.

It's wear resistant, shows low shrinkage and for this reason it's very suitable for sheet metal forming moulds and big volume moulds for solid casting.

Storing

At appropriate storage (18 - 25 °C) in closed original container 6 months.

Already opened containers should be closed immediately after use and be protected against moisture. This material should be used up as soon as possible.

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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