

Basis	dimensionally very accurate slowly-curing casting compound
Resin	GM 725-7 Comp. A
Hardener	PUR 4 Comp. B
Colour	beige
Further colours	green, grey

Applications

- Sheet metal forming
- fixtures
- Pattern plates
- Foundry patterns
- Control castings
- Negatives

Properties

- thick castable
- very high strength
- dimensionally accurate
- workable

Processing data

Product		Mixture GM 725-7 / PUR 4	Resin GM 725-7 Comp. A	Hardener PUR 4 Comp. B
Colour		beige	beige	brown
Mixing ratio	p. b. w.		100	15
Viscosity at 25°C	mPas	11000 ± 2000	pasty	90 ± 20
Density at 20°C	g / cm ³	1,75 ± 0,05	1,85 ± 0,05	1,22 ± 0,02
Pot life 200 g / 20°C	min.	20 ± 2	-	-
Curing time at RT	hrs.	12 - 16	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	56 ± 5
Flexural strength at breakage	EN ISO 178	%	1,0 ± 0,1
Flexural modulus	EN ISO 178	MPa	8620 ± 800
Tensile strength	EN ISO 527	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	3,5 ± 0,5
Compressive strength	EN ISO 604	MPa	84 ± 8
Heat resistance (HDT)	DIN EN ISO 75 B	°C	56 ± 2
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	ca. 52
Linear shrinkage	internal	%	-
Tear resistance / angle test piece	EN ISO 34-1	kN/m	-
Elongation	EN ISO 527	%	-
Wear jet test	internal tests	W(V/t) [mm ³ /min]	ca. 182

Sales units (packages)

Units	Resin	GM 725-7 Comp. A	5,000 kg / 15,000 kg / 30,000 kg
	Comp. B	PUR 4 Comp. B	1,000 kg / 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

This product is a polyurethane system.

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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