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| Basis | Wear resistant, well moldable casting resin |
| Resin | GM 979 neu Comp. A |
| Hardener | PUR 1 Comp. B |
| Colour | green |
| Further colours | beige |

Applications

- Pattern plates
- Foundry patterns
- Core boxes
- Negatives

Properties

- wear resistant
- good compressive strength
- impact resistant
- heat resistant
- excellent dissolving of mould and core sand properties

Processing data

| Product | | Mixture GM 979 new / PUR 1 | Resin GM 979 neu Comp. A | Hardener PUR 1 Comp. B |
|-----------------------|---------------------|-------------------------------|-----------------------------|---------------------------|
| Colour | | green | green | brown |
| Mixing ratio | p. b. w. | | 100 | 25 |
| Viscosity at 25°C | mPas | 6500 ± 800 | 25000 ± 5000 | 100 ± 30 |
| Density at 20°C | g / cm ³ | 1,65 ± 0,05 | 1,73 ± 0,05 | 1,24 ± 0,02 |
| Pot life 200 g / 20°C | min. | 25 - 35 | - | - |
| Curing time at RT | hrs. | 8 - 12 | - | - |

Physical data

| Properties | Inspect. requirem. | Unit | Value |
|--|--------------------|-------------------|------------|
| Flexural strength | EN ISO 178 | MPa | 68 ± 5 |
| Flexural modulus | EN ISO 178 | MPa | 6700 ± 500 |
| Flexural strength at breakage | EN ISO 178 | % | 1,20 ± 0,1 |
| Tensile strength | EN ISO 527 | MPa | - |
| Elongation | EN ISO 527 | % | - |
| Compressive strength | EN ISO 604 | MPa | 85 ± 5 |
| Impact resistance (Charpy) | EN ISO 179 | kJ/m ² | 5,5 ± 0,5 |
| Heat resistance (HDT) | DIN EN ISO 75 B | °C | 80 ± 3 |
| Shore hardness | DIN 53505 | Shore D | 90 ± 3 |
| Linear shrinkage | internal | % | - |
| Abrasion Taber Abraser H 18 Application weight 500g / 250 Rotations | internal | mg | ca. 125 |

Sales units (packages)

| | | | |
|--------------|---------------------|-------------------------------------|---|
| Packing size | B-Pack | GM 979 new / PUR 1 | resin 6 x 0,960 kg / hardener 6 x 0,240 kg = 7,200 kg |
| Units | Comp. A Hardener | GM 979 neu Comp. A PUR 1 Comp. B | 25 kg 1,500 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

ebalta GM 979 new is an easy-to-handle-2components-polyurethane casting compound which shows very low adhesive properties compared to moulding sand. Due to its high abrasion resistance, GM 979 new is especially suitable for foundry patterns, which have to resist to abrasive wear by moulded sand. GM 979 new even keeps its high mechanical strength when using moulding sands with higher temperatures.

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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