

Basis	<b>PU casting resin</b>
Resin	<b>GM 985-1 Comp. A (Iso)</b>
Hardener	<b>GM 985-1 Comp. B (Amine)</b>
Colour	grey
Further colours	brownish-transparent

### Applications

- Foundry patterns
- Pattern plates
- Core boxes
- fixtures

### Properties

- non-toxic according to regulations for hazardous material
- Shore D hardness approx. 68
- hard flexible
- well castable
- no brittleness phase
- very abrasion resistant

### Processing data

Product		Mixture GM 985-1 / Comp. A+B	Resin GM 985-1 Comp. A (Iso)	Hardener GM 985-1 Comp. B (Amine)
Colour		grey	yellow clear	grey
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>50</b>
Viscosity at 25°C	mPas	4600 ± 400	5000 ± 500	1800 ± 200
Density at 20°C	g / cm <sup>3</sup>	1,12 ± 0,02	1,10 ± 0,02	1,12 ± 0,02
Pot life 200 g / 20°C	min.	11 - 16	-	-
Curing time at RT	hrs.	12 - 16	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	25 ± 3
Flexural elongation at flexural strength	EN ISO 178	%	8,0 ± 0,5
Flexural modulus	EN ISO 178	MPa	680 ± 70
Tensile strength / test piece type 2	ISO 37	MPa	35 ± 2
Elongation at break / test piece type 2	ISO 37	%	240 ± 25
Shore hardness	DIN 53505	Shore D	68 ± 2
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	ca. 29
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 22

### Sales units (packages)

Packing size	B-Pack	GM 985-1 / Comp. A+B	9 x 0,400 kg Comp. A / 9 x 0,200 kg Comp. B = 5,400 kg
Units	Comp. A	GM 985-1 Comp. A (Iso)	4,000 kg / 28,000 kg
	Comp. B	GM 985-1 Comp. B (Amine)	2,000 kg / 14,000 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.

### Important processing instructions:

B comp. (amine) must be stirred in and carefully mixed into A comp. (isocyanate). The material must be free of streaks.

## In General

This product is a polyurethane system.

GM 985-1 Comp. B (Amine) can be subject to colour variations due to raw materials, but these colour variations have no influence on the quality and the properties of the product.

The postcured material is not UV stable and darkens by and by. However according to our experience the change in colour does not affect its utilizability.

Physical final properties will be achieved after 7 days' curing at room temperature or after postcuring for 8 hrs. at 80°C.

As bonding agent on aluminium support we recommend our PU coupling paste KP 8.

## 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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