

Basis	Thin liquid casting resin
Resin	GH 723
Hardener	D
Colour	green

### Applications

- Bonding resin for fillers

### Properties

- low viscosity
- very well castable
- well workable

### Processing data

Product		Mixture GH 723 / D	Resin GH 723	Hardener D
Colour		green	green	colourless
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>7</b>
Viscosity at 25°C	mPas	1500 ± 250	6000 ± 1500	5 ± 2
Density at 20°C	g / cm <sup>3</sup>	1,75 ± 0,05	1,80 ± 0,05	0,87 ± 0,02
Pot life 200 g / 20°C	min.	55 - 65	-	-
Curing time at RT	hrs.	16 - 20	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	65 ± 5
Flexural elongation at break	EN ISO 178	%	1,8 ± 0,1
Flexural modulus	EN ISO 178	MPa	6250 ± 400
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	6,3 ± 0,5
Compressive strength	EN ISO 604	MPa	70 ± 7
Heat resistance (HDT)	DIN EN ISO 75 B	°C	46 ± 2
Glass transition temperature TG	method DSC	°C	-
Shore hardness	DIN ISO 7619-1	Shore D	87 ± 3
Coefficient of thermal expansion	internal test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	ca. 63
Dielectric strength E <sub>D</sub>	DIN 53481	KV/mm	-
Linear shrinkage	internal	%	-

### Sales units (packages)

Units	Resin	GH 723	6,000 kg / 20,000 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 ebaclean.

## In General

**ebalta** GH 723/D is a very well castable two-components epoxy resin, which, after curing at room temperature, can be worked on well with tools for metalworking.

This system is a most suitable back cast resin for moulds of which the back has to be worked on mechanically after curing. For back-casting round aluminium granules are used, for bulking: rough aluminium granules. Since the resin/hardener mixture is very liquid, a 50-100 weightcontent of fillers like aluminium granules or silica sand has to be added to get a back-cast mass of 100-200 mm thickness. Under normal circumstances a thickness of 40 mm can be reached with GH 723/D.

## Storing

Storage at room temperature (18-25 °C) in closed original container 9 months.

Close open containers after use, keep away from moisture and use up immediately

## 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.