

Basis	aluminium filled epoxy castin resin
Resin	GH 752
Hardener	LI 100-2
Colour	alu grey

Applications

- Vacuum forming tools
- PU-foaming tools
- RIM foam tools
- Heatable foundry patterns

Properties

- heat resistant
- very thick castable
- low shrinkage
- well workable
- low heat effect

Processing data

Product		Mixture GH 752 / LI 100-2	Resin GH 752	Hardener LI 100-2
Colour		alu grey	alu grey	yellowish transparent
Mixing ratio	p. b. w.		100	9
Viscosity at 25°C	mPas	6707 ± 100	18500 ± 3500	50 ± 10
Density at 20°C	g / cm ³	1,76 ± 0,05	1,90 ± 0,05	0,97 ± 0,02
Pot life 200 g / 20°C	min.	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	103 ± 5
Flexural elongation at break	EN ISO 178	%	1,8 ± 0,2
Flexural modulus	EN ISO 178	MPa	8890± 85
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	11,8 ± 1
Compressive strength	EN ISO 604	MPa	108 ± 2
Shore hardness	DIN ISO 7619-1	Shore D	89 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	96,6 ± 0,7

Sales units (packages)

Units	resin	GH 752	14,025 kg
	Hardener	LI 100-2	1,300 kg / 5,000 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 752/ LI 100-2 is a very thick-castable aluminium-filled heat resistant two-components epoxy resin which shows an almost aluminium-like character after curing at room temperature.

Due to the high content of aluminium the heat conductivity of GH 752/ LI 100-2 is quite good, the material is well workable and has a low linear heat expansion coefficient .

GH 752/ LI 100-2 can also be cast in a thickness of more than 150 mm. By adding massive aluminium round granules it's even possible to cast much bigger thicknesses.

After curing at room temperature the maximum thermal heat resistance for thin-walled parts is achieved by thermal treatment at 50-80°C for 12-15 hrs.

The thermal treatment can also be effected by careful heating up to working temperature.

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: see 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.