

Basis **very soft casting resin**
 Resin **GM 900-1 Comp. A**
 Hardener **GM 900-1 Comp. B**

Colour black
 Further colours beige

Applications

- Casting mould for gypsum
- Casting mould for ceramic materials
- Casting mould for plastic
- Casting mould for wax

Properties

- shore A hardness 13
- highly flexible
- good tear propagation resistance
- RoHS conform

Processing data

| Product | | Mixture GM 900-1 / Comp. A+B | Resin GM 900-1 Comp. A | Hardener GM 900-1 Comp. B |
|-----------------------|---------------------|---------------------------------|---------------------------|------------------------------|
| Colour | | black | black | transparent |
| Mixing ratio | p. b. w. | | 100 | 10 |
| Viscosity at 25°C | mPas | 1350 ± 200 | 1600 ± 500 | 20 ± 10 |
| Density at 20°C | g / cm ³ | 1,12 ± 0,03 | 1,15 ± 0,03 | 0,962 ± 0,03 |
| Pot life 200 g / 20°C | min. | 17 - 27 | - | - |
| Curing time at RT | hrs. | 7 - 10 | - | - |

Physical data

| Properties | Inspect. requirem. | Unit | Value |
|---|--------------------|---------|-----------|
| Tensile strength / test piece type 2 | ISO 37 | MPa | 1,1 ± 0,2 |
| Elongation at break / test piece type 2 | ISO 37 | % | 750 ± 75 |
| Shore hardness | DIN ISO 7619-1 | Shore A | 13 ± 2 |
| Tear resistance arch shaped test piece with incision 1 mm | DIN ISO 34-1 | kN/m | 2,2 ± 0,2 |

Sales units (packages)

| | | | |
|--------------|---------|----------------------|---|
| Packing size | B-Pack | GM 900-1 / Comp. A+B | resin 6 x 0,800 kg / hardener 6 x 0,080 kg = 5,280 kg |
| Units | Comp. A | GM 900-1 Comp. A | 15,000 kg |
| | Comp. B | GM 900-1 Comp. B | 1,500 kg |

Processing instructions

Material- and working- 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

Both components can be easily mixed free from air bubbles in small quantities by hand with a round stirring rod or in larger quantities with a spiral stirrer.

In General

The product is a very soft-elastic polyurea casting compound.

ebalta GM 900-1 is suitable as a flexible casting system in the field of mould- and tooling for parts which require low shore hardness and high tear propagation resistance due to deep under cuts.

Mould temperatures of about 60 °C lead and/or curing at 60°C, to faster curing and therefore short demoulding time. Demoulding can be reduced to 30-40 min.

To achieve final properties as fast as possible, postcuring can be made at 60°C for 6-8 hrs. and after curing at room temperature.

For complete curing of the mould, any non-postcured moulds should only be employed after 2-3 days.

Any non-observance may lead to shorter pot life.

The potlife of GM 951-1 can be shortened by mixing hardener GM 951-1 with hardener GM 900-1 (see mixing table).

For individual formulation of the shore hardness, GM 951-1 can be mixed with GM 900-1 (see mixing table).

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.