

|          |                                    |
|----------|------------------------------------|
| Basis    | <b>flexible casting resin</b>      |
| Resin    | <b>GM 956 Comp. A (Isocyanate)</b> |
| Hardener | <b>GM 956-80 Comp. B (Polyole)</b> |
| Colour   | transparent                        |

## Applications

- Prototypes with rubber-like properties
- Flexible parts
- jet mask

## Properties

- shore A hardness 83
- shore hardness variable till A 30
- excellent flow properties
- transparent
- easily dyeable
- odourless
- high tear strength
- free of mercury
- RoHS conform
- seawater steady - according to DIN 50905

## Processing data

| Product               |                     | Mixture<br>GM 956 / GM 956-80 | Resin<br>GM 956 Comp. A<br>(Isocyanate) | Hardener<br>GM 956-80 Comp. B<br>(Polyole) |
|-----------------------|---------------------|-------------------------------|---|--|
| Colour                |                     | transparent                   | transparent                             | amber-transparent                          |
| <b>Mixing ratio</b>   | <b>p. b. w.</b>     |                               | <b>100</b>                              | <b>80</b>                                  |
| Viscosity at 25°C     | mPas                | 2000 ± 200                    | 5000 ± 1000                             | 190 ± 10                                   |
| Density at 20°C       | g / cm <sup>3</sup> | 1,04 ± 0,02                   | 1,06 ± 0,02                             | 1,00 ± 0,02                                |
| Pot life 200 g / 20°C | min.                | 15 - 20                       | -                                       | -  |
| Curing time at 70° C  | h                   | 2                             | -                                       | -  |

## Physical data

| Properties   | Inspect. requirem. | Unit    | Value    |
|--|--------------------|---------|----------|
| Tensile strength / test piece type 2                                   | ISO 37             | MPa     | 8 ± 1    |
| Elongation at break / test piece type 2                                | ISO 37             | %       | 600 ± 75 |
| Shore hardness   | DIN ISO 7619-1     | Shore A | 83 ± 3   |
| Tear resistance arch shaped test piece with incision 1 mm              | DIN ISO 34-1       | kN/m    | 15 ± 1   |
| Abrasion Taber Abraser H 18<br>Application weight 500g / 500 Rotations | internal           | mg      | ca. 46   |

## Sales units (packages)

|       |         |                                |                     |
|-------|---------|--------------------------------|---------------------|
| Units | Comp. A | GM 956 Comp. A<br>(Isocyanate) | 1,000 kg / 5,000 kg |
|       | Comp. B | GM 956-80 Comp. B<br>(Polyole) | 0,800 kg / 4,000 kg |

## Processing instructions

Material- and processing temperature between 18°C and 25°C.  
Mixing ratio resin and hardener according instructions.

When using pigment paste, it needs to stir it in Comp.B.

To reach shore hardness A 65 mix GM 956 Comp. A, GM 956-30 Comp. B and GM 956-80 Comp. B as follows:

GM 956 Comp. A (100 weight contents) + GM 956-30 Comp. B (100 weight contents) + GM 956-80 Comp. B (40 weight contents)

First step is the mixture of the B-components, second step: stir B components in Comp. A.

Mould temperature for fabrication of vacuum casting parts: 70°C

Final properties reached after 7 days at room temperature or 4 hrs. post curing at 70°C

Any resin residues at mixing rods, can be removed with **ebalta** cleaning Agent.

To accelerate use our Accelerator 08.

## In General

This product is a polyurethane system.

After use please close the containers carefully.

The product 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.

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.

## 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.