

Basis	flexible casting resin
Resin	GM 971-85 Comp. A (Polyole)
Hardener	GM 971-85 Comp. B (Isocyanate)
Colour	white

Applications

- Flexible parts
- Vacuum casting parts
- Casting mould for gypsum
- Casting mould for plastic
- Casting mould for wax
- Casting mould for PU-foam
- fixtures

Properties

- Shore A hardness 86
- well castable
- high strength
- cold flexible
- easily dyeable
- free of mercury

Processing data

Product		Mixture GM 971-85 / Comp. A+B	Resin GM 971-85 Comp. A (Polyole)	Hardener GM 971-85 Comp. B (Isocyanate)
Colour		white	white	yellow clear
Mixing ratio	p. b. w.		100	52
Viscosity at 25°C	mPas	-	900 ± 200	150 ± 30
Density at 20°C	g / cm ³	1,11 ± 0,02	1,06 ± 0,02	1,22 ± 0,02
Pot life 200 g / 20°C	min.	4 - 5	-	-
Curing time at RT	hrs.	2 - 2,5	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Tensile strength / test piece type 2	ISO 37	MPa	14 ± 2
Elongation at break / test piece type 2	ISO 37	%	600 ± 100
Shore hardness	DIN ISO 7619-1	Shore A	86 ± 3
Tear resistance arch shaped test piece with incision 1 mm	DIN ISO 34-1	kN/m	25 ± 3
Tear resistance arch shaped test piece without incision	DIN ISO 34-1	kN/m	80 ± 5

Sales units (packages)

Packing size B-Pack GM 971-85 / Comp. A+B resin 9 x 0,500 kg + hardener 9 x 0,260 kg = 6,840 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** ebaclean.

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

The processing in a vacuum is also possible.

For fast demoulding:

Material temperature: 25 – 30 °C

Moulding temperature: 70 °C

Demoulding time: approx. 45 minutes at a mould temperature 70°C and 2 mm thickness

In General

This product is a polyurethane system.

Mechanical data according to test pieces post-cured for 8 hrs. at 80°C.

No heavy chemical and mechanical stress before 7 days after curing at room temperature (20-23°C).

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.