

Basis	PU casting resin
Resin	GM 984-1 Comp. A (isocyanate)
Hardener	GM 984-1 Comp. B (amine)
Colour	reddish transparent

Applications

- Foundry patterns
- Pattern plates
- fixtures
- Core boxes

Properties

- abrasion resistant
- hard flexible
- well castable
- long potlife
- Shore D hardness approx. 65

Processing data

Product		Mixture GM 984-1 / Comp. A+B	Resin GM 984-1 Comp. A (isocyanate)	Hardener GM 984-1 Comp. B (amine)
Colour		reddish transparent	yellow clear	orange-transparent
Mixing ratio	p. b. w.		100	130
Viscosity at 25°C	mPas	3500 ± 500	2500 ± 500	4400 ± 700
Density at 20°C	g / cm ³	1,15 ± 0,02	1,14 ± 0,02	1,08 ± 0,02
Pot life 200 g / 20°C	min.	30 - 45	-	-
Curing time at RT	hrs.	12 - 16	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	28 ± 1
Flexural elongation at flexural strength	EN ISO 178	%	7 ± 0,5
Flexural modulus	EN ISO 178	MPa	610 ± 40
Tensile strength	EN ISO 527-1	MPa	33 ± 2
Elongation of tensile strength	EN ISO 527-1	%	140 ± 8
Shore hardness	DIN ISO 7619-1	Shore D	65 ± 2
Wear jet test	internal tests	W(V/t) [mm ³ /min]	approx. 41
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 17

Sales units (packages)

Packing size	B-Pack	GM 984-1 / Comp. A+B	8 x 0,300 kg Comp. A/8 x 0,390 kg Comp. B = 5,520 kg
Units	Comp. A	GM 984-1 Comp. A (isocyanate)	3,850 kg
	Comp. B	GM 984-1 Comp. B (amine)	5,000 kg

Processing instructions

Material- and processing 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.

Important processing instructions:

B comp. (amine) must be stirred in and carefully mixed into A comp. (isocyanate). The material must be free of streaks.

In General

This product is a polyurethane system.

GM 984-1 Comp. B (Amine) 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.

The postcured material is not UV stable and darkens by and by. However according to our experience the change in colour does not affect its utilizability.

Physical final properties will be achieved after 7 days' curing at room temperature or after postcuring for 8 hrs. at 80°C.

As bonding agent on aluminium support we recommend our PU coupling paste KP 8.

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.