

Basis	<b>PU Casting resin</b>
Resin	<b>GM 987-2 Comp. A (Iso)</b>
Hardener	<b>GM 987-2 Comp. B (Amine)</b>
Colour	orange-opaque

### Applications

- Foundry patterns
- Pattern plates
- Fixtures
- Core boxes

### Properties

- excellent abrasion resistance
- hard flexible
- well castable
- Shore D hardness approx. 65

### Processing data

Product		Mixture GM 987-2 / Comp. A+B	Resin GM 987-2 Comp. A (Iso)	Hardener GM 987-2 Comp. B (Amine)
Colour		orange-opaque	transparent	orange-opaque
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>40</b>
Viscosity at 25°C	mPas	5100 ± 200	4000 ± 500	650 ± 100
Density at 20°C	g / cm <sup>3</sup>	1,12 ± 0,02	1,10 ± 0,02	1,19 ± 0,02
Pot life 200 g / 20°C	min.	ca. 13	-	-
Curing time at RT	hrs.	ca. 16	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	30 ± 5
Flexural elongation at flexural strength	EN ISO 178	%	8,0 ± 0,5
Flexural modulus	EN ISO 178	MPa	630 ± 50
Tensile strength	EN ISO 527-1	MPa	27 ± 5
Elongation at tensile strength	EN ISO 527-1	%	75 ± 15
Shore hardness	DIN ISO 7619-1	Shore D	65 ± 2
Coefficient of thermal expansion	internal test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	approx. 125
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	34 ± 2
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 11

### Sales units (packages)

Units	Comp. A	GM 987-2 Comp. A (Iso)	4,000 kg
	Comp. B	GM 987-2 Comp. B (Amine)	2,000 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** cleaning agent.

Important processing instructions:

We recommend repotting to avoid mixing errors.

We recommend our star mixer as a stirring tool for bubble-free mixing. B comp. (amine) must be stirred in and carefully mixed into A comp. (isocyanate).

The material must be free of streaks. Before use you have to stir up / shake the comp. B

## In General

This product is a polyurethane urea system.

GM 987-2 comp. B orange might tend to raw material based colour variations, which however do not affect the quality or properties of the material.

At a temperature of 60°C Shore hardness is about 60 Shore D, at 80°C about 50 - 52 Shore D.

The cured material is not UV stable and darkens after some time but according to our experiences does not affect the availability for use.

Physical final properties are achieved after 7 days at room temperature or after postcuring for 8 hrs. at 80°C .

Due to some material based brittleness we recommend demoulding of complicated geometries after 48 hrs. As a bonding agent on aluminium carriers use 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.