

Basis	flexible casting resin
Resin	GM 965-55 Comp. A
Hardener	GM 965-55 Comp. B
Colour	red

Applications

- Casting moulds for concrete
- Casting mould for gypsum
- Casting mould for cement

Properties

- shore A hardness about 55
- excellent flow properties
- good tear propagation resistance
- low absorption
- good chemical resistance
- good degasing
- RoHS conform

Processing data

Product		Mixture GM 965-55 / Comp. A+B	Resin GM 965-55 Comp. A	Hardener GM 965-55 Comp. B
Colour		red	red	brown transparent
Mixing ratio	p. b. w.		100	11
Viscosity at 25°C	mPas	2200 ± 300	3000 ± 500	40 ± 5
Density at 20°C	g / cm ³	1,27 ± 0,03	1,26 ± 0,03	1,22 ± 0,03
Pot life 200 g / 20°C	min.	15 - 20	-	-
Curing time at RT	hrs.	10 - 24	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Tensile strength / test piece type 2	ISO 37	MPa	3,8 ± 0,5
Elongation at break / test piece type 2	ISO 37	%	400 ± 40
Shore hardness	DIN ISO 7619-1	Shore A	55 ± 3
Tear resistance arch shaped test piece with incision 1 mm	DIN ISO 34-1	kN/m	5,5 ± 0,5
Tear resistance arch shaped test piece without incision	DIN ISO 34-1	kN/m	18 ± 2

Sales units (packages)

Units	Comp. A	GM 965-55 Comp. A	5,000 kg / 25,000 kg
	Comp. B	GM 965-55 Comp. B	0,550 kg / 2,750 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.

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 star-shaped stirrer.

The processing in a vacuum is also possible.

Stirring rods etc. with residual resin can be easily cleaned with **ebalta** cleaning agent

For face-casting application of the resin the riser diameter has to be up to casting thickness.

By adding our thixotropic agent 72 the product can be applied with brush.

Our product HV 55 serves both as adhesive and coupling agent.

Demoulding time can be shortened by curing at 40°C.

Do not increase temperature before partly gelling of the casting resin.

For concrete casting we recommend our "**concrete release agent B2**".

Avoid any application of mineral spirit-containing concrete release agents.

In General

This product is a polyurethane system.

No load on GM 965-55 before 24 hrs. curing at room temperature (23°C)

If the product is cured at room temperature, no entire chemical and mechanical load before 7 days after curing.

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.

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.