Technical Datasheet

GM 986-1 / Comp. A+B

Basis	**PU casting resin**
Resin	**GM 986-1 Comp. A /Isocyanate**
Hardener	**GM 986-1 Comp.B/Amin**
Colour	yellow-opaque

Applications

- Foundry patterns
- Pattern plates
- fixtures

Properties

- very abrasion resistant
- hard flexible
- no brittleness phase
- well castable
- dimensionally stable at high temperatures
- Shore D hardness approx. 70

Processing data

Product		**Mixture GM 986-1 / Comp. A+B**	**Resin GM 986-1 Comp. A /Isocyanate**	**Hardener GM 986-1 Comp.B/Amin**
Colour		yellow-opaque	yellow-opaque	brown transparent
Mixing ratio	**p. b. w.**		**100**	**26**
Viscosity at 25°C	mPas	5800 ± 500	6200 ± 500	650 ± 150
Density at 20°C	g / cm^3	1,10 ± 0,02	1,08 ± 0,02	1,20 ± 0,02
Pot life 200 g / 20°C	min.	16 - 20	-	-
Curing time at RT	hrs.	14 - 18	-	-

Physical data

Properties	**Inspect. requirem.**	**Unit**	**Value**
Flexural strength	EN ISO 178	MPa	35 ± 5
Flexural enlongation at flexural strength	EN ISO 178	%	8,0 ± 0,5
Flexural modulus	EN ISO 178	MPa	850 ± 100
Tensile strength	EN ISO 527	MPa	35 ± 5
Elongation of tensile strength	EN ISO 527	%	150 ± 20
Shore hardness	DIN ISO 7619-1	Shore D	70 ± 2
Wear jet test	internal tests	W(V/t) [mm^3/min]	approx. 35

Sales units (packages)

Packing size	B-Pack	GM 986-1 / Comp. A+B	resin 10 x 0,600 kg / hardener 10 x 0,156 kg = 7,560 kg
Units	Comp. A	GM 986-1 Comp. A /Isocyanate	4,000 kg / 20,000 kg
	Comp. B	GM 986-1 Comp.B/Amin	1,040 kg / 5,200 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:
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 stirr up / shake the comp. A.

In General

GM 986-1 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.

This material is most suitable for high pressure moulding plants with high moulding pressure and temperature resistance. For application at 60°C Shore hardness D is between 60-62!

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.

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

The material is also dimensionally stable at high temperatures. At a mould temperature of approx. 60°C a Shore hardness D of 62-64 will still be reached.
Due to remanent brittleness, for complicated geometries we recommend demoulding after 48 hrs.

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 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.

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