

Basis	<b>hard casting resin</b>
Resin	<b>GH 706</b>
Hardener	<b>GL</b>
Colour	blue

### Applications

- Foundry patterns
- Core boxes
- Copying models

### Properties

- abrasion resistant
- fine structure
- good compressive strength
- very hard
- wear resistant
- well castable
- castable up to 30 mm

### Processing data

Product		Mixture GH 706 / GL	Resin GH 706	Hardener GL
Colour		blue	blue	yellow
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>10</b>
Viscosity at 25°C	mPas	10000 ± 2000	19000 ± 3500	750 ± 150
Density at 20°C	g / cm <sup>3</sup>	2,05 ± 0,05	2,23 ± 0,07	1,00 ± 0,02
Pot life 200 g / 20°C	min.	30 - 40	-	-
Curing time at RT	hrs.	12 - 16	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	83 ± 2,6
Flexural elongation at break	EN ISO 178	%	1,3 ± 0,07
Flexural modulus	EN ISO 178	MPa	8424 ± 380
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	7 ± 1
Compressive strength	EN ISO 604	MPa	104 ± 4
Heat resistance (HDT)	DIN EN ISO 75 B	°C	67 ± 2
Shore hardness	DIN ISO 7619-1	Shore D	90 ± 3
coefficient of linear expansion 20 - 50 °C	internatl test / Dilatometer	10 <sup>-6</sup> K <sup>-1</sup>	ca. 60
Linear shrinkage	internal	%	-
Wear jet test	internal tests	W(V/t) [mm <sup>3</sup> /min]	ca. 357

### Sales units (packages)

Packing size	A-Pack	GH 706 / GL	resin 6 x 1,250 kg / hardener 6 x 0,125 kg = 8,250 kg
Units	Resin	GH 706	8,000 kg
	Hardener	GL	1,5000 kg / 5,000 kg

## Processing instructions

The temperature of material and processing should be between 18 and 25° C.

Filled systems should be stirred thoroughly before use.

After each use the containers have to be closed again.

Porous mould surfaces should be sealed before ( **ebalta** sealant ).

For an optimum mould release we recommend a suitable release agent (e.g. T 1-1) which can be easily applied with a brush.

The mould should be treated 2 or 3 times with release agent and allowed to evaporate for approx. 20 min after every application.

Mixing ratio resin/hardener according to instructions!

To get a clean component part, we recommend upward flow casting and to take care of sufficient venting.

Resin residues at stirring rods and so on can be easily cleaned with our ebaclean.

## In General

**ebalta** GH 706/GL is a well castable two-components epoxy resin, which cures at room temperature and can be casted 40 - 50 mm thickness.

The resin GH 706 contains very fine hard fillers and with hardener GL it has got a very hard, wear resistant surface with high compression strength and very fine structure.

Physical data as per test specimen cured for 8 hrs. at 80°C

**ebalta** GH 706 is the castable version of the very hard gelcoat OH 6-1.

## 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.