

Basis	Casting resins for climbing holds
Resin	GM 1914 Comp. A
Hardener	GM 1914 Comp. B
Colour	whitish

## Applications

- climbing holds

## Properties

- suitable for production of climbing holds according EN 12572-3:2017
- abrasion resistant
- free of plasticizer
- good impact strength
- easily dyeable
- very well castable
- unfilled
- contains > 40 % raw materials from renewable sources

## Processing data

Product		Mixture GM 1914 durability	Resin GM 1914 Comp. A	Hardener GM 1914 Comp. B
Colour		whitish	whitish	yellow transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>80</b>
Viscosity at 25°C	mPas	1400 ± 100	2500 ± 150	20 ± 5
Density at 20°C	g / cm <sup>3</sup>	1,14 ± 0,02	1,07 ± 0,02	1,22 ± 0,02
gel time 200 g / 20°C	min	L Hand casting 8 - 10 S Machine casting 2 - 3	-	-
Curing time at RT	min.	L Hand casting approx. 60 S Machine casting 10 - 15	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	90 ±5
Flexural elongation at break	EN ISO 178	%	no break
Flexural modulus	EN ISO 178	MPa	2200 ± 100
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	50 ± 10
Shore hardness	DIN ISO 7619-1	Shore D	approx. 80
Heat resistance (HDT)	DIN EN ISO 75 B	°C	80 ± 5

## Sales units (packages)

Units	GM 1914 Comp. A	5,000 kg / 25,000 kg / 200,000 kg
	GM 1914 Comp. B	4,000 kg / 20,000 kg / 200,000 kg

## Processing instructions

The material and processing temperature should be between 18 and 25°C. Low temperatures can lead to brittleness and increased abrasion.

The chemical reaction is slower in cold places, therefore the reaction shrinkage is shifted to these places. The silicone mold should be preheated to approx. >30°C in order to avoid shrinkage marks, especially on handles with strongly differing thicknesses on the surface and hidden contours. For Dual Texture handles / washers, the temperature should be >50°C to achieve a high-quality surface.

## In General

The casting compound GM 1914 durability is a whitish unfilled polyurethane casting resin.

Depending on the type, the material is adjusted for both manual and machine casting of climbing holds and is suitable for producing climbing holds according to the requirements of the standard EN 12572-3:2017.

Attention: Geometries to be proved by manufacturer.

Easy casting also for fine and rough contours.

Good abrasion resistance for long life cycle of climbing holds as well as good impact resistance.

Comp. A can be dyed by adding pigments. We recommend **ebalta** colour pastes for covering colour coat.

The material does not contain any of the following substances:

asbestos, lead, formaldehyde, mineral tar oil, carbonileum, polychlorinated biphenyles (PCBs)

The casting resin is free of plasticizers and contains >40% raw material from renewable sources.

Mechanical data based on test specimen postcured for 8 hrs. at 80°C.

Do not expose parts to full chemical and mechanical stress before 7 days after curing at room temperature at 20-23°C. We recommend post curing for 8 hrs. at 80°C.

## Storing

Recommended storing temperature is 18-25°C. Isocyanate is stabilized to avoid crystallisation

## 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.