

Basis	flexible casting resin
Resin	GM 956 Comp. A (Isocyanate)
Hardener	GM 956-70 Comp.B (Pol.)
Colour	transparent

Applications

- Sealing profiles in core boxes
- Flexible parts

Properties

- shore A hardness 75
- excellent flow properties
- odourless
- high tear strength
- free of mercury

Processing data

Product		Mixture GM 956 / GM 956-70	Resin GM 956 Comp. A (Isocyanate)	Hardener GM 956-70 Comp.B (Pol.)
Colour		transparent	transparent	yellow transparent
Mixing ratio	p. b. w.		100	110
Viscosity at 25°C	mPas	2000 ± 200	5000 ± 1000	425 ± 50
Density at 20°C	g / cm ³	1,04 ± 0,02	1,06 ± 0,02	1,00 ± 0,02
Pot life 200 g / 20°C	min.	15 - 20	-	-
Curing time at 70° C	h	2	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Tensile strength / test piece type 2	ISO 37	MPa	5,1 ± 0,5
Elongation at break / test piece type 2	ISO 37	%	700 ± 100
Shore hardness	DIN ISO 7619-1	Shore A	70 ± 3
Tear resistance arch shaped test piece without incision	DIN ISO 34-1	kN/m	12 ± 1

Sales units (packages)

Units	Comp. A	GM 956 Comp. A (Isocyanate)	1,000 kg / 5,000 kg
	Comp. B	GM 956-70 Comp.B (Pol.)	1,100 kg

Processing instructions

Material- and processing temperature between 18°C and 25°C.
Mixing ratio resin and hardener according instructions.

Mould temperature for fabrication of vacuum casting parts: 70°C
Final properties reached after 7 days at room temperature or 4 hrs. post curing at 70°C
Any resin residues at mixing rods, can be removed with **ebalta** cleaning Agent.

To accelerate use our Accelerator 08.

In General

This product is a polyurethane system.

After use please close the containers carefully.

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.

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.

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.