

Basis	PU Casting resin
Resin	GM 986-2 Comp. A (Iso)
Hardener	GM 986-2 Comp. B (Amine)
Colour	yellow-opaque

Applications

- Foundry patterns
- Pattern plates
- Fixtures
- Core boxes

Properties

- abrasion resistant
- hard flexible
- well castable
- dimensionally stable at high temperatures
- Shore D hardness approx. 68

Processing data

Product		Mixture GM 986-2 / Comp. A+B	Resin GM 986-2 Comp. A (Iso)	Hardener GM 986-2 Comp. B (Amine)
Colour		yellow-opaque	transparent	yellow-opaque
Mixing ratio	p. b. w.		100	35
Viscosity at 25°C	mPas	5300 ± 300	4000 ± 500	1400 ± 200
Density at 20°C	g / cm ³	1,16 ± 0,02	1,10 ± 0,02	1,18 ± 0,02
Pot life 200 g / 20°C	min.	13 - 18	-	-
Curing time at RT	hrs.	ca. 16	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	35 ± 5
Flexural elongation at flexural strength	EN ISO 178	%	8,0 ± 0,5
Flexural modulus	EN ISO 178	MPa	750 ± 50
Tensile strength	EN ISO 527-1	MPa	35 ± 5
Elongation at tensile strength	EN ISO 527-1	%	90 ± 20
Shore hardness	DIN ISO 7619-1	Shore D	68 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	84 ± 3
Coefficient of thermal expansion	internal test / Dilatometer	10 ⁻⁶ K ⁻¹	approx. 150
Wear jet test	internal tests	W(V/t) [mm ³ /min]	approx. 30
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 11

Sales units (packages)

Units	Comp. A	GM 986-2 Comp. A (Iso)	5,000 kg
	Comp. B	GM 986-2 Comp. B (Amine)	1,750 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.

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

Important processing instructions:

We recommend repotting to avoid mixing errors. We recommend our star mixer as a stirring tool for bubble-free mixing.

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 stir up / shake the comp. B.

In General

The product is a polyurea system.

GM 986-2 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 61 - 64, at 80°C about 57 Shore D.

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.

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: 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.