

Basis	Universal casting resin
Resin	GH 730
Hardener	BR
Colour	black
Further hardeners	GL / D

Applications

- Foundry patterns
- Core boxes
- Jigs

Properties

- impact resistant
- versatile

Processing data

Product		Mixture GH 730 / BR	Resin GH 730	Hardener BR
Colour		black	black	yellow transparent
Mixing ratio	p. b. w.		100	10
Viscosity at 25°C	mPas	8000 ± 1500	18000 ± 3000	875 ± 225
Density at 20°C	g / cm ³	2,20 ± 0,05	2,50 ± 0,10	0,96 ± 0,02
Pot life 200 g / 20°C	min.	35 - 45	-	-
Curing time at RT	hrs.	12 - 14	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	80 ± 5
Flexural modulus	EN ISO 178	MPa	7800 ± 400
Flexural strength at breakage	EN ISO 178	%	1,25 ± 0,2
Compressive strength	EN ISO 604	MPa	105 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	6 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	64 ± 2
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	ca. 42
Linear shrinkage	internal	%	ca. 0,1 - 0,2
Abrasion Taber Abraser CS 17 Application weight 500g / 500 Rotations	internal	mg	ca. 19

Sales units (packages)

Packing size	A-Pack	GH 730 / BR	Resin 6 x 1,500 kg / Hardener 6 x 0,150 kg = 9,900 kg
Units	Resin	GH 730	8,000 kg / 25,000 kg
	Hardener	BR	1,500 kg / 2,500 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 cleaning agent.

In General

ebalta GH 730/BR is a quite versatile two-components epoxy resin with good castability, curing at room temperature.

Due to its easy workability as well as its high strength and low shrinkage there's a big variety of applications as mouldmaking, toolmaking and in foundries. Moreover the high impact resistance and cast thickness of more than 30 mm make even more applications possible.

Storing

Storage at room temperature (18-25 °C) in closed original container 9 months.

Already opened containers should be closed immediately after use and should be used as soon as possible.

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.

ebalta Kunststoff GmbH . Erlbacher Straße 100 . 91541 Rothenburg ob der Tauber / Germany
Tel.: +49 9861 7007-0 . Fax: +49 9861 7007-77 . info@ebalta.de . www.ebalta.de