

Basis	Universal, low viscosity casting resin
Resin	GH 761
Hardener	D
Colour	black

Applications

- Foundry patterns
- Pattern plates
- Negatives
- Control castings
- Coping models
- Mould probes for trimming of prototypes

Properties

- low viscosity
- well castable
- versatile

Processing data

Product		Mixture GH 761 / D	Resin GH 761	Hardener D
Colour		black	black	colourless
Mixing ratio	p. b. w.		100	5
Viscosity at 25°C	mPas	2500 ± 500	30000 ± 5000	5 ± 2
Density at 20°C	g / cm ³	2,45 ± 0,05	2,55 ± 0,1	0,87 ± 0,02
Pot life 200 g / 20°C	min.	50 - 60	-	-
Curing time at RT	hrs.	14 - 16	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	85 ± 5
Flexural modulus	EN ISO 178	MPa	8850 ± 650
Flexural strength at breakage	EN ISO 178	%	1,2 ± 0,2
Compressive strength	EN ISO 604	MPa	110 ± 10
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
Heat resistance (HDT)	DIN EN ISO 75 B	°C	59 ± 2
Shore hardness	DIN 53505	Shore D	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-

Sales units (packages)

Packing size	B-Pack	GH 761 / D	resin 6 x 1,500 kg / hardener 6 x 0,075 kg = 9,450 kg
Units	Resin	GH 761	8,000 kg / 25,000 kg
	Hardener	D	4,000 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 761/D is a very well castable two-components epoxy casting resin, which even cures at 40 mm thickness at room temperature. The excellent castability allows versatile applications as a massive casting resin. During processing just note that the extremely low-viscosity hardener is mixed carefully with the filled resin. The resin/hardener mixture has a long potlife and is well castable free from air bubbles.

Storing

Storage at room temperature 18-25 °C.

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

Information about the expiration date you find on the sales packages.

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.

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