

Basis	<b>Dimensionally very accurate, slow curing casting resin</b>
Resin	<b>GM 725-7 Comp. A</b>
Hardener	<b>PUR 13 Comp. B</b>
Colour	beige
Further colours	green
<b>Further hardeners</b>	<b>PUR 4</b>

### Applications

- Foundry patterns
- Negatives
- Pattern plates
- Control castings
- Jigs
- Sheet metal forming

### Properties

- thick castable
- dimensionally accurate
- excellent flow properties
- well workable
- long potlife
- high strength

### Processing data

Product		Mixture GM 725-7 / PUR 13	Resin GM 725-7 Comp. A	Hardener PUR 13 Comp. B
Colour		beige	beige	brown transparent
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>15</b>
Viscosity at 25°C	mPas	6000 ± 500	pasty	15 ± 5
Density at 20°C	g / cm <sup>3</sup>	1,75 ± 0,05	1,85 ± 0,05	1,22 ± 0,02
Pot life 200 g / 20°C	min.	40 - 50	-	-
Curing time at RT	hrs.	12 - 16	-	-

### Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	56 ± 5
Flexural modulus	EN ISO 178	MPa	8025 ± 800
Flexural strength at breakage	EN ISO 178	%	0,9 ± 0,1
Tensile strength	EN ISO 527	MPa	-
Elongation	EN ISO 527	%	-
Compressive strength	EN ISO 604	MPa	76 ± 8
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	3,6 ± 0,5
Heat resistance (HDT)	DIN EN ISO 75 B	°C	51 ± 2
TG in TMA T <sub>G</sub>	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore D	87 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	ca. 52
Linear shrinkage	internal	%	ca. 0,1

### Sales units (packages)

Units	Resin	GM 725-7 Comp. A	5,000 kg / 15,000 kg / 30,000 kg
	Hardener	PUR 13 Comp. B	0,750 kg / 2,250 kg / 4,500 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.

## In General

**ebalta** GM 725-7 is a well castable 2-components, polyurethane casting compound, which cures slowly at room temperature. It's especially suitable for solid casting of very dimensional accurate big volume moulds. The thin liquid hardener PUR 13 leads to slow mixing viscosity.

Therefore a supplementary addition of 50 % filler F-B /3 or 75 % filler F-iron is possible.

Shrinkage is reduced to 0,05 %. Alternatively plastic granules can be added (more than 50 %).

In this case we recommend primer application of gelcoat OH 11 new or OH 16.

## Storing

At appropriate storage (18 - 25 °C) in closed original container 6 months.

Already opened containers should be closed immediately after use and be protected against moisture. This material should be used up 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.

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