

Basis	Flexible casting resin for mould constructions
Resin	GM 959 Comp. A
Hardener	GM 959-1 Comp. B
Colour	amber
Further hardeners	GM 959 Komp. B

Applications

- Casting moulds for concrete industry
- Casting mould for cement
- Casting mould for ceramic materials
- Casting mould for wax
- Casting mould for gypsum
- Casting mould for plastic
- Prototypes with rubber-like properties

Properties

- shore A hardness 80
- shore hardness (flexibility) variable
- excellent flow properties
- good degasing
- easily dyeable
- high tear strength

Processing data

Product		Mixture GM 959 / GM 959-1	Resin GM 959 Comp. A	Hardener GM 959-1 Comp. B
Colour		amber	yellow transparent	amber
Mixing ratio	p. b. w.		100	50
Viscosity at 25°C	mPas	1350 ± 200	6750 ± 1000	40 ± 10
Density at 20°C	g / cm ³	1,04 ± 0,02	1,06 ± 0,02	1,01 ± 0,02
Pot life 200 g / 20°C	min.	22 - 28	-	-
Curing time at RT	hrs.	20 - 24	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural modulus	EN ISO 178	MPa	-
Tensile strength / test piece type 2	ISO 37	MPa	8,4 ± 0,8
Tensile modulus	EN ISO 527	MPa	-
Elongation at break / test piece type 2	ISO 37	%	900 ± 100
Compressive strength	EN ISO 604	MPa	-
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
Heat resistance (Martens)	DIN 53458	°C	-
TG in TMA T _g	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore A	80 ± 2
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	-
Tear resistance arch shaped test piece with incision 1 mm	DIN ISO 34-1	kN/m	16,7 ± 0,5
Tear resistance arch shaped test piece without incision 1 mm	DIN ISO 34-1	kN/m	-

Sales units (packages)

Units	GM 959 Comp. A	1 kg / 5 kg
	GM 959-1 Comp. B	0,5 kg / 2,5 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.

Both components can be easily mixed free from air bubbles in small quantities by hand with a round stirring rod or in larger quantities with a spiral stirrer.

The processing in a vacuum is also possible.

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

In General

This product is a polyurethane system.

By mixing of hardeners shore hardness between A 40 and A 80 can be reached (see mixing table).

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.

Storing

Storage at room temperature (18 – 25°C) in closed original container 6 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.

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