

Basis	Clear, flexible casting resin
Resin	GM 960 Comp. A
Hardener	GM 960 Comp. B
Colour	transparent

Applications

- Crystal clear mould
- Reproduction of models
- Decorative casting
- Special effects
- Prototypes

Properties

- UV-stable
- max. temperature of applicaton about 80 °C
- colour effects by additon of pigments

Processing data

Product		Mixture GM 960 / Comp. A+B	Resin GM 960 Comp. A	Hardener GM 960 Comp. B
Colour		transparent	transparent	transparent
Mixing ratio	p. b. w.		50	100
Viscosity at 25°C	mPas	250 ± 50	-	-
Density at 20°C	g / cm ³	1,04 ± 0,02	-	-
Pot life 200 g / 20°C	min.	20 - 30	-	-
Curing time at RT	hrs.	16 - 18	-	-
Post curing	Time in h/ Temperature in °C	-	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	-
Flexural modulus	EN ISO 178	MPa	-
Flexural strength at breakage	EN ISO 178	%	-
Tensile strength	EN ISO 527	MPa	1,7 ± 0,02
Breaking elongation (tensile)	EN ISO 527	%	> 100
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
TG in TMA T _G	Methode TMA	°C	n. a.
Shore hardness	DIN 53505	Shore A	50 ± 3
Linear shrinkage	internal	%	-
Tear resistance / angle test piece	EN ISO 34-1	kN/m	4,5 ± 0,05

Sales units (packages)

Units	Resin	GM 960 Comp. A	0,454 kg
	Hardener	GM 960 Comp. B	0,908 kg

Processing instructions

In order to get bubble-free parts, we recommend working under vacuum.
Straight before casting, we recommend a one-time air impact from 10 of 60-70 mbar.

Cure the mould over night at room temperature (22 °C) (at least 16 h, better fo 24-48 h),
before demoulding.

Avoid curing at temperatures below 18 °C.

The material shows the best properties after 5-7 days at room temperature.

If the casting part is demoulded before 12 hrs, the surface might be sticky.

If so, heat it for about 4 – 6 hrs at 65 °C.

In General

GM 960 is a flexible polyurethane casting compound, which was especially developped
for applications requiring absolute clarity and UV-stability (no yellowing, light darkening
possible). By adding adequate pigments brillant colours and colour effects can be achieved
To avoid curing interferences (condensation-curing silicones) have to be free of evaporation.

Processing preferrably in vacuum casting plants.

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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