

Basis **Flexible casting resin**
 Resin **GM 973 Comp. A**
 Hardener **GM 973 Comp. B**

Colour beige
 Further colours black

Applications

- Flexible parts
- Jigs

Properties

- shore A hardness 90
- high tear strength
- well castable
- flexible
- dyeable

Processing data

Product		Mixture GM 973 / Comp. A+B	Resin GM 973 Comp. A	Hardener GM 973 Comp. B
Colour		beige	beige	brown transparent
Mixing ratio	p. b. w.		100	15
Viscosity at 25°C	mPas	4500 ± 500	4500 ± 500	690 ± 150
Density at 20°C	g / cm ³	1,08 ± 0,02	1,07 ± 0,02	1,2 ± 0,02
Pot life 200 g / 20°C	min.	12 - 15	-	-
Curing time at RT	hrs.	12 - 16	-	-

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	16 ± 2
Elongation	EN ISO 527	%	550 ± 50
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	n. a.
Shore hardness	DIN 53505	Shore A	90 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	-
Tear resistance / angle test piece	EN ISO 34-1	kN/m	55 ± 5

Sales units (packages)

Packing size B-Pack GM 973 / Comp. A+B Resin 6 x 0,750 kg /Hardener 6 x 0,113 kg = 5,178 kg

Processing instructions

Material- and working- 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

The product is a Polyurethane system.

For improving of the flow characteristics, GM 973 can be preheated to approx. 30°C.

The final strength is achieved at room temperature after approx. 3-5 days.

By post-curing at 80°C for 5 hours the stated values are achieved in short time.

Parts / moulds must not be cast with addition curing silicone, since this might lead to faulty reactions when curing the silicone.

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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