

Basis	Flexible, abrasion resistant PU casting resin
Resin	GM 974 Comp. A
Hardener	GM 974 Comp. B
Colour	reddish transparent
Further colours	brown

Applications

- Core boxes
- Jigs

Properties

- very abrasion resistant
- hard flexible
- castable until 20 mm

Processing data

Product		Mixture GM 974 / Comp. A+B	Resin GM 974 Comp. A	Hardener GM 974 Comp. B
Colour		reddish transparent	yellow clear	light red
Mixing ratio	p. b. w.		100	65
Viscosity at 25°C	mPas	2800 ± 500	7500 ± 800	90 ± 15
Density at 20°C	g / cm ³	1,09 ± 0,02	1,10 ± 0,02	1,08 ± 0,02
Pot life 200 g / 20°C	min.	20 - 25	-	-
Curing time at RT	hrs.	10 - 12	-	-

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	23 ± 4
Tensile modulus	EN ISO 527	MPa	220 ± 20
Elongation	EN ISO 527	%	300 ± 30
Compressive strength	EN ISO 604	MPa	n. a.
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	-
Heat resistance (HDT)	DIN EN ISO 75 B	°C	n. a.
TG in TMA T _G	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore D	60 ± 3
Coefficient of linear expansion	DIN 53752	10 ⁻⁶ K ⁻¹	-
Linear shrinkage	internal	%	ca. 0,26
Tear resistance / angle test piece	EN ISO 34-1	kN/m	-
Abrasion Taber Abraser H 18 Application weight 500g / 500 Rotations	internal	mg	ca. 27

Sales units (packages)

Packing size	B-Pack	GM 974 / Comp. A+B	Resin 9 x 0,400 kg / Hardener 9 x 0,260 kg = 5,940 kg
Units	Resin	GM 974 Comp. A	4 kg / 25 kg
	Hardener	GM 974 Comp. B	2,600 kg / 16,25 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

The product is a Polyurethane system.

GM 974 can be cast in surface coating process on a metallic support or on a epoxy resin core.

Solid casting can be executed in a thickness of 30-40 mm.

GM 974 is available in 2 colours:

GM 974 red-transparent: comp. A – yellow-clear

comp. B – light red

GM 974 brown: comp. A – yellow-clear

comp. B – orangebrown

Also plywood can be completely filled in as a torpedo. The material thickness of GM 974 is approx. 10-20 mm. The demoulding can be executed after 6-8 hours depending on the casting thickness. Before the castings can be used the material should cure for some days or postcure for approx. 8 hours at 50-60°C.

Possibly colour variations in Comp. B, due to raw materials, don't affect the quality or 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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