

Basis	<b>Casting resin resistant to abrasion and compression</b>
Resin	<b>GM 976 new Comp. A</b>
Hardener	<b>PUR 1 Comp. B</b>
Colour	green
Further colours	beige

## Applications

- Core boxes
- Foundry pattern

## Properties

- abrasion resistant
- good compressive strength
- well castable

## Processing data

Product		Mixture GM 976 new / PUR 1	Resin GM 976 new Comp. A	Hardener PUR 1 Comp. B
Colour		green	green	brown
<b>Mixing ratio</b>	<b>p. b. w.</b>		<b>100</b>	<b>30</b>
Viscosity at 25°C	mPas	4000 ± 500	10000 ± 2500	100 ± 30
Density at 20°C	g / cm <sup>3</sup>	1,60 ± 0,05	1,68 ± 0,05	1,24 ± 0,02
Pot life 200 g / 20°C	min.	30 ± 5	-	-
Curing time at RT	hrs.	4 - 10	-	-

## Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	75 ± 5
Flexural modulus	EN ISO 178	MPa	5275 ± 250
Flexural strength at breakage	EN ISO 178	%	2,0 ± 0,2
Tensile strength	EN ISO 527	MPa	-
Elongation	EN ISO 527	%	-
Compressive strength	EN ISO 604	MPa	85 ± 5
Impact resistance (Charpy)	EN ISO 179	kJ/m <sup>2</sup>	10 ± 2
Heat resistance (HDT)	DIN EN ISO 75 B	°C	69 ± 2
TG in TMA T <sub>g</sub>	Methode TMA	°C	-
Shore hardness	DIN 53505	Shore D	88 ± 3
Coefficient of linear expansion	DIN 53752	10 <sup>-6</sup> K <sup>-1</sup>	-
Linear shrinkage	internal	%	-

## Sales units (packages)

Packing size	B-Pack	GM 976 new / PUR 1	resin 6 x 0,800 kg / hardener 0,240 kg = 6,240 kg
Units	resin	GM 976 new Comp. A	20,000 kg
	Hardener	PUR 1 Comp. B	1,500 kg / 3,000 kg / 6,000 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 976 new is an easy-to-handle-2components-polyurethane casting compound which shows very low adhesive properties compared to moulding sand. Due to its very high abrasion resistance, GM 976 new is especially suitable for foundry patterns, which have to resist to abrasive wear by moulded sand. GM 976 new even keeps its high mechanical strength when using moulding sands with higher temperatures.

## 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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